HERNON®
High Performance Adhesives and Sealants
ISO 9001 Registered

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Technical Data Sheet
Nuts N' Bolts® 434

Product Description

Hernon® Nuts N' Bolts® 434 is a thixotropic, 100% active anaerobic compound which solidifies with reliable and expected strength upon application to most fasteners. Particularly suitable for applications on less active substrates such as stainless steel and plated surfaces, where disassembly with hand tools is required for servicing.

Product Benefits

Nuts N' Bolts® 434 is easily applied. No mixing (single component), no curing outside the joint and no torque adjustments are necessary. **Nuts N' Bolts® 434** offers increased profitability, having approximately 80% cost advantage over the cheapest mechanical methods as well as reducing inventories, maintenance, and the need for costly precision tolerances. **Nuts N' Bolts® 434** can be used on up to ¾ inch bolts with light oil contamination.

Typical Applications

- Shaft coupling bolts
- Drive shaft fasteners
- Gear box bolts
- Bearing cover cap screws
- Railroad bolts

Typical Properties (Uncured)

Property	Value
Chemical Type	Dimethacrylate Ester
Appearance	Blue Fluorescent Liquid
Viscosity @ 77ºF (25ºC), cP	1500 to 3000
Specific gravity	1.05
Flash point	See SDS
VOC Content (ASTM D2369)	0.88 lb/gal

Typical Properties (Cured)

Property	Value
Temperature Range, ºC (ºF)	-55 to 150 (-65 to 300)
Set Time, Steel, minutes	<10
Gap Filling	0.005 in.

Typical Cured Performance

Cured and tested at 22ºC on 3/8 x 16 grade 5 bolts and type 2 nuts according to ASTM D5363.

Cure	Substrate	Torque	Value, in-lb
24 Hours	Steel	Breakaway	80 to 150
		Prevailing	35 to 88

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some case, these aqueous washes can affect the cue and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

Directions for Use
Shake well prior to use. For best performance surfaces should be clean and free of grease. **Nuts N' Bolts® 434** should be applied to the bolt in sufficient quantity to fill all engaged threads.

Disassembly and Cleanup
To aid in disassembly anaerobic compounds can be weakened by heating to at least 500ºF (260ºC). Once disassembled, cured adhesive can be removed with **Hernon® Gasket Remover 30**.

Storage
Nuts N' Bolts® 434 should be stored in a cool, dry location in unopened containers at a temperature between 45ºF to 85ºF (7ºC to 29ºC) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon**® **Sales** for additional information.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. HERNON MANUFACTURING, INC. shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Hernon's Quality Management System for the design and manufacture of high-performance adhesives and sealants is registered to the ISO9001 Quality Standard.