



AST-LOCK™ 77HS

HIGH STRENGTH, FASTENER AND STUD LOCKING PERMANENT THREAD LOCKER

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Product Description

AST-LOCK™ 77HS is a High Strength, Heavy Duty Threadlocker designed as a permanent Threadlocker that will provide high strength threadlocking for permanent installations. It is used when you do not want the fastener to be removed with common handtools. It provides a very strong bond strength and is designed for fasteners **1" and larger** which are subject to extreme shock and vibration. It has good gap filling capabilities. To remove the fastener if desired, you will have to heat the part up to about 300°F (149°C).

This Threadlocker undergoes a chemical crosslinking only in the presence of metal and the absence of air. This is typically referred to as "curing". The Threadlocker begins to cure right after assembly and reaches full cure in about 24 hours depending upon temperatures. In Colder Climates it may require more time and in Warmer Climates, less time.

AST-LOCK™ 77HS Threadlocker works particularly well with softer more active metals such as Brass, Bronze, aluminum or steel. For Stainless Steel, Titanium, Alloys, plated fittings, fittings with a wide gap fill or if the material is being applied in very cold temperatures where a full cure is still needed then a primer may be required to ensure a full cure is achieved **AST-LOCK™ 77HS** works best for on a wide variety of applications and on a wide variety of thread geometries, both course threads and fine threads on sizes 1" or larger. It is not recommended for certain plastic components as the methacrylate base may cause stress cracking.

AST-LOCK™ 77HS conforms to MIL-S-46163A and ASTM D-5363

Cleaning

A Threadlocker works best if the parts are clean and free of grease, oil, foreign material or old Threadlocking agents. Normally cleaning with an appropriate solvent and / or wiring brushing the parts to ensure they are clean.

Application

For best results we recommend applying a thin coating of the Threadlocker to the length of thread that needs to be engaged in the fastener. For some applications you may be able to coat the circumference of one or two thread and allow the excess to be pushed up the thread as its being engaged.

Typical Properties

Property	Value
Color	Red
Fixture Speed , no primer	30 minutes @ 76°F
Fixture Speed with primer	< 10 seconds
Full Cure Time	24 hr @ 70°F
Typical Breakaway Strength	250 To 350 in. lbs
Typical Prevailing Strength	250To 350in lbs.
Viscosity	7000 cps
Max. Operating Temp.	-65F to 300° F
Primer	Primer N or T
MIL-S-46163-A	Type I, Grade L
ASTM D 5363	AN0211
RoHS 3	Compliant
Gap Fill	0.010"

Storage and Shelf Life

For best results and a longer shelf life, Threadlocker should be stored at moderate Temperatures under 80° F. The shelf life is around 24 months if it is stored under these conditions. Storage at higher temperatures may shorten it shelf life or result is lower Prevailing Torque values.

Cautions

This product is not recommended for use in an oxygen system and not as a sealant for chlorine or other strong oxidizing materials. Read all information on labels and Safety Data Sheets prior to use. All products should be tested and evaluated for a particular purpose prior to use.

GHS compliant

[This product requires GHS pictograms on labels.](#)
[Refer to Label and SDS for GHS information.](#)

Product Limited Warranty

This information is based on information we believe to be reliable and accurate, but no guarantee of its accuracy is made for a particular application. We urge and recommend that Users pretest their application prior to incorporating the product into use and assume that the User will conduct such testing. Also see warranty statement on website.

Available In:

SIZE: 10ml, 50ml 250 ml
P/N: 39771 39772 39773