

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1256
SHEET : 1 of 4
RELEASE : August, 1972
REVISION : August, 1979

NAME: COMPOUND - THREAD LOCKING, SEALING AND RETAINING

1. APPLICATION:

This specification covers various types of sealant and thread locking anaerobic compounds, each type having characteristics rendering it suitable for specific locations.

2. SPECIFIC REQUIREMENTS:

Class & Type	Application	Selection Basis	Colour	Torque (1+2) (in lb.f)		Cure Time (2)		Viscosity (CP) ± 20%
				Breakaway Prevailing		Un-Primed (hrs)	Primed (mins)	
<u>Class 1</u> Type 1	Locks & seals studs. Provides maximum locking on nuts & screws where dis-assembly is not required. High strength produces maximum resistance to vibration and shock	Standard grade for threaded parts up to 1" dia.	Red	180	265	2-4	30-60	500
Type 1a		Increased breakloose & prevailing torque while providing controlled lubricity.	Red	80	150	24	120	1500
Type 2		For large clearance threads & parts over 1" dia.	Red	240	300	12-24	30-60	1500
<u>Class 2</u> Type 1	Locks & seals nuts. Prevents loosening from vibration; permits removal Medium strength	Standard grade for threaded parts up to 5/8" diameter.	Blue	100	75	2-4	15-30	125
Type 2		For large clearance threads & parts over 5/8" dia.	Blue	100	75	12-24	30-60	1500

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NUMBER : HN 1256
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NAME: COMPOUND - THREAD LOCKING, SEALING AND RETAINING

2. SPECIFIC REQUIREMENTS: (continued)

Class & Type	Application	Selection Basis	Colour	Torque (1+2) (in lb.f)		Cure Time (2)		Viscosity (CP) ± 20%
				Breakaway Prevailing		Un-Primed (hrs)	Primed (mins)	
<u>Class 3</u> Type 1	Locks & seals screws. Prevents vibration loosening; permits adjustments & removal. Moderate strength.	Standard grade for threaded parts up to 5/8" diameter.	Purple	65	35	2-4	15-30	125
Type 2		For large clearance threads & parts over 5/8" diameter.	Brown	40	20	12-24	30-60	2000

Class & Type	Application	Selection Basis	Colour	Shear Strength PSI (2+3)	Cure Time (2)		Viscosity (CP)±20 %
					Unprimed (Hrs)	Primed (mins)	
<u>Class 4</u> Type 1	Bonds rigid cylindrical parts such as gears, sleeves fans, bushings rotors, pulleys, etc.	Strongest grade for high load requirements. High viscosity	Green	4000	Not recommended for Auto motive Applications	30-60	
Type 2		High temperature grade for service to 400°F. Medium viscosity.	Green	3000		30-60	
Type 3		Standard grade for fastest cure	Green	3000		15-30	
Type 4		Weakest grade, where disassembly is required.	Blue	1500		30-60	125

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