



AST-LOCK™ 71HS

HIGH STRENGTH, PERMANENT THREAD LOCKER

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Product Description

AST-LOCK™ 71HS is a High Strength Threadlocker designed as a permanent Threadlocker . 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 subject to extreme shock and vibration.

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™ 71HS 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 up to about 1”. It is not recommended for certain plastic components as the methacrylate base may cause stress cracking.

AST-LOCK™ 71HS conforms to MIL-S-46163A and ASTM D-5363

Directions for use:

Shake before using.

Both the internal and external threads should be clean prior to assembly. Foreign materials such as cutting oils or rust can diminish the cure strength. Previously applied, cured Threadlocker material should be cleaned off using a wire brush.

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.



AST-LOCK™ 71HS Threadlocker works particularly well with softer more active metals such as Steel, 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.

Heat will be required to disassemble the parts. Heat the part up to 350F (177C) or higher using the appropriate means to ensure safety.

Typical Properties

Property	Value
Color	Red
Fixture Speed , no primer	30 minutes @ 76F
Fixture Speed with primer	< 5 seconds
Full Cure Time	24 hr @ 70F
Typical Breakaway Strength	200 To 300 in. lbs
Typical Prevailing Strength	250 To 350 in lbs.
Viscosity	500 cps
Max. Operating Temp.	-65F to +300 F
Primer	Primer N or T
MIL-S-46163A	Type I, Grade K
ASTM D5363	AN0221
RoHS	Compliant
Gap Fill	0.007”

Storage and Shelf Life

For best results and a longer shelf life, Threadlocker should be stored at moderate Temperatures under 80F. The shelf life is around 18 month 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: 39711 39712 39713

ANTI-SEIZE TECHNOLOGY

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