



TECHNICAL DATA BULLETIN

INSTAbond® 146

Liquid Anaerobic Sealant

PRODUCT DESCRIPTION:

INSTAbond® 146 is a high-strength, low-viscosity threadlocking compound designed for metal fasteners up to 1" in diameter. Other features include fast-cure and good chemical resistance. INSTAbond® 146 complies with MIL-S-46163 Type I Grade K / ASTM D 5363-03 AN0221.

Physical Properties (Uncured)

Parameters	Test Method	Specification
Color	-----	Red
Viscosity, 25 deg C	ASTM D445	500 cPs
Specific Gravity, 25 deg C	ASTM D792	1.1 gms/ml
Flash Point	ASTM D56	>93 deg C
UV Light Properties	-----	Illumination @ 230 nm

CURED PROPERTIES

Properties	Specifications
Fixture Time:	
Unprimed steel @ 25 °C	5-10 minutes
*Primed steel @ 25 °C	3-5 minutes
Full Cure:	
Unprimed steel @ 25 °C	18 hours
*Primed steel @ 25 °C	12 hours
Breakaway Torque, 24 hours @ 25°C	24.8 N-m
Prevailing Torque, 24 hours @ 25°C	33.9 N-m
Hot Strength, 2 hours @ 93 deg C	20.3 N-m (breakaway torque)
Solvent Resistance: (Breakaway Torques)	
Distilled Water	24.0 N-m
n-Butanol	20.3 N-m
Toluene	16.9 N-m
Motor Oil (10W-30)	21.5 N-m
JP-4 Jet Fuel	17.2 N-m
Ethylene Glycol	20.0 N-m
Temperature Range	-65 – 300 deg F



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GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with a sealant for chlorine-containing constituents or other strong oxidizing materials. This product is not suitable for use on plastic parts. Refer to Material Safety Data Sheet for instructions on safe handling of this material.

STORAGE

This product should be stored less than 100 deg F and out of direct sunlight. Product should be stored in the original, closed container. NEVER combine liquid primers/activators with anaerobic sealing compounds as violent chemical reactions will result. Shelf life is 18 months when stored in accordance with manufacturer's recommendations.

DIRECTIONS FOR USE

Substrates should be cleaned and degreased with a solvent such as acetone, MEK, or trichloroethylene. Do use mineral spirits or Stoddard solvent. Allow substrates to dry completely before applying sealing compound. Apply sealing compound to both surfaces and assemble. For faster cure speed and maximum bonding, apply INSTAbond® Primer N, INSTAbond® Primer T or INSTAbond® Primer F prior to application of sealing compound. Allow primer to dry thoroughly before applying sealing compound. Once fixturing has occurred, no adjustments should be made as this will decrease the sealing compound's total locking strength once the fixture bond is broken.

NOTE

The information contained in this document is furnished for information only and it's believed to be reliable based on previous evaluations. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for user's application based on user's production methods. This data should only be used as a guide for determining feasibility for a particular application.

PRODUCT INFORMATION CONTAINED HEREIN IS INTENDED FOR REFERENCE ONLY. MATERIAL SAFETY DATA INFORMATION AVAILABLE AT (662) 895-4480 OR IN WRITNG TO: ACCRAbond, Inc. 8848 Hacks Cross Road, Olive Branch, MS 38654, www.accrabond.com.