

## Technical Data Sheet Nuts N' Bolts<sup>®</sup> 220

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### Product Description

Hernon<sup>®</sup> Nuts N' Bolts<sup>®</sup> 220 is a single component, high strength, anaerobic compound used to lock and seal fine threaded nuts, bolts, and studs in a wide variety of applications.

### Product Benefits

- Single component (no mixing)
- Predictable and reliable performance
- Reduces inventory
- No shrinkage or cracking due to solvent evaporation

### Typical Applications

- Replaces the fastener locking device of all kinds
- Thread sealer
- Locking adjustment screw
- Seal porosity in welds, castings, and powdered metal parts.

### Performance Testing

Each batch of Nuts N' Bolts<sup>®</sup> 220 is tested to the lot requirements of MIL-S-22473E (Grade AA), and to the detail requirements of ASTM D5363 (AN0111).

### Typical Properties (Uncured)

Property	Value
Chemical Type	Dimethacrylate Ester
Appearance	Green Liquid
Viscosity @ 25°C, cP	10-15
Specific Gravity	1.06
Flash Point	See SDS
Fluorescence	Positive Under UV

### Typical Properties (Cured)

Property	Value
Temperature Range, °C (°F)	-55 to 150 (-65 to 300)
Gap Filling	Max. 0.004 in.

### Typical Performance Properties

Torque Strength, ASTM D5363  
3/8 x 24 Grade 2 Steel Nuts and Bolts

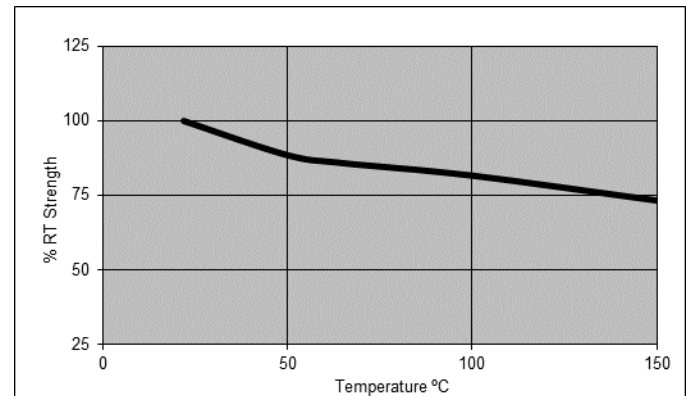
Cure Time at 22°C	Prevailing Torque N•m (in-lb)
6 Hours	≥ 8.5 (75)
24 Hours	8.5 to 42.4 (150-375)

### Typical Environmental Resistance

Cured 72 hours at standard conditions,  
Breakaway Torque, ISO 10964,  
3/8 x 24 Grade 2 Steel Nuts and Bolts

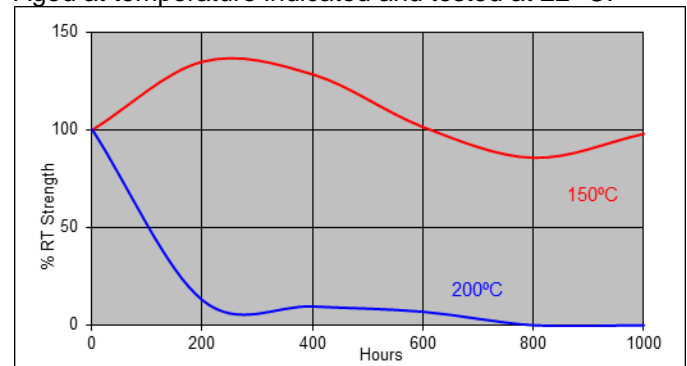
#### A. Hot Strength

Tested at temperature



#### B. Heat Aging

Aged at temperature indicated and tested at 22 °C.



#### C. Chemical/Solvent Resistance

Aged for 300 hours under the conditions indicated and tested at 22 °C,

Chemical/Solvent	Temp (°C)	% of Initial Strength
Hydraulic Fluid	93	105
Water	93	100
Ethylene Glycol	93	83

Ethanol	22	106
Acetone	22	121

### 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 cure 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). Users are recommended to confirm compatibility of the product with such substrates. Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

### Directions for use

#### For Assembly

1. For best results, clean all surfaces (external and internal) with **Hernon® Cleaning Solvent 62** and allow to dry.
2. If the material is an inactive metal or the cure speed is too slow, spray all threads with **Primer 49 or 50** and allow to dry.
3. Shake the product thoroughly before use.
4. To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during application.
5. **For Thru Holes**, apply several drops of the product onto the bolt at the nut engagement area.
6. **For Blind Holes**, apply several drops of the product down the internal threads to the bottom of the hole.
7. **For Sealing Applications**, apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free. Force the material into the threads to thoroughly fill the voids. For bigger threads and voids adjust product amount accordingly and apply a 360° bead of product on the female threads also.
8. Assemble and tighten as required.

#### For Disassembly

1. Remove with standard hand tools.
2. In rare instances where hand tools do not work because of excessive engagement length, apply

localized heat to nut or bolt to approximately 250°C. Disassemble while hot.

3. Once disassembled, cured adhesive can be removed with **Hernon® Gasket Remover 30** by following instructions. A solvent wipe with an organic or petroleum solvent will remove uncured adhesive outside the joint.

#### For Cleanup

1. Cured product can be removed with a combination of soaking in **Hernon® Cleaning Solvent 62** and mechanical abrasion such as a wire brush.

#### Storage

**Nuts N' Bolts® 220** 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 ISO 9001 Quality Standard.