



# TECTORIUS™ TEC-BOND™ 200 SERIES

Pre-Applied Fastener Adhesive & Thread Locker

## DESCRIPTION:

The Tec-Bond 200 Series of thread locking products are room-temperature curing, microencapsulated adhesives. They can be applied to male or female threaded fasteners of virtually all sizes, configurations, compositions and finishes.

Tec-Bond 200 Series contains a microencapsulated, reactive element that is suspended in a quick-curing, waterborne resin. The shearing forces caused by installation of the fastener to the mating part release the activator to allow curing of the resin matrix. The resulting chemical reaction rapidly bonds the surfaces, locking parts together and sealing leak paths.

Tec-Bond 200 products offer consistent and predictable torque values, and require no heat or primers for curing.

Specific formulations of Tec-Bond™ meet or exceed the performance requirements of the following standards:

### 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
- Meritor/Rockwell International Q-29
- Caterpillar 1E2486

## PRODUCT FEATURES:

- » **Unaffected By Automotive Fluids:** these materials resist and seal against most automotive fluids including oil, water, antifreeze, and gasoline.
- » **Variety of Strengths, Colors, & Viscosities:** this product is available in a variety of colors (custom colors available) for easy part inspection. Different strengths and properties are available to fit the desired application.
- » **Fast Fixture Times:** Under typical conditions, fixture is achieved within 15 minutes.
- » **High Temperature & Torque-Sensitive Formulas:** The 200 Series includes grades that are specifically intended for use in high temperature settings or tension-sensitive applications.
- » **Saves Money:** Tec-Bond products save valuable time and are less expensive than applying bottled thread locking compounds at the point of assembly.
- » **Suitable for Production Coating:** Each grade of the 200 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.



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## AVAILABLE GRADES:

Grade	Color	Primary Usage	Temperature Range		Break/Prevail Torque After Full Cure		Lubricity	Competes With
			(°F)	(°C)	(in. lbs.)	(Nm)		
<b>200</b>	Yellow	General Purpose	-65/300	-54/150	210/250	24/48	Medium	Loctite® Dri-Loc® 200
<b>200-HV</b>	Yellow	General Purpose	-65/300	-54/150	210/250	24/48	Medium	Dri-Loc® 200
<b>201</b>	Yellow	High Temp.	-65/400	-54/200	225/250	25/28	Low	Dri-Loc® 201
<b>201-HV</b>	Yellow	High Temp.	-65/400	-54/200	225/250	25/28	Low	Dri-Loc® 201
<b>202</b>	Green	Medium Strength	-65/300	-54/150	200/185	23/21	Medium	Dri-Loc® 202
<b>202-HV</b>	Green	Medium Strength	-65/300	-54/150	200/185	23/21	Medium	Dri-Loc® 202
<b>203</b>	Silver	Low Strength	-65/300	-54/150	175/100	20/12	Medium	Dri-Loc® 203
<b>203-HV</b>	Silver	Low Strength	-65/300	-54/150	175/100	20/12	Medium	Dri-Loc® 203
<b>204</b>	Pink	Plated Surfaces	-65/300	-54/150	270/260	30/30	Low	Dri-Loc® 204
<b>204-HV</b>	Pink	Plated Surfaces	-65/300	-54/150	270/260	30/30	Low	Dri-Loc® 204
<b>211</b>	Sapphire	High Strength	-65/300	-54/150	270/260	30/30	Medium	Dri-Loc® 211
<b>211-HV</b>	Sapphire	High Strength	-65/300	-54/150	270/260	30/30	Medium	Dri-Loc® 211
<b>218</b>	Green	Medium Strength	-65/300	-54/150	175/100	20/12	Medium	Dri-Loc® 218
<b>218-HV</b>	Green	Medium Strength	-65/300	-54/150	175/100	20/12	Medium	Dri-Loc® 218
<b>220</b>	Light Blue	Medium Strength	-65/300	-54/150	>200/70	>22/8	High	Loctite® Straight Thread Sealant™

Torques based on 3/8" - 16 dry phosphated bolts and nuts.  
Loctite® and Dri-Loc® are registered trademarks of Henkel Corp.

## ADDITIONAL SPECIFICATIONS:

<b>Installation Torque (in lbs.)</b> (Nm)	<10 <1.13
<b>Fixture Time</b>	<15 min.
<b>On-Part Life (Varies due to storage conditions)</b>	4 years
<b>Full Cure @ Room Temperature</b>	72 Hours
<b>Resin (Anaerobic)</b>	Methacrylate
<b>Specific Gravity</b>	1.05 to 1.15
<b>Typical Lead Threads</b>	1 to 3
<b>Typical Coating Length</b>	1.5x Diameter