



TECHNICAL DATA BULLETIN

INSTAbond® Primer F

Anaerobic Primer

PRODUCT DESCRIPTION:

INSTAbond® Primer F is used to decrease the fixture time of INSTAbond® anaerobic threadlocking compounds. INSTAbond® Primer will increase the breakaway torque on most fastener surfaces. Other benefits include good cold weather application and quick drying. INSTAbond® Primer F contains no ozone depleting solvents.

SPECIFICATION:

Meets Mil-S-46163A, Grade F, Form R

NATIONAL STOCK NUMBERS:

8030-01-152-2285 – 6oz aerosol

INSTRUCTIONS FOR USE:

Spray or brush on the activator on both mating surfaces to be bonded. For small gaps, treatment of only one surface may be adequate. Contaminated or highly oiled surfaces may require repeat applications. Other special degreasing methods may be used prior to application of primer. Allow solvent to completely evaporate before applying anaerobic threadlocking compound. When anaerobic threadlocking compound is applied and surfaces are joined, allow proper fixture before moving assembled parts.

PROPERTIES OF MATERIALS AS SUPPLIED

Property	Test Method	Unit	Value
Appearance	Visual	-----	Transparent green liquid
Brookfield Viscosity	ASTM D2393	cP	Very low
Specific Gravity	ASTM D792	g/cc (lb/gal)	0.85
Flash Point	-----	Deg F	-4°F
Solvent			Acetone
Shelf Life			18 Months

PERFORMANCE

Fixture time and cure speed achieved will depend on the type of anaerobic sealing compound used. The drying time at 25°C is 40 - 70 seconds depending on temperature and humidity.

STORAGE & HANDLING



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Olive Branch, MS 38654
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This product should be stored less than 100°F and out of direct sunlight. Always store this product in original closed containers. NEVER combine liquid primers/activators with anaerobic sealing compounds as violent chemical reactions will result. Keep containers tightly closed when not in use. At elevated temperatures, pressure build up will occur depending on the amount of product in the container. Always open containers with caution.

PACKAGING:

INSTAbond® Primer F is available in 1-oz, 2-oz, 4-oz glass bottles, 6oz aerosol, pints, quarts and gallons. Other package sizes and options are available upon request.

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 38654-1827, www.accrabond.com.