

## Product Description

Vibra-Tite 121 is a medium strength, anaerobic thread locking compound. Vibra-Tite 121 is designed for locking threaded fasteners that require disassembly with standard hand tools. The product performs on aluminum, steel, plated parts, stainless steel, and special alloy parts. Vibra-Tite 121 exhibits good temperature and is solvent resistant.

## Typical Applications

Vibra-Tite 121 will lock and seal fasteners, and set screws. Vibra-Tite 121 is used in applications where shock and vibration may cause the fastener to loosen.

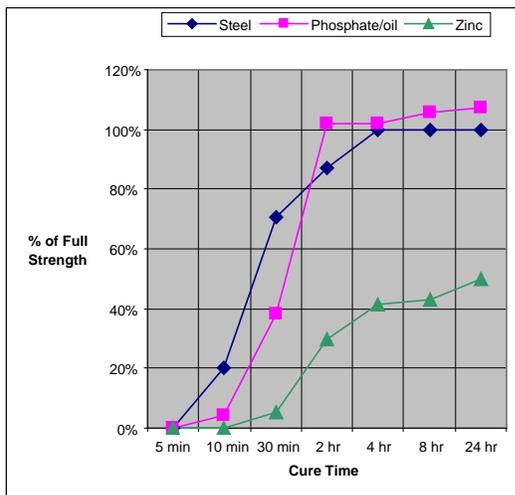
## Properties of Uncured Material

Chemical Type: Anaerobic  
 Appearance: Blue  
 Toxicity: Low  
 Solids: 100%  
 Viscosity @ 25°C, cPs  
     Brookfield RVT,  
     Spindle 3 @ 20 rpm: 900-1500  
 Specific Gravity: 1.07

## Typical Curing Performance

### Cure Speed

The cure speed is dependent on temperature and substrate. The graph below shows the Breakaway Strength on M-10 Steel, Phosphate/oil, and Zinc finishes.



## Performance of Cured Material

### Typical Values

Fixture Time: 15-20 min @ 72°F  
 Full Cure Time: 24 hrs @ 72°F  
 Temperature Range: -60°F to 300°F (-51°C to 150°C)

## Breakaway Strength

3/8" Plain Steel nut and bolt @ 1 hr      50-150 lb<sub>f</sub>-in  
 3/8" Plain Steel nut and bolt @ 24 hr      75-150 lb<sub>f</sub>-in  
 3/8" Zinc nut and bolt @ 24 hr              60-100 lb<sub>f</sub>-in

## Environmental and Fluid Resistance

(Shear strength values after 1,000 hours.)

### Typical Values

Heat age @ 150°C                              100%  
 Engine oil @ 150°C                            100%  
 Brake fluid @ 150°C                          100%  
 ATF @ 150°C                                    85%  
 50/50 water/ethylene glycol @ 120°C    80%  
 Water @ 100°C                                 80%  
 Gasoline @ 25°C                               95%  
 Diesel fuel @ 25°C                            100%  
 Ethyl Alcohol @ 25°C                         95%

## Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

## Compatible Primers

Primers such as Vibra-Tite Excel 611 (Primer N) or Excel 612 (Primer T) can be used to speed the fixture time of the adhesive. Fixture times can improve by as much as 50%. The use of primers can result in lower strength and performance should be tested after full cure.



## **General Information**

### **Storage**

Product should be stored in a cool and dry location at temperatures between 14°F (-10°C) to 86°F (30°C). Shelf life is 2 years from date of manufacture when stored at 72±8°F (22±4°C).

### **Note**

Vibra-Tite 121 is recommended for threaded components under 1" in diameter. Components can be disassembled using conventional hand tools. It is color coded blue and once cured, seals and vibration proofs the assembly giving controlled breakaway and prevailing torques.

Product conforms to MIL-S-46163A, ASTM D-5363, NSF.

### **Health & Safety in use**

IRRITANT: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water.