



# LT HIGH STRENGTH RED THREADLOCKER

PART NO. **AT160**

## DESCRIPTION

AT160 is a single-component, red, high-strength, threadlocking adhesive. It is designed for larger threaded fasteners up to 1" in diameter and is suitable for heavy-duty applications where high levels of shock, vibration, and stress are present. This formula is recommended in applications where permanent adhesion is needed and may require heat to be disassembled.

## PHYSICAL PROPERTIES

Technology / Base	Dimethacrylate Ester
Type of Product	Adhesive and Sealant
Components	One Component
Curing	Anaerobic with Secondary Heat Cure
Appearance / Color	Red
Consistency	Liquid

## TECHNICAL DATA

Property	Value	Method/Condition
<b>Rheology</b>		
Viscosity	1800 +/- 600 cPs	Brookfield at 25°C, Spindle 3 @ 20 rpm
<b>Density</b>		
Specific Gravity	1.10	N/A
<b>Uncured Materials Characteristics</b>		
Flash Point	> 93°C (200°F)	N/A
Gap Fill	0.010 inch	N/A
Shelf Life	12 months unopened	N/A
Storage Condition	20°C (68°F)	N/A
<b>Cured Materials Characteristics</b>		
Full Cure Conditions	24 hours at 25°C	N/A
Cure Appearance	Red Solid	N/A
RoHS Compliant	Yes	N/A
<b>Cured Mechanical Properties</b>		
Locking Strength	High	N/A
Breakaway Torque	125 in-lb. to No Limit	ASTM D5649
Prevailing Torque	150 in-lb. to No Limit	ASTM D5649
Service Temperature	-55°C to 150°C (-65°F to 300°F)	N/A

## SPECIFICATIONS AND APPROVALS

Mil-S-46163A, Type II Grade O;  
ASTM D-5363 AN 0331



## INSTRUCTIONS

Surfaces to be bonded should be clean, dry and free of grease. Product should be applied in enough quantity to fill all engaged threads or gap. The product performs best in thin bond gaps. Very large gaps may create voids that will affect the cure speed and overall strength. Good contact is essential. It is recommended to confirm compatibility of the product with all substrates prior to use. This product is not recommended for use with strong oxidizing materials. Where aqueous washing systems are used to clean the surfaces before bonding, these aqueous washes can affect the cure and performance of the adhesive. This product is not normally recommended for use on plastics, users must check compatibility of the product with such substrates.

## CURING PERFORMANCE

The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

## STORAGE

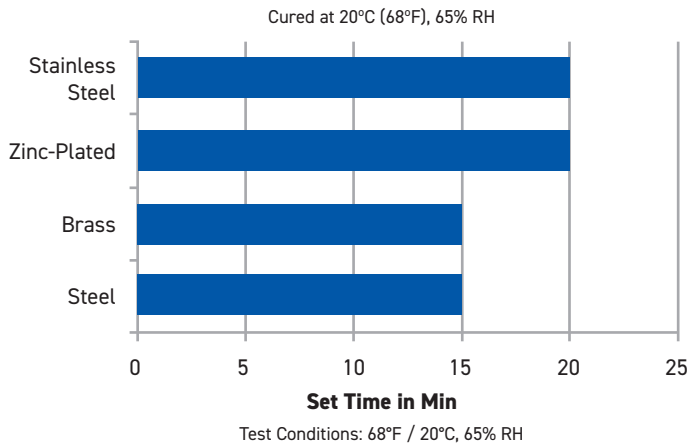
Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

## SAFETY & DISPOSAL

For safe handling information on this product, consult the Safety Data Sheet (SDS).



## SET TIME ON VARIOUS SUBSTRATES

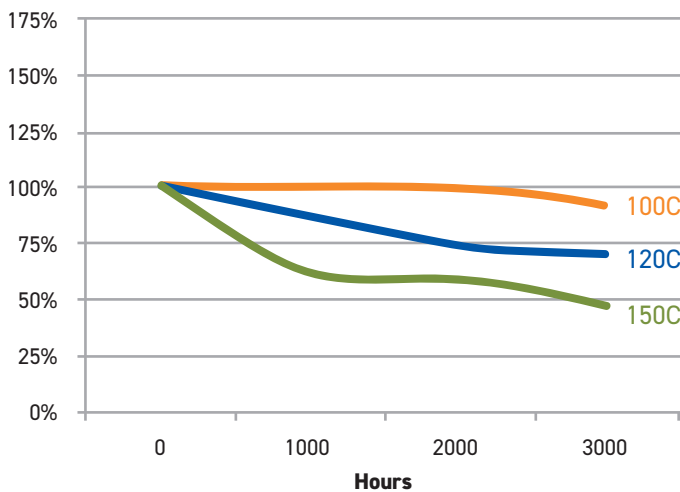


## SOLVENT RESISTANCE

Solvent	Example	Resistance
Alcohol	Ethanol, methanol	Excellent
Ester (aromatic)	Ethylacetate	Poor
Ketone (aromatic)	Acetone, benzophenone	Poor
Aliphatic hydrocarbon (alkanes)	Petrol, heptanes, hexane	Good
Aromatic hydrocarbons	Benzyl, toluol, xylol	Good
Halogenated hydrocarbons	Methylenchloride, chloroform, chlorobenzol	Poor
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	Excellent (poor if concentrated)
Weak aqueous base	Sodium hydroxide solution, caustic potash	Excellent (poor if concentrated)

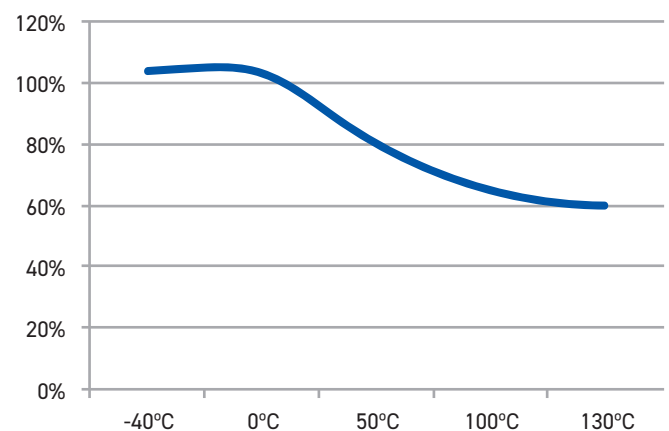
## HEATING AGING

Aged at Temperature Indicated & Tested at 22°C



## HOT STRENGTH

%RT Strength, Tested at Temperature



## DISCLAIMER

IMPORTANT: The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is user's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. The user is advised to review the specific context of the intended use to determine whether the user's intended use violates any law or infringes upon any patent(s). No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

**NOTE TO USER:** by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Unless otherwise noted, trademarks are property of H.B. Fuller Company or one of its affiliated entities. Gorilla and GorillaPro are registered trademarks of The Gorilla Glue Company.

© H.B. Fuller Company, 2022.

TDS - Threadlocker - AT160 - Updated 11-10-2021



**GorillaPro.com**

9001 W. Fey Dr. · Frankfort, IL 60423 · +1-888-676-7763  
SUPPORT: 1-888-MRO-PROF, gorillapro@hbfuller.com



**H.B. Fuller**