



Kem Vibra-TITE 122
Oil Tolerant Medium Strength Threadlocker



Product Description

Kem Vibra-Tite 122 Oil Tolerant Threadlocker is a medium viscosity, thixotropic, anaerobic thread locking adhesive for all types of metal, threaded fasteners. Cured performance shows controlled medium strength with good temperature and solvent resistance against water and nonpolar solvents. This product cures rapidly on plated, oily metal surfaces or inactive surfaces.

Typical Applications

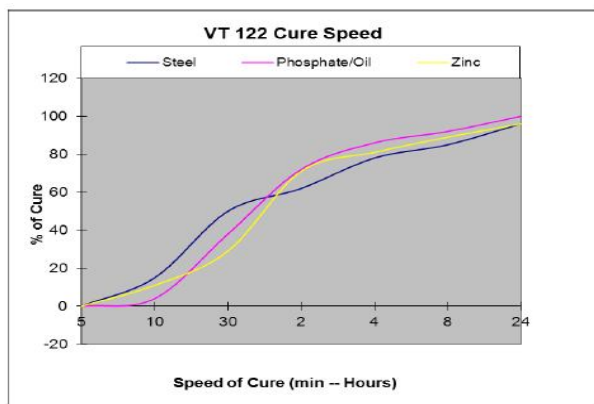
Kem Vibra-Tite 122 replaces lock washers and plastic inserts. Locks machine tool access bolts, studs, and hydraulic system bolts. Used on gear box bolts/drive shaft, bearing cover cap screws, counter sunk screws, conveyor roller bolts and construction equipment.

Technical Features

#	Parameter	Specifications
1	Resin Type	Modified Acrylate
2	Color	Blue
3	Fixture Speed with Primer	< 1 sec
4	Fixture Speed w/o Primer	5 – 10 min @ 25°C
5	Viscosity @ 25°C cps	2250 - 12000
6	Gas Fill	0.0015"
7	Shelf Life, Months @ 20°C	12
8	Operating Temperature, Max °C	-51 - 150

Typical Curing Performance

The cure speed is depended on temperature and substrate. The graph below shows the Breakaway Strength on M-10 Steel, Phosphate/oil, and Zinc finishes.



Curing Schedule and Performance

Fixture Time	10 – 20 min @ 15°C
Full Cure Time	24 Hrs. @ 15°C

Breakthrough Strength

3/8" Plain Steel nut & Bolt @ 1 Hr	50 – 150 lbf-in
3/8" Plain Steel nut & Bolt @ 24hrs	100 – 170 lbf-in
3/8" Zinc Nut & Bolt @ 24hrs	120 – 170 lbf-in
3/8" Phos Oil Nut & Bolt @ 24hrs	120 – 170 lbf-in

Environmental Fluid Resistance

(Shear Shtrength Values)

Heat Age	100%
Engine Oil @ 150°C	100%
Brake Fluid @ 150°C	100%
ATF @ 150°C	85%
50:50 water/Eth Glycol@ 120°C	85%
Water @ 100°C	80%
Gasoline @ 25°C	95%
Diesel Fuel @ 25°C	100%
Ethanol @ 25°C	95%

Compatible Primers

Primers such as Kem Vibra-TITE Excel 611 (Primer N) or Excel 612 (Primer T) can be used. The use of primers can result in lower strength and performance should be tested after full cure.

Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

Procedure for Application

Product is normally hand applied from the bottle onto threaded parts.

Packing

Bottles - 10 ml, 50 ml, 250 ml

General Information

Storage

Product should be stored in a cool and dry location at temperatures between -10 °C to 30 °C. Optimal storage is 22±4°C. Shelf life is 18 months from date of manufacture when stored at 22±4°C.

Note

Kem Vibra-TITE 122 is easy to apply and color coded red to assist in selection. Because of its chemical resistance it is ideal for applications such as sealing for refrigeration environments, air conditioning applications and plant and processing equipment using corrosive chemicals. Product conforms to MIL-S-46163A , ASTM D-5363, NSF.

Health & Safety

IRRITANT: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water.

NOTE TO USER

The information contained in this document while based on evidence and reliable methods can not be considered exhaustive. This information are current to the date of issuance of this data sheet.

The user, under its own responsibility, shall respect all the existing provisions on hygiene and safety and shall verify every time the features and the specific and appropriate way to use the product, cause the respect of the provisions is not under producer's direct control. The manufacturer does not guarantee nor assume any liability or responsibility for whatsoever harm that might result from a misuse of the product or for damages that have arisen after the product's distribution.

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