

TECHNICAL BULLETIN
TORQ-LOK
EPOXY THREAD LOCKING COMPOUND

TorqLok is an epoxy based metal adhesive. Conveniently packaged in the EPOXY PAX, TorqLok is preformulated to the exact mix ratio, eliminating any weighing or mixing. TorqLok is recommended for bonding all threaded and sleeve type applications where welding is undesirable. This system will withstand break-out torques twice as great as normally recommended make-up torques. TorqLok will withstand continuous vibrations and heavy shock loads. TorqLok is impervious to oil, petroleum solvents, gasoline, alcohols, acids, alkalis and salts. TorqLok also prevents galling of threads.

PHYSICAL PROPERTIES

Color	Part A-Gray, Part B-Red
Hardness (Shore D)	89
Viscosity (cps)	50,000
Shear Load (Ft.lbs.)	160
Work Life (75°F)	10 minutes
Coefficient of Friction	.096
Friction Factor	1.20 – 1.25
Cure Schedule (for optimum cure)	24 hours at 75°F 1 hour at 150°F
Lap Shear (psi)	2550
Specific Gravity (grams/cc)	1.53

Directions: To use the EPOXY PAX, pull both ends of packet to remove clip. Mix contents thoroughly until a uniform mixture is obtained. Snip end of packet to dispense contents to connection that has been thoroughly cleaned with non-petroleum based solvent, such as acetone or MEK.

Break-out: Break-out procedures should be performed in a well ventilated area. The use of a NIOSH approved cartridge mask is recommended. Heat connection evenly to 400°F and apply recommended break-out torque. Remove any residual TorqLok with a motorized wire brush.

The information contained herein is believed to be reliable. All recommendations are made without guarantee inasmuch as conditions and methods of commercial use are beyond our control. Properties given are typical values and are not intended for use in preparing specifications.

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