

Installation Instructions for 28085

Green Bolt Locker

Wicking Formula

Note: This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

GENERAL INSTRUCTIONS

1. Surfaces to be bonded should be clean and dry and free of grease.
2. Product should be applied in enough quantity to fill all engaged threads.
3. The product performs best in thin bond gaps. Very large gaps may create gaps, which will affect the cure speed and overall strength. Good contact is essential.
4. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

SETTING TIME (680°F/200°C, 65% R.H.)

Substrate	Set time/Full cure
Steel	15 min/24 hrs.
Brass	15 min/24 hrs.
Zinc-Plated	20 min/24 hrs.
Stainless Steel	20 min/24 hrs.

PHYSICAL PROPERTIES

Service Temp Range: -65 to 3000 °F (-54 to 1490 °C)

Pin/Collar Strength: 2000 psi

Gap Fill: 003"

TYPICAL APPLICATIONS

- Pre-assembled threaded assemblies
- Adjustment screws
- Brazed joints in cooling systems
- Carburetors
- Electrical connectors



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