



TECTORIUS® TEC-BOND® P-SERIES

Pre-Applied Fastener Adhesive & Thread Locker

DESCRIPTION:

The Tec-Bond® P-Series of thread locking products are room-temperature curing, microencapsulated adhesives. They can be applied to male or female threaded fasteners of virtually all sizes, configurations, compositions and finishes.

Tec-Bond P-Series contains a microencapsulated, reactive element that is suspended in a quick-curing, solvent borne resin. The shearing forces caused by installation of the fastener to the mating part release the activator to allow curing of the resin matrix. The resulting chemical reaction rapidly bonds the surfaces, locking parts together and sealing leak paths.

Tec-Bond products offer consistent and predictable torque values, and require no heat or primers for curing.

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

AUTOMOTIVE:

- Chrysler PF-6616, MS-CC-76, MCSD7
- Ford WX200, ES-20007-S100, ES-20010-S100, WSS-M11P45-A1, WSS-M18P12-A, WSK-M2G354-A3, ESS-M11P24-A1 & ESS-M11P24-A2
- General Motors GM6175M, GM6193M, GM6194M, & GM6124M

INDUSTRIAL FASTENER INSTITUTE:

- IFI 125
- IFI 525
- DIN 267 Part 27

OEM:

- Detroit Diesel 80K15
- Meritor/Rockwell International Q-29
- Meritor Q-52
- Caterpillar 1E2486

PRODUCT FEATURES:

- » **Unaffected By Automotive Fluids:** these materials resist and seal against most automotive fluids including oil, water, antifreeze, and gasoline.
- » **Variety of Strengths, Colors, & Viscosities:** this product is available in a variety of colors (custom colors available) for easy part inspection. Different strengths and properties are available to fit the desired application.
- » **Fast Fixture Times:** Under typical conditions, fixture is achieved within 15 minutes.
- » **High Temperature & Torque-Sensitive Formulas:** The P-Series includes grades that are specifically intended for use in high temperature settings or tension-sensitive applications.
- » **Saves Money:** Tec-Bond products save valuable time and are less expensive than applying bottled thread locking compounds at the point of assembly.
- » **Suitable for Production Coating:** Each grade of the P-Series is available in viscosities suitable for use on a broad range of production coating equipment.
- » **Tec-Bond P-80 G and P-85 G** is a condensed liquid version that can be shipped **non-hazardous**. Made functional with customer added solvent.

*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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AVAILABLE GRADES:

Grade	Color	Primary Usage	Break/Prevail Torque After Full Cure		Temperature Range		Lubricity	Viscosity cPs
			(in/lbs.)	(Nm)	(°F)	(°C)		
P-30	Yellow	Moderate Strength	80/120	9/14	-58/300	-50/150	Medium	800-4000
P-30 HV	Yellow	Moderate Strength	80/120	9/14	-58/300	-50/150	Medium	20000-40000
P-60	Purple	Hi Strength, Hi-Temp	265/300	30/34	-58/392	-50/200	High	800-4000
P-61 (HV)	Purple	Hi Strength, Hi-Temp	265/300	30/34	-58/392	-50/200	High	20000-40000
P-80	Pink	Hi Strength, Hi-Temp	265/300	30/34	-58/392	-50/200	High	800-4000
P-80 G	Pink	Hi Strength, Hi-Temp	265/300	30/34	-58/392	-50/200	High	20000-40000
P-80 HV	Pink	Hi Strength, Hi-Temp	265/300	30/34	-58/392	-50/200	High	20000-40000
P-85	Turquoise	Hi Strength, Torque Control	265/300	30/34	-58/392	-50/200	High	800-4000
P-85 G	Turquoise	Hi Strength, Torque Control	265/300	30/34	-58/392	-50/200	High	20000-40000
P-85 HV	Turquoise	Hi Strength, Torque Control	265/300	30/34	-58/392	-50/200	High	20000-40000

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

SPECIFICATIONS:

Installation Torque (in/lbs.)	<10
Fixture Time	<15 min.
On-Part Life*	4 years
Full Cure Time @ Room Temperature	<72 hours

* Varies due to storage conditions.

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