

## Nut Grade Adhesive

Product Code: D77

### CURING PROPERTIES

<b>Handling Cure Time</b>	10 minutes
<b>Functional Cure Time</b>	1 - 3 hours
<b>Full Cure Time</b>	24 hours
<b>Breakaway Torque</b>	20 N.m; 180 lb.in

### KEY BENEFITS

-  Medium Strength
-  Fast Curing
-  Anti-Vibration
-  Chemical and Oil Resistant
-  Corrosion and Leakage Prevention



## PRODUCT OVERVIEW

Delta 77 is a fast-curing, medium-strength anaerobic threadlocking compound designed for bonding and sealing threaded assemblies and retaining cylindrical parts. It provides reliable locking performance with excellent resistance to heat, vibration, water, oils, gases, hydrocarbons, and many industrial chemicals.

### TECHNICAL PROPERTIES

PROPERTY	VALUE
<b>Composition</b>	<b>Dimethacrylate Ester</b>
<b>Colour</b>	<b>Blue</b>
<b>Viscosity</b>	<b>2250 cps at 25°C</b>
<b>Specific Gravity</b>	<b>1.07</b>
<b>Flash Point</b>	<b>&gt;100°C</b>
<b>Temperature Range</b>	<b>-55°C to 150°C</b>

## APPLICATIONS



Fasteners between 6mm and 20mm in diameter



Less active materials such as stainless steel and plated parts



Meets Military specifications: MIL-S-46163 Type II Grade N and MIL-S-22473E Letter Grade CVV.



Nuts, screws, and studs requiring secure locking

## CHEMICAL RESISTANCE

CHEMICAL	TEMP	500 Hours	1000 Hours
Acetone	22°C	95%	90%
Ethanol	22°C	100%	100%
Motor Oil (125°C)	125°C	95%	95%
Gasoline	22°C	100%	100%
Break Fluid	22°C	100%	100%
Water/Glycol (87°C)	87°C	90%	80%

## INSTRUCTIONS FOR USE

- 1. Prepare surfaces** - Ensure all parts are clean, dry, and free from oil, grease, or other contaminants before application.
- 2. Apply adhesive** - Apply Delta 77 directly to the bolts in sufficient quantity to fill threads. The product performs best in thin bond gaps.
- 3. Assemble components** - Assemble and tighten parts as required. The formulation provides controlled friction and consistent torque/tension during assembly.

## STORAGE

Anaerobic adhesives shall be ideally stored in a cool, dry place in unopened containers at a room temperature between 5 °C and 25 °C. Please do not return any unused material in its original container.

## HEALTH AND SAFETY

- Classification: Xi irritant
- Keep out of reach of children
- Keep away from face and eyes
- Shelf Life: 2 Years

## LEGAL NOTE

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Delta Adhesives Limited accepts no liability arising out of the use of this information or the products described herein.