

Technical Data Sheet

Nuts N' Bolts[®] 128

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Product Description

Hernon[®] Nuts N' Bolts[®] 128 is a single component, low strength thread locker designed for locking plastic and metal fasteners. Fixture time is about 5 minutes and adhesive can be pre or post applied.

Any excess adhesive on the surface will cure and will not migrate to the other parts. **Nuts N' Bolts[®] 128** can be used as a low strength thread locker, bonder or tamper proofer for metal, polyester, nylon and many other thermo plastics materials.

Typical Properties (Uncured)

Property	Value
Chemical Type	Cyanoacrylate ester
Appearance	Blue liquid
Viscosity @ 77°F (25°C), cP	75 - 85
Specific gravity	1.07
Flash point	See MSDS
Temperature range, °C, (°F)	-54 to +85 (-65 to 185)

Typical Cured Performance

Adhesive Properties

Torque Strength
Cured for 24 hours at 22°C

Fastener Size	Breakaway	Prevail
	N•m (in-lb)	N•m (in-lb)
3/8 x 24 Steel	≥2.8 (≥ 25)	≥ 2.8 (≥ 25)
3/8 x 24 Plated	≥2.8 (≥ 25)	≥ 2.8 (≥ 25)
Fixture time	6-8 mins	

Fixture time can be speeded up with use of Activator EF58

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 Material Safety Data Sheet (MSDS).

Directions for use

1. For best performance bond surfaces should be clean and free from grease.
2. This product performs best in thin bond gaps (0.05 mm).
3. For Sealing Applications, apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free. Apply the nut and tighten as required. For fixtures, apply several drops of sealant down the internal threads to the bottom of the hole.
4. To prevent the sealant from clogging in the nozzle, do not allow the tip to touch bonding surfaces during application.
5. Excess adhesive can be dissolved with **Hernon[®] CA Remover 14** or acetone.
6. Can be disassembled with standard hand tools.

Storage

Cyanoacrylate adhesives must be stored under refrigeration at a temperature of 45°F ± 5°F for extended shelf life. Before opening, the containers must be warmed to room temperature, otherwise, water may condense into the bottle and cause hardening of the adhesive. To prevent contamination of unused adhesive, do not return product to its original container.

Dispensing Equipment

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

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