

## Nuts N' Bolts® 25203

### Product Description

**Hernon® Nuts N' Bolts® 25203** is a single component anaerobic penetrating adhesive and sealant. Utilizing capillary action, **Nuts N' Bolts® 25203** penetrates and seals porosities and cracks as large as 0.127 mm. Once confined away from air **Nuts N' Bolts® 25203** cures to a thermoset plastic. Sealant remaining on the surface will not cure and can be easily wiped clear. Benefits include retention of fluids and pressures as well as corrosion and contamination elimination. Temperature resistance is up to 400°F (204°C).

**Nuts N' Bolts® 25203** is impervious to most solvents. Welds, castings and powder metal parts can be sealed to their rupture pressure.

### Typical Properties (Uncured)

Property	Value
Chemical Type	Methacrylate Ester
Appearance	Amber fluorescent liquid
Specific Gravity	1.07
Viscosity @ 25°C, cP	9-25
Flash Point	See SDS

### Typical Properties (Cured)

Property	Value
Temperature Range, °F	-65 to 400

### Typical Cured Performance

Cured and tested at 22°C on 3/8 x 16 grade 5 bolts and type 2 nuts.

Cure	Substrate	Torque	N•m (in-lb)
30 minutes	Steel	Prevailing	8.2 to 28.2 (75 to 250)
24 Hours	Steel	Breakaway	2.3 to 16.9 (20 to 150)
		Prevailing	16.9 to 56.5 (150 to 500)
	Plated	Breakaway	1.1 to 11.3 (10 to 100)
		Prevailing	8.2 to 56.5 (75 to 500)

### 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).

### Directions for Use

- Nuts N' Bolts® 25203** is recommended for inactive surfaces, such as zinc or aluminum. It can also be used on iron or steel surfaces. However, its rapid cure speed may not allow for total penetration into porosity.
- For best performance all surfaces must be free of dirt and excessive oil. If cleaning is necessary, only non-greasing solvents should be used.
- Apply sealant directly to prepared surfaces.
- Metal temperature may range from 15°C to 60°C. Higher temperatures will open porosities, reduce the viscosity and speed up the cure.
- Brushing is the easiest and most economical means of application. 3cc's of sealant are required to seal 254 cm of weld when using a 12.7 mm brush.
- Nuts N' Bolts® 25203** cures between any metallic surface. Full cure occurs after 24 hours.
- Nuts N' Bolts® 25203** should be allowed to cure before further processing or testing. Application to non-metallic surfaces may require heat curing.

### Storage

**Nuts N' Bolts® 25203** should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°C) 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.