

No. 642

Medium Strength Threadlocker



FASSTIX® No. 642 is a medium strength, anaerobic thread locking compound 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. FASSTIX® No. 642 exhibits good temperature and is solvent resistant.

Typical Applications:

FASSTIX® No. 642 will lock and seal fasteners, and set screws. It is used in applications where shock and vibration may cause the fastener to loosen.

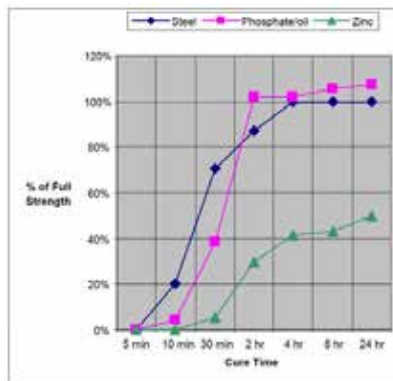
Properties of Uncured Material:

Chemical Type	Anaerobic
Colour	Blue
Toxicity	Low
Solids	100%
Viscosity @ 25 °C	cPs
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 to 20 Min @ 22 °C (72 °F)
Full Cure Time:	24 hours @ 22 °C (72 °F)
Temperature Range:	-51 °C to 150 °C (-60 °F to 300 °F)



Breakaway Strength:

3/8" Plain Steel nut and bolt @1 hr 50-150 lbf-in
 3/8" Plain Steel nut and bolt @24 hr 75-150 lbf-in
 3/8" Zinc nut and bolt @ 24 hr 60-100 lbf-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%

Informations générales :

Instructions for Use

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

Storage:

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

Note

FASSTIX® No. 642 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 :

WARNING: Causes skin irritation. Causes serious eye irritation. May cause an allergic skin reaction. Suspected of causing cancer. May cause respiratory irritation. May cause damage to organs through prolonged or repeated exposure. Avoid breathing vapours. Wear protective gloves. Wear eye protection. Inhalation: Remove person to fresh air. Eye Contact: Rinse cautiously with water for several minutes. If eye irritation persists, get medical attention. Skin Contact: Wash with plenty of water. If skin irritation or rash occurs, get medical attention.