

NUT GRADE ADHESIVE



Product Code: D77

Curing Properties

Handling Cure Time	10 minutes
Functional Cure Time	1 - 3 hours
Full Cure Time	24 hours
Breakaway Torque	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

COMPOSITION	Dimethacrylate Ester
COLOUR	Blue
VISCOSITY	2250 cps at 25°C
SPECIFIC GRAVITY	1.07
MAX THREAD SIZE	>100°C
TEMPERATURE RANGE	-55°C to 150°C

Storage: Store below 25°C • Safety: See SDS for full details • www.delta-adhesives.co.uk

Applications



- ✓ Fasteners between 6mm and 20mm in diameter
- ✓ Less active materials such as stainless steel and plated parts
- ✓ Fasteners between 6mm and 20mm in diameter
- ✓ Meets Military specifications: MILS-46163 Type II Grade N and MIL-S22473E Letter Grade CVV.

Chemical Resistance

CHEMICAL	TEMP	500 HOURS	1000 HOURS
Aceton	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 of 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 threads in sufficient quantity to fill threads. The product performs best in thin bond gaps.
- 2. 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 & 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.