



# TECTORIUS® TEC-BOND™ 251

Pre-Applied Fastener Adhesive & Thread Locker

## DESCRIPTION:

The Tec-Bond 251 Series of thread locking products are high-temperature resistant, microencapsulated adhesives. They can be applied to male or female threaded fasteners of virtually all sizes, configurations, compositions and finishes.

Tec-Bond 251 products contain microencapsulated reactive elements that are suspended in a quick-curing resin, carried in a solvent or water medium (dependent on formula).

The shearing forces caused by installation of the fastener to the mating part release reactive compounds that cure into a tough, well-bonded polymer. The resulting matrix rapidly bonds the surfaces, semi-permanently locking parts together and sealing leak paths.

Tec-Bond 251 products offer consistent and predictable torque values, and require no heat or primers for curing.

**Specific formulations of Tec-Bond™ 251 meet or exceed the performance requirements of the following standards:**

### AUTOMOTIVE:

- Chrysler PF-6616 & MS-CC-76
- Ford ES-20007-S100, ES-20010-S100  
ESS-M11P24-A1 & ESS-M11P24-A2
- General Motors GM6175M & GM6194M

### INDUSTRIAL FASTENER INSTITUTE:

- IFI 125
- IFI 525

### OEM:

- Detroit Diesel 80K15
- Meritor/Rockwell International Q-29
- Caterpillar 1E2486

## PRODUCT FEATURES:

- » **Unaffected By Automotive Fluids:** these materials resist and seal against most automotive fluids. Oil, water, antifreeze, and gasoline have virtually no effect on this family of materials once final cure has been achieved. Tec-Bond 251 products are designed to function in high-temperature environments for extended periods of time, such as in engine compartments.
- » **Variety of Strengths, Colors, & Viscosities:** this product is available in a variety of colors (for easy part inspection) and formulas to best suit the customers' coating equipment. A wide range of similar Tec-Bond products are formulated to satisfy most thread locking requirements.
- » **Fast Fixture Times:** Under typical conditions, fixture is achieved within 90 minutes.
- » **Saves Money:** Tec-Bond 251 products save valuable time and are less expensive than applying bottled thread locking compounds at the point of assembly.
- » **Suitable for Production Coating:** Each grade of the 251 Series is available in viscosities suitable for use on a broad range

\*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 warranty expressed or implied.

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## SPECIFICATIONS:

	Grade 251	251 SC	251 WB	251 DPC
<b>Color</b>	Orange/Neutral	Orange/Neutral	Orange/Neutral	Orange/Neutral
<b>Variant Purpose</b>	Standard Formula	Highly concentrated for transport efficiency	No solvent formula	Solvent removed for transport efficiency
<b>Carrier Medium</b>	Toluene	Solvent Concentrate	Water	None / Dry Concentrate
<b>Installation Torque (in/lbs.)</b>	<10	<10	<10	<10
<b>Break/Prevail Torque After Full Cure (in/lbs.)</b>	225/250	225/250	225/250	225/250
<b>(Nm)</b>	25/28	25/28	25/28	25/28
<b>Temperature Range (°F)</b>	-65/350	-65/350	-65/350	-65/350
<b>(°C)</b>	-54/175	-54/175	-54/175	-54/175
<b>Fixture Time</b>	>90 min.	>90 min.	>90 min.	>90 min.
<b>On-Part Life*</b>	4 years	4 years	4 years	4 years
<b>Full Cure Time @ Room Temperature</b>	>72 hrs.	>72 hrs.	>72 hrs.	>72 hrs.
<b>Bulk Shelf Life</b>	1 year	1 year	1 year	3 years

Torques based on 3/8" - 16 dry phosphated bolts and nuts.

\* Varies due to storage conditions.

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