TECTORIUS® TEC-BOND™ P Series

Pre-Applied Adhesive & Threadlocker

DESCRIPTION:

The Tec-Bond® P-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 P-Series contains a microencapsulated, reactive element that is suspended in a quick-curing, solvent borne 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 products offer consistent and predictable torque values and require no heat or primers for curing.

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

AUTOMOTIVE:

- **Chrysler** PF-6616, MS-CC-76, MCSD7
- **Ford** WX200, ES-20007-S100, ES-20010-S100, WSS-M11P45-A1, WSS-M18P12-A, WSK-M2G354-A3, ESS-M11P24-A1 & ESS-M11P24-A2
- **General Motors** GM6175M, GM6193M, GM6194M, & GM6124M

INDUSTRIAL FASTENER INSTITUTE:

- IFI 125
- IFI 525
- DIN 267 Part 27

OEM:

Detroit Diesel 80K15
Meritor/Rockwell International Q-29
Meritor Q-52
Caterpillar 1E248



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 can be achieved in as little as 15 minutes.

» **High Temperature & Torque-Sensitive Formulas:** The P-Series includes grades that are specifically intended for use in high temperature settings or torque-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, while also improving product quality and reducing warranty claims.

» **Suitable for Production Coating:** Each grade of the P-Series is available in viscosities suitable for use on a broad range of high speed production coating equipment.

*The information provided is based on technical data that Tectorius believes to be reliable. Since we cannot anticipate or control the various conditions under which this information and our product may be used, we cannot guarantee the applicability of this information or the suitability of our product in any individual situation. Therefore, the product is sold without warrantee expressed or implied.

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AVAILABLE GRADES:

Grade	Color	Primary Usage	Break/Prevail Torque After Full Cure		Temperature Range		Lubricity	Viscosity cPs
			(in/lbs)	(Nm)	(˚F)	(˚C)		
P-30	Yellow	Low Strength	80/50	9/5.7	-58/300	-50/150	Medium	300-1200
P-80	Pink	Hi Strength, Hi Temp	265/200	30/22.6	-58/392	-50/200	High	300-1200
P-85	Turquoise	Medium Strength, Torque Control	180/100	20.3/11.3	-58/392	-50/200	high	300-1200

Regulatory Compliant (-RC) Versions

The Tec-Bond P-Series is available in a Regulatory Compliant form, denoted by the suffix -RC. Tec-Bond P30-RC, P80-RC and P85-RC meet and exceed the requirements of EU Regulations 2020/784 and 2021/1297 regarding de minimis content of PFOA (C9-C14) and related compounds.

Torque based on 3/8” - 16 dry phosphated bolts and nuts.

SPECIFICATIONS:

Installation Torque (in/lbs.)	<10
Fixture Time	<1 hour
On-Part Life*	4 years
Full Cure Time @ Room Temperature	<72 hours

Don’t see a product that suits your application needs? Our research and development team (R&D) is ready to assist you in formulating a custom coating to meet your specific requirements.



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