

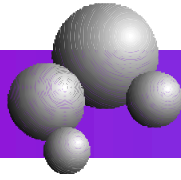
ND MICROSPHERES[®]

Fastener Adhesive

PreApplied

Acrylic Series

AA0695, AA0795, AA0895,
AA0995, AA1095, AA1195



Automotive Approved

ND
INDUSTRIES

DESCRIPTION:

- ❑ The ND Microspheres Acrylic Series of threadlocking products are microencapsulated, room temperature curing adhesives that can be applied to **male** or **female** threaded fasteners of virtually all sizes, configurations materials and finishes.
- ❑ ND Microspheres Acrylic Series contains a microencapsulated activator that is suspended in a quick curing waterborne resin. The shearing forces caused by engagement with a mating part release the activator and allow it to mix with the resin. The resulting chemical reaction rapidly bonds the surfaces, locking the parts together and sealing leak paths. The Acrylic Series offers consistent and predictable torque values and requires no heat or primers for curing.

FEATURES:

- ❑ **Unaffected By Automotive Fluids:** ND Microspheres Acrylic Series resists and seals against most automotive fluids. Oil, water, antifreeze, and gasoline have virtually no effect on the Acrylic Series once final cure has been achieved.
- ❑ **Variety of Strengths, Colors, & Viscosities:** ND Microspheres Acrylic Series is available in a variety of colors for easy part inspection and in different strengths to fit the desired application.
- ❑ **Fast Fixture Times:** Under typical conditions fixture is achieved within 5 minutes.
- ❑ **High Temperature & Torque Sensitive Formulas:** ND also manufactures formulations of ND Microspheres Acrylic Series that are specifically intended for use in high temperature or torque/tension sensitive applications.
- ❑ **Saves Money:** ND Microspheres Acrylic Series brand **PreApplied** thread adhesives are less expensive than applying bottled threadlocking compounds at the point of assembly.



Attention Production Fastener Coaters:

ND Microspheres Acrylic Series is available in liquid form for application by fastener coating companies.

- **Suitable for Production Coating:** Each member of the ND Microspheres Acrylic Series is available in viscosities suitable for use on a broad range of production coating equipment.
- **Minimal Cleanup Requirements:** Cleanup is a simple process that requires only soap and water.



Particular formulations of the ND Microspheres Acrylic Series meet or exceed the performance requirements of the following specifications:

AUTOMOTIVE

- ❑ Chrysler PF-6616 & MS-CC-76
- ❑ Ford ES-20007-S100, ES-20010-S100
ESS-M11P24-A1 & ESS-M11P24-A2
- ❑ General Motors GM6175M, GM6193M, & GM6194M

INDUSTRIAL FASTENER INSTITUTE

- ❑ IFI 125
- ❑ IFI 525

OEM

- ❑ Detroit Diesel 80K15
- ❑ Rockwell International Q-29
- ❑ Caterpillar 1E2486

For a complete list contact ND INDUSTRIES

PROPERTIES SUMMARY:

As Applied to Fastener

Product Formula	AA0695	AA0795	AA0895	AA0995	AA1095	AA1195
Color	Yellow	Yellow	Green	Silver	Pink	Light Blue
Primary Usage	General Purpose	High Temperature	Medium Strength	Low Strength	Plated Surfaces	High Strength High Lubricity
Average On Torque* (in lbs.)	<10	<10	<10	<8	<10	<5
Break/Prevail Torque* After Full Cure @ R.T. (in/lbs.)	210/250	225/250	200/185	175/100	270/260	210/95
(Nm)	24/28	25/28	23/21	20/12	30/30	24/11
Temperature Range (°F) (°C)	-65/300 -54/150	-65/400 -54/200	-65/300 -54/150	-65/300 -54/150	-65/300 -54/150	-65/300 -54/150
Lubricity	Medium	Low	Medium	Medium	Low	High
Fixture Time	5 Min.	5 Min.	5 Min.	5 Min.	5 Min.	5 Min.
On-Part Life***	4 years	4 years	4 years	4 years	4 years	4 years
Competitor Equivalent	Loctite** Dri-Loc** 200	Loctite** Dri-Loc** 201	Loctite** Dri-Loc** 202	Loctite** Dri-Loc** 203	Loctite** Dri-Loc** 204	Loctite** Dri-Loc** STS
Full Cure Time @ Room Temperature	72 hrs	72 hrs	72 hrs	72 hrs	72 hrs	72 hrs

Bulk Liquid State

Resin (anaerobic)	Dimethacrylate	Dimethacrylate	Dimethacrylate	Dimethacrylate	Dimethacrylate	Dimethacrylate
Specific Gravity	1.05 to 1.15	1.05 to 1.15	1.05 to 1.15	1.05 to 1.15	1.05 to 1.15	1.05 to 1.15
Flashpoint (Cleveland Open Cup)	Above 200°F/93°C	Above 200°F/93°C	Above 200°F/93°C	Above 200°F/93°C	Above 200°F/93°C	Above 200°F/93°C

Note: See MSDS for Safety & Material Handling Instructions. © ND Microspheres and ND Industries are registered trademarks of ND Industries, Inc.

* Based on 3/8 - 16 dry phosphated bolts and nuts.

** Loctite and Dri-Loc are registered trademarks of the Loctite Corporation.

*** Varies due to storage conditions.

For more information on ND Microspheres® Acrylic Series, or any of ND Industries other quality fastening products, contact your nearest ND Service Center:

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Solutions For Fastening Technology

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