



TECTORIUS® TEC-BOND® 251

Pre-Applied Fastener Adhesive & Thread Locker

DESCRIPTION:

Tec-Bond® 251 is a high-temperature resistant, microencapsulated adhesive. It can be applied to male or female threaded fasteners of virtually all sizes, configurations, compositions and finishes.

Tec-Bond 251 contains microencapsulated reactive elements that are suspended in a quick-curing resin, carried in a solvent medium.

The shearing forces caused by installation of the fastener to the mating part release reactive compounds that cure into a tough, well-bonded polymer. The resulting matrix rapidly bonds the surfaces, semi-permanently locking parts together and sealing leak paths.

Tec-Bond 251 offers consistent and predictable torque values, and requires no heat or primers for curing.

Specific formulations of Tec-Bond™ 251 meet or exceed the performance requirements of the following standards:

AUTOMOTIVE:

- Chrysler PF-6616 & MS-CC-76
- Ford ES-20007-S100, ES-20010-S100
ESS-M11P24-A1 & ESS-M11P24-A2
- General Motors GM6175M & GM6194M

INDUSTRIAL FASTENER INSTITUTE:

- IFI 125
- IFI 525

OEM:

- Detroit Diesel 80K15
- Meritor/Rockwell International Q-29
- Caterpillar 1E2486

PRODUCT FEATURES:

- » **Unaffected By Automotive Fluids:** Tec-Bond 251 resists and seals against most automotive fluids: oil, water, antifreeze, and gasoline have virtually no effect once final cure has been achieved. Tec-Bond 251 is designed to function in high-temperature environments for extended periods of time, such as in engine compartments.
- » **Variety of Strengths, Colors, & Viscosities:** this product is available in a variety of colors (for easy part inspection) and formulas to best suit the customers' coating equipment. A wide range of similar Tec-Bond products are formulated to satisfy most thread locking requirements.
- » **Fast Fixture Times:** Under typical conditions, fixture is achieved within 90 minutes.
- » **Saves Money:** Tec-Bond 251 saves valuable time and is less expensive than applying bottled thread locking compounds at the point of assembly.
- » **Suitable for Production Coating:** Tec-Bond 251 is available in viscosities suitable for use on a broad range of production coating equipment.

*For a more environmentally friendly option, we offer a water-based version called Tec-Bond 261.

*The information provided is based on technical data that Tectorius believes to be reliable. Since we cannot anticipate or control the various conditions under which this information and our product may be used, we cannot guarantee the applicability of this information or the suitability of our product in any individual situation. Therefore, the product is sold without warranty expressed or implied.

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SPECIFICATIONS:

	Grade 251	251 SC	251 DPC
Standard Color	Orange	Orange	Orange
Specialty Colors	Neutral, Yellow, Red, Green	Neutral, Yellow, Red, Green	Neutral, Yellow, Red, Green
Variant Purpose	Standard Formula	Highly concentrated for transport efficiency	Solvent removed for transport efficiency
Carrier Medium	Toluene Modified	Solvent Concentrate	None / Dry Concentrate
Installation Torque (in/lbs.)	<10	<10	<10
Break/Prevail Torque After Full Cure (in/lbs.)	225/250	225/250	225/250
	(Nm) 25/28	25/28	25/28
Temperature Range (°F)	-65/350	-65/350	-65/350
	(°C) -54/175	-54/175	-54/175
Fixture Time	>90 min.	>90 min.	>90 min.
On-Part Life*	4 years	4 years	4 years
Full Cure Time @ Room Temperature	>72 hrs.	>72 hrs.	>72 hrs.
Bulk Shelf Life	1 year	1 year	3 years

Torques based on 3/8" - 16 dry phosphated bolts and nuts.

* Varies due to storage conditions.

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