

Cyanoacrylates
Anaerobics
Epoxies
Acrylics
Gasketing & Sealing

PACER TECHNOLOGY

INDUSTRIAL

ADHESIVES

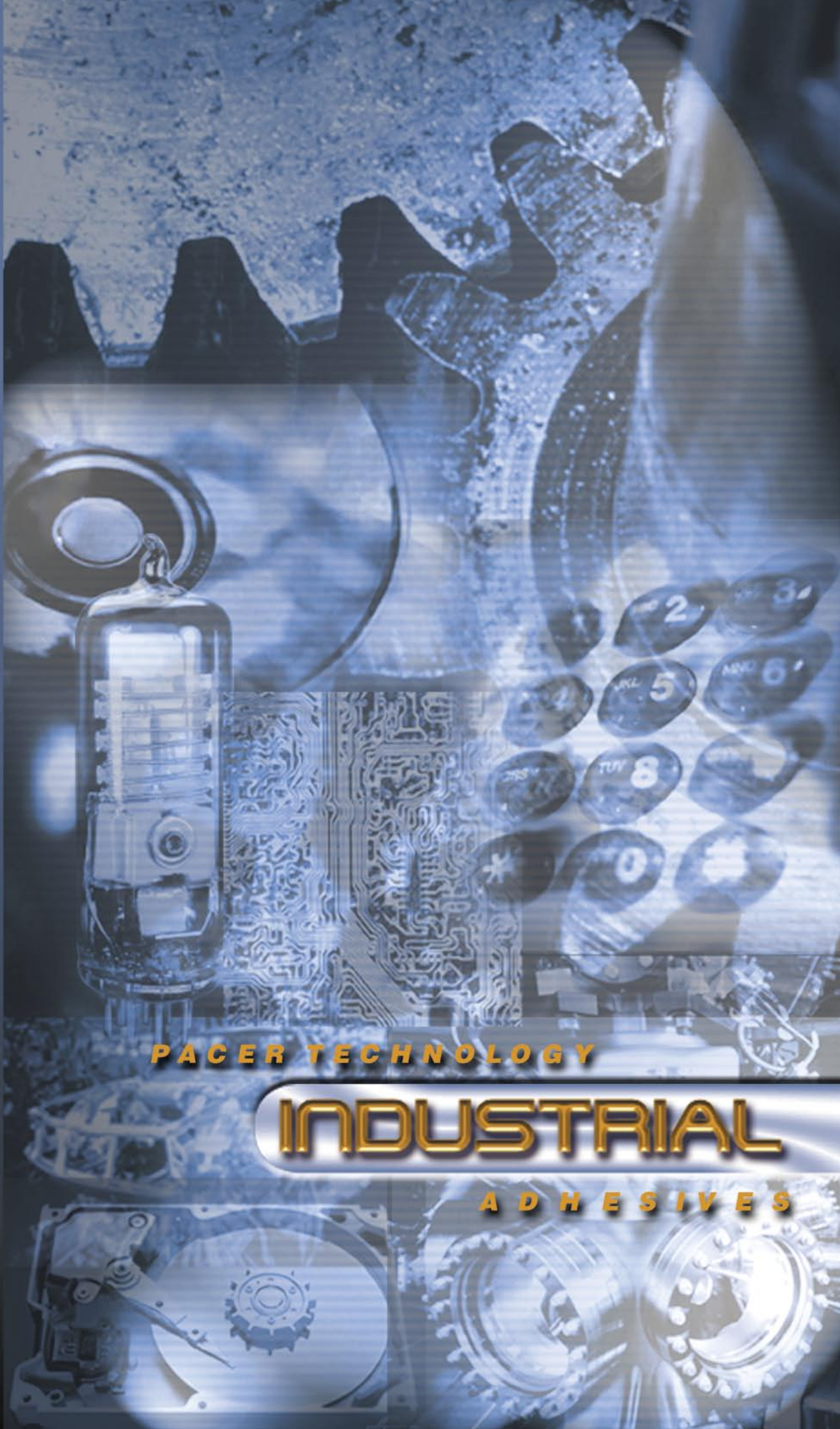


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PACER TECHNOLOGY began supplying adhesives and related chemicals to its customers in 1975. Since then, Pacer has evolved into a multi-faceted company involving manufacturing, formulating, packaging and marketing high performance **Engineering Adhesives including Cyanoacrylates, Anaerobics, Epoxies, Acrylics, Gasketing and Sealing** products. Our products are sold worldwide under both private label and proprietary trademarks to the industrial markets.

PACER TODAY

Pacer headquarters, manufacturing, and distribution facilities are located in Southern California. Three manufacturing and distribution facilities, totaling 90,000 square feet, currently support our growing industrial customer base. These state of the art facilities and fully integrated operations give us the ability to customize product formulations, private label package and produce a total turnkey package to meet our customer's specifications.

PACER MEANS HIGHER QUALITY

Pacer Technology has a long-standing track record for consistently high quality products. Pacer's **Advanced Technology Cyanoacrylates** are unmatched in the industry, bonding dirty, contaminated, porous, non-porous, acidic, and many other hard to adhere surfaces. We manufacture our own bottles, tips and caps from proprietary resin formulations with in-house injection and blow molding equipment. Our patented tips are specially formulated to prevent clogging. In addition, all tips are fused to the bottle to insure maximum shelf life and eliminate separation. Pacer's patented breakaway luer tip allows easy opening and resealing, and will accept standard luer dispensing needles.

Our ANA-LOK™ **Anaerobic** grades are non-surface sensitive and require no primer for cure. To compliment these industry essential products, Pacer manufactures **Epoxies** with varying set times, structural **Acrylics**, and automotive **Gasketing and Sealing** products.

STANDARD GRADE CYANOACRYLATES

Pacer Standard Grade Cyanoacrylates are the "workhorse grades", requiring close fitting, clean, dry, oil-free surfaces to achieve optimum bonding performance.

"Adhering to Excellence"™



PACER SERVICE

Our years of knowledge and support to the industrial market have solved countless OEM, MRO and general application issues. An experienced staff of customer and technical service representatives support all the Pacer technology products. Complementing our production flexibilities is our expert knowledge of EDI, ASN's, state-of-the-art bar coding and scanning distribution methods, all of which make for a very efficient and effortless shipping and purchasing decision.

IMPORTANT NUMBERS & INFORMATION

For questions regarding customer service, technical advice or purchase orders including EDI, call:

Toll Free: (800) 538-3091 or
(909) 987-0550

To place an order by fax:
Customer Service fax - (909) 481-0063
Main fax - (909) 987-0490

To email:
info@pacertechnology.com

For International email:
intlsales@pacertechnology.com

Website:
www.pacertechnology.com

SIMPLIFIED PRODUCT IDENTIFICATION

Pacer has simplified the instant adhesive selection process by defining the chemical type (letter) with viscosity number designations (i.e. E-5 means ethyl chemical type at a viscosity 5 cps RX-100 means Range Extended at 100 (cps). All Pacer instant adhesive labels are color coded according to cure time.

COLOR	CURE DESIGNATION	ACTUAL CURE TIME
RED LABEL	INSTANT CURE	2-10 SECONDS*
ORANGE LABEL	FAST CURE	5-20 SECONDS*
YELLOW LABEL	MEDIUM CURE	10-30 SECONDS*
GREEN LABEL	SLOW CURE	30-50 SECONDS*
BLUE LABEL	VERY SLOW CURE	35-60 SECONDS*
BLACK LABEL	SLOWEST CURE	30-120 SECONDS*

*Times may vary with gaps and surface type.

MIL-SPEC CERTIFICATION

Pacer Technology cyanoacrylates certified for compliance to MIL-A-46050C and to commercial item A-A-3097. Certification status is verified by this interchange. Shipments can be certified by batch number and by purchase order.

Pacer Product Designation	Military Type	Class (viscosity)
E-5	II	1
E-40	II	1
E-100	II	2
E-1500	II	3
E-2500	II	3
HC-150	Note B*	2
HI-50	II	1
HI-150	II	2
HI-500	II	3
HP-10	II	1
HP-500	II	3
HP-3000	II	3
HP-5000	II	4
ISL-22	Note A* II	2
ISL-42	Note A* II	3
ISL-71	Note A* II	2
ISL-90	Note A* II	1
MR-10	II	1
MR-290	II	2
MR-3000	II	3
PX-5	II	1
PX-50	II	1
PX-500	II	2
RX-5	II	1
RX-50	II	1
RX-100	II	2
RX-500	II	3
RX-700	II	3
TX-5	II	1
TX-100	II	2
TX-750	II	3

NOTE A*: For Section 3.2.1. Compliance, the ISL products will be supplied colorless. Request for dyed products should qualify this deviation from the specification.

NOTE B*: These products are Isopropyl-2 Cyanoacrylates - No type category exists for this chemistry on the current MIL-SPEC. Request deviation from spec as required for each application.

All Pacer Anaerobic threadlocking materials meet MIL-S-46163A* with the following types and grades.

Pacer Product Designation	Type/Grade
ANL-22	TYPE II/GRADE M
ANL-42	TYPE II/GRADE N
ANL-71	TYPE I/GRADE K
ANL-77	TYPE I/GRADE L
ANL-90	TYPE III/GRADE R
MIL-S-22473E	

*Pacer Technology products may exceed the maximum prevailing strength values on plated parts as shown on Table III or section 3.4.1 of MIL-S-46163A. Performance specification ASTM D-5363 is intended to replace this specification.

INDUSTRIAL

Instant Adhesives • Standard Grade Cyanoacrylates



STANDARD ETHYL TYPES

For bonding similar as well as dissimilar materials; including ceramics, metal, plastic, rubber and wood. **Features include:** good heat aging characteristics, moisture resistance, and weatherability. Excellent for adhering glass, but bond will deteriorate with age.

		Size	Part #
E-5	INSTANT CURE: Able to penetrate between parts • 5 cP viscosity* allows up to .002" gap fill capability • Meets MIL-A-46050C Type II Class 1	5 gram	01015
		20 gram	01010
		1 lb.	01013
E-40	FAST CURE: General purpose • 40 cP viscosity* allows up to .004" gap fill capability • Meets MIL-A-46050C Type II Class 1	5 gram	01025
		20 gram	01020
		1 lb.	01023
E-100	MEDIUM CURE: Broad use adhesive • 100 cP viscosity* allows up to .005" gap fill capability • Meets MIL-A-46050C Type II Class 2	5 gram	01035
		20 gram	01030
		1 lb.	01033
E-1500	SLOW CURE: Bridges gaps, allows work piece alignment • 1500cP viscosity* allows up to .010" gap fill capability • Meets MIL-A-46050C Type II Class 3	20 gram	01050
		1 lb.	01053
E-2500	VERY SLOW CURE: Allows maximum time for positioning of parts. Use to bond fibrous and porous materials • 2500 cP viscosity * allows up to .020" gap fill capability • Meets MIL-A-46050C Type II Class 3	20 gram	01060
		1 lb.	01063

NOTE: Shelf life of all E Series adhesives is one year stored at 70°F. Optimum shelf life obtained when stored unopened at 40°F.
* Nominal Viscosity – refer to physical property chart for viscosity range.

PHYSICAL PROPERTY CHART • Standard Grade Cyanoacrylates

	Clear Liquid • Grade	E-5	E-40	E-100	E-1500	E-2500	
Liquid State	CHEMICAL TYPE	ETHYL	ETHYL	ETHYL	ETHYL	ETHYL	
	Viscosity Range, cP	2-10	30-70	80-120	1300-1700	2200-2700	
	Specific Gravity (25°C)	1.05	1.06	1.08	1.10	1.11	
	Flashpoint (COC °F)	185	185	185	185	185	
	Vapor Pressure (@ 70°C, mmHg)	8	8	8	8	8	
	Soluble in:	Pacer X-8 Debonder, [™] Acetone, Nitromethane					
Cured State	Melting Point (°F/°C)	365/185	365/185	365/185	368/187	368/187	
	Softening Point (°F/°C)	311/155	307/153	306/152	301/149	301/149	
	Service Temperature Range	(-65°F to 180°F) (-54°C to 82°C)					
	Refractive Index (n _{20°C/D} ± .03)	1.45	1.45	1.45	1.45	1.45	
	Hardness – ROCKWELL	M75	M75	M74	M72	M72	
	Gap Filled, Typical, Inches	.002	.004	.005	.010	.015	
	Outgassing @ 10 ⁻⁶ mmHg (72°F)	0	0	0	0	0	
	Elongation (%)	< 2	< 2	< 2	< 2	< 2	
	Tensile Shear Strength, steel/steel, ASTM-D1002 (ft./in ²)	2200 - 2600	2400 - 3000	2200 - 2600	2000 - 2400	1800 - 2200	
	Soluble in:	Pacer X-8 Debonder, [™] Acetone, Nitromethane					

NOTE: Values are typical and should not be used as product specification.



INDUSTRIAL

Advanced Grade Cyanoacrylates • Instant Adhesives

RX-RANGE EXTENDED

This group of instant adhesives is virtually non-surface sensitive, and will bond in situations where conventional cyanoacrylates fail. The bonding surfaces of acidic substrates (H+), like woods, veneers, rubber, cork, cardboard and leather, are overcome by these High Performance grades of cyanoacrylates. Unlike other instant adhesives available, the RX chemistry allows the user to achieve **Instant/High Strength** bonds on surfaces contaminated with: Silicone greases, oils & release agents, as well as plated parts, reducing surface preparation costs. RX will also bond routine plastics, nylon, Delrin®, vinyls, naphahyde, woven fabrics and metals.

		Size	Part #
RX-5	INSTANT CURE: Able to penetrate between parts • 5 cP viscosity * allows up to .002" gap fill capability • Meets MIL-A-46050C, Type II, Class 1	5 gram	04055
		20 gram	04050
		1 lb.	04053
RX-50	FAST CURE: General purpose • 50 cP viscosity* allows up to .004" gap fill capability • Meets MIL-A-46050C, Type II, Class 1	5 gram	04015
		20 gram	04010
		1 lb.	04013
RX-100	MEDIUM CURE: Broad use adhesive • 100 cP viscosity* allows up to .005" gap fill capability • Meets MIL-A-46050C, Type II, Class 2	5 gram	04025
		20 gram	04020
		1 lb.	04023
RX-500	SLOW CURE: Bridges gaps, allows work piece alignment • 500cP viscosity* allows up to .008" gap fill capability • Meets MIL-A-46050C, Type II, Class 3	20 gram	04040
		1 lb.	04043
RX-700	VERY SLOW CURE: Allows more time for parts positioning; can be spread or squeegee applied • 700 cP viscosity * allows up to .010" gap fill capability • Meets MIL-A-46050C, Type II, Class 3	20 gram	04060
		1 lb.	04063
RX-GEL	SLOWEST CURE TIME: Allows maximum time for positioning of parts. Non-sag, non-running formula allows for vertical applications. • Allows .020" gap fill capability	5 gram tube	04075
		20 gram tube	04070
		200 gram cartridge	04072

NOTE: Shelf life of all RX adhesives is one year stored at 70°F. Optimum shelf life obtained when stored unopened at 40°F.

* Nominal Viscosity – refer to physical property chart for viscosity range.

PHYSICAL PROPERTY CHART - Advanced Grade Cyanoacrylates

	Clear Liquid • Grade	RX-5	RX-50	RX-100	RX-500	RX-700	RX-GEL
Liquid State	CHEMICAL TYPE	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID
	Viscosity Range, cP	2-10	30-70	80-120	400-600	600-800	45,000-85,000
	Specific Gravity (25°)	1.05	1.05	1.06	1.06	1.06	1.08
	Flashpoint (COC °F)	185	185	185	185	185	185
	Vapor Pressure (@ 70°C, mmHg)	< 2	< 2	< 2	< 2	< 2	< 2
	Soluble in:	X-8 Debonder,™ Acetone, Nitromethane					
Cured State	Melting Point (°F/°C)	365/185	365/185	365/185	365/185	365/185	368/187
	Softening Point (°F/°C)	310/154	305/152	305/152	305/152	305/152	303/151
	Service Temperature Range	-65°F to 180°F (-54°C to 82°C)					
	Refractive Index (n _{20°C/D} ± .03)	1.45	1.45	1.45	1.45	1.45	1.45
	Hardness – ROCKWELL	M75	M75	M75	M75	M75	M73
	Gap Filled, Typical, Inches	.002	.004	.005	.008	.010	.020
	Outgassing @ 10 ⁻⁶ mmHg (72°F)	0	0	0	0	0	0
	Elongation (%)	< 2	< 2	< 2	< 2	< 2	< 2
	Tensile Shear Strength, steel/steel ASTM-D1002 (ft./in ²)	2200-2600	2200-2600	2200-2600	2200-2600	2200-2600	2200-2600
	Soluble in:	Pacer X-8 Debonder,™ Acetone, Nitromethane					

NOTE: Values are typical and should not be used as product specification.

INDUSTRIAL

Instant Adhesives • Advanced Grade Cyanoacrylates



Pacer Technology MR Instant Adhesives are specially formulated to resist moisture and humidity while retaining tensile shear strength. MR's are also temperature resistant. Three viscosity ranges are available to meet a variety of bonding application needs.

		Size	Part #
MR-10	FAST CURE: Able to penetrate between parts • 10 cP viscosity* allows up to .002" fill gap capability • Meets MIL-A-46050C, Type II, Class 1	20 gram	04440
		1 lb.	04443
MR-290	SLOW CURE: Allows part positioning time • 290 cP viscosity* allows up to .012" gap fill capability • Meets MIL-A 46050C, Type II, Class 2	5 gram	04455
		20 gram	04450
		1 lb.	04453
MR-3000	VERY SLOW CURE: Allows work piece alignment • 3000cP viscosity* allows up to .015" gap fill capability • Meets MIL-A 46050C, Type II, Class 3	20 gram	04460
		1 lb.	04463
NO-150	SLOW CURE: Allows part positioning time • 150 cP viscosity * allows up to .006" gap fill capability	20 gram	04110
		1 lb.	04123

No Odor - No Frost: Instant adhesives for applications where appearances are critical without irritating vapors or fumes. Good adhesive for plastic, rubber and metal with suitable applications on cosmetic cases, medical devices and electronic assemblies.

NOTE: Shelf life of all MR series adhesives is one year stored at 70°F. Optimum shelf life is obtained when stored unopened at 40°F.
Shelf life of NO series adhesives is six months stored at 70°F. Optimum shelf life is obtained when stored unopened at 40°F.
*Nominal viscosity - refer to physical property chart for viscosity range.

PHYSICAL PROPERTY CHART - Advanced Grade Cyanoacrylates

	MR-10	MR-290	MR-3000	NO-150
Liquid State				
Clear Liquid • Grade	MR-10	MR-290	MR-3000	NO-150
CHEMICAL TYPE	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	METHOXY
Viscosity Range, cP	6-12	250-350	2500-3500	100-200
Specific Gravity (25°C)	1.05	1.05	1.05	1.04
Flashpoint (COC °F)	185	185	185	185
Vapor Pressure (@ 70°C, mmHg)	< 2	< 2	< 2	< 2
Soluble in:	Pacer X-8 Debonder, [™] Acetone, Nitromethane			
Cured State				
Melting Point (°F/°C)	366/186	361/183	356/180	329/165
Softening Point (°F/°C)	310/155	300/149	296/147	304/151
Service Temperature Range	MR-10 /290 / 3000 (-55°F to 250°F) (-48°C to 121°C)			NO-150 (-65°F to 200°F) (-54°C to 93°C)
Refractive Index (n ₂₀ [°] C/D ± .03)	1.45	1.45	1.45	1.49
Hardness – Rockwell (M)	73	67	64	SHORE D 75-80
Gap Filled, Typical, Inches	.002	.012	.020	.006
Outgassing @ 10 ⁻⁶ mmHg 72°F)	0	0	0	0
Elongation (%)	< 2	< 2	< 2	3 >
Tensile Shear Strength, steel/steel, ASTM-D1002 (ft./in ²)	2800 - 3000	2800 - 3000	2800 - 3000	2000 - 3000
Soluble in:	Pacer X-8 Debonder, [™] Acetone, Nitromethane			

NOTE: Values are typical and should not be used as product specification.



INDUSTRIAL

Advanced Grade Cyanoacrylates • Instant Adhesives

PX Plastics - Extended Performance grades provide maximum strengths for bonding various plastics and elastomers together or in combination with metals and other materials. Select PX whenever organic materials are to be bonded. Service temperature range -65°F to 200°F, impact strengths, 4-8 lbs/in². The PX chemistry provides an intermediate grade between the RX and the HI type product capabilities. Excellent performance on nylon, ABS, PVC, certain fluorocarbons, etc. Will not crack or craze ABS.

		Size	Part #
PX-5	INSTANT CURE: Able to penetrate between parts • 5 cP viscosity* allows up to .002" gap fill capability • Meets MIL-A-46050C, Type II, Class 1	20 gram	05070
		1 lb.	05073
PX-50	FAST CURE: General purpose • 50 cP viscosity* allows up to .004" gap fill capability • Meets MIL-A-46050C, Type II, Class 1	5 gram	05085
		20 gram	05080
		1 lb.	05083
PX-500	SLOW CURE: Allows work piece alignment • 500 cP viscosity * allows up to .008" gap fill capability • Meets MIL-A-46050C, Type II, Class 3	20 gram	05090
		1 lb.	05093
<p>TX Temperature Extended: Single component, high temperature cyanoacrylates for use at service temperatures up to 300°F. Best for wire tacking and component bonding to printed circuit boards before and after wave soldering. TX chemistry is specially designed to permit rapid "wire tacking" to plain printed circuit boards; boards covered with solder masks; and provides the best performance for "tacking" when board processing includes water washing operations. These formulations work well on chromate conversion coatings and oily parts. Excellent impact strengths of 10-15 lbs/in² can be obtained.</p>			
TX-5	INSTANT CURE: Able to penetrate between parts • 5 cP viscosity* allows up to .002" fill gap capability • Meets MIL-A-46050C, Type II, Class 1	20 gram	05101
		1 lb.	05102
TX-100	MEDIUM CURE: Broad use adhesive • 100 cP viscosity* allows up to .004" gap fill capability • Meets MIL-A-46050C, Type II, Class 2	20 gram	05511
		1 lb.	05512
TX-750	SLOW CURE: Allows work piece alignment • 750 cP viscosity * allows up to .010" gap fill capability • Meets MIL-A-46050C, Type II, Class 3	20 gram	04504
		1 lb.	04503

NOTE: Shelf life of all TX and PX adhesives is one year stored at 70°F. Optimum shelf life obtained when stored unopened at 40°F.
*Nominal viscosity - refer to physical property chart for viscosity range.

PHYSICAL PROPERTY CHART - Advanced Grade Cyanoacrylates

	Clear Liquid • Grade	PX-5	PX-50	PX-500	TX-5	TX-100	TX-750
Liquid State	CHEMICAL TYPE	ETHYL PROPYL	ETHYL PROPYL	ETHYL PROPYL	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID
	Viscosity Range, cP	2-10	30-80	400-600	2-10	80-150	650-850
	Specific Gravity (25°C)	1.04	1.04	1.04	1.05	1.05	1.06
	Flashpoint (COC °F)	186	186	186	185	185	185
	Vapor Pressure (@ 70°C, mmHg)	< 2	< 2	< 2	< 2	< 2	< 2
	Soluble in:			F	Ac		
Cured State	Melting Point (°F/°C)	363/184	363/184	363/184	369/187	369/187	368/186
	Softening Point (°F/°C)	303/151	303/151	313/151	313/156	312	309
	Service Temperature Range	(-65°F to 200°F) (-54°C to 93°C)			(-65°F to 300°F) (-54°C to 149°C)		
	Refractive Index (n _{20°C/D} ± .03)	1.45	1.45	1.45	1.45	1.45	1.45
	Hardness – ROCKWELL	M70	M70	M70	M73	M70	M70
	Gap Filled, Typical, Inches	.002	.004	.008	.002	.004	.010
	Outgassing @ 10 ⁶ mmHg (72°F)	0	0	0	0	0	0
	Elongation (%)	< 2	< 2	< 2	< 2	< 2	< 2
	Tensile Shear Strength, steel/steel, ASTM-D1002 (ft./in ²)	2800-3200	2800-3200	2800-3200	2800-3200	2800-3200	2800-3200
	Soluble in:	Pacer X-8 Debonder,™ Acetone, Nitromethane					

NOTE: Values are typical and should not be used as product specification.

INDUSTRIAL

Instant Adhesives • Advanced Grade Cyanoacrylates



HI-HIGH IMPACT

This group of structural instant adhesives is formulated to contribute toughness and impact resistance. Maximum impact values attainable (15-25 ft-lbs/in²). Also recommended for bonding plastic and rubber together. Works well on aluminum and other metal surfaces.

		Size	Part #
HI-50	FAST CURE: General purpose • 50 cP viscosity* allows up to .004" gap fill capability • Meets MIL-A-46050C, Type II, Class 1	20 gram	05010
		1 lb.	05013
HI-150	MEDIUM CURE: Broad use adhesive • 150 cP viscosity* allows up to .005" gap fill capability • Meets MIL-A-46050C, Type II, Class 2	20 gram	05020
		1 lb.	05023
HI-500	SLOW CURE: Allows work piece alignment • 500 cP viscosity* allows up to .008" gap fill capability • Meets MIL-A 46050C, Type II, Class 3	20 gram	05110
		1 lb.	05111

HC - HIGH CLARITY

An isopropyl formulation that generates 75% less adhesive vapor during cure, resulting in dramatically reduced chlorosis (i.e., formation of white deposition of low molecular weight) in applications where cosmetics are important. High clarity grades have better moisture resistance than ethyl type cyanoacrylates.

HC-150	MEDIUM CURE: Broad use adhesive • 150 cP viscosity* allows up to .006" gap fill capability	20 gram	03040
		1 lb.	03043

HP - HIGH PEEL/HIGH PERFORMANCE

This chemistry exhibits characteristics unique to instant adhesives; high T-peel strength, impact strength (impact resistance), thermal shock resistance, excellent performance for metal to metal structural bonds.

HP-10	FAST CURE: Able to penetrate between parts • 10 cP viscosity* allows up to .002" gap fill capability • Meets MIL-A-46050C, Type II, Class 1	1 lb.	04213
HP-500	SLOW CURE: Allows part positioning time • 500 cP viscosity* allows up to .012" gap fill capability • Meets MIL-A 46050C, Type II, Class 3	20 gram	04240
		1 lb.	04243
HP-3000	VERY SLOW CURE: Allows work piece alignment • 3000 cP viscosity* allows up to .015" gap fill capability • Meets MIL-A 46050C, Type II, Class 3	20 gram	04260
		1 lb.	04263
HP-5000	SLOWEST CURE TIME: Large gap fill • 5000 cP viscosity* allows up to .018" gap fill capability • Meets MIL-A-46050C, Type II, Class 4	20 gram	04280
		1 lb.	04283

NOTE: Shelf life of all HI, HC and HP adhesives is one year stored at 70°F. Optimum shelf life obtained when stored unopened at 40°F.

* Nominal Viscosity – refer to physical property chart for viscosity range.

PHYSICAL PROPERTY CHART • Advanced Grade Cyanoacrylates

	Clear Liquid • Grade	HI-50	HI-150	HI-500	HC-150	HP-10	HP-500	HP-3000	HP-5000	
Liquid State	CHEMICAL TYPE	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	PROPYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	ETHYL HYBRID	
	Viscosity Range, cP	30-70	100-200	400-600	100-200	5-15	400-600	2500-4500	4000-6000	
	Specific Gravity (25°C)	1.07	1.07	1.09	1.02	1.05	1.05	1.05	1.05	
	Flashpoint (COC °F)	185	185	185	190	185	186	187	187	
	Vapor Pressure (@ 70°C, mmHg)	< 2	< 2	< 2	< 2	< 2	< 2	< 2	< 2	
	Soluble in:	Pacer X-8 Debonder, Acetone, Nitromethane								
Cured State	Melting Point (°F/°C)	366/186	367/186	368/187	343/173	366/186	361/183	356/180	356/180	
	Softening Point (°F/°C)	309/154	309/154	315/157	290/143	310/154	300/149	296/147	296/147	
	Service Temperature Range	(-65°F to 200°F) (-54°C to 93°C)					(-55°F to 250°F)		(-48°C to 121°C)	
	Refractive Index (n _{20°C/D} ± .03)	1.45	1.45	1.45	1.45	1.45	1.408	1.442	1.444	
	Hardness – ROCKWELL	M75	M73	M75	M71	M73	M60	M50	M50	
	Gap Filled, Typical, Inches	.004	.005	.008	.006	.002	.012	.015	.018	
	Outgassing @ 10 ⁻⁶ mmHg (72°F)	0	0	0	0	0	0	0	0	
	Elongation (%)	< 2	< 2	< 2	< 2	< 3	7-10	10-15	10-15	
	Tensile Shear Strength, steel/steel, ASTM-D1002 (lbs/in ²)	2600-3000	2600-3000	2600-3000	2200-2600	2800-3000	2800-3000	2800-3000	2800-3000	
	Impact Strength, Steel/Steel, ASTM 950 (ft.-lbs/in ²)	20-30	20-30	20-30	10-14	5-10	12-25	15-20	20-25	
	T-peel Strength, Steel/Steel, ASTM D-1876-83 (lbs/in)	-	-	-	-	10-12	10-15	13-16	15-18	
	Soluble in:	Pacer X-8 Debonder, Acetone, Nitromethane								

NOTE: Values are typical and should not be used as product specification.

ISL-LOK™ Series • Threadlocking Compounds



Pacer ISL™ Threadlocking Compounds are patented technology, structural cyanoacrylates that offer the strength and durability of anaerobics, and the cure times of an instant adhesive. This chemistry is NOT a metal reactive system. Unlike anaerobics, these materials will perform well on platings, stainless steel, and even plastic fasteners without the use of surface activators. • Use on any type of components, including metal, plated parts, plastic, wood, etc., for thread locking, sealing, joining, fastening and retaining. • Will not craze most plastics. • Non-surface sensitive. • Can be pre-applied. • Can be handled in 1-5 minutes • 80% of full strength in 15-30 minutes. **NOTE:** ISL® compounds are not recommended for applications involving constant immersion in water or constant exposure to temperatures over 180°F.

			Size	Part #
ISL-22		LOW STRENGTH: Removable for locking/sealing small screws under 1/4" in diameter. May be disassembled with hand tools. • Meets MIL-A-46050C, Type II, Class 2*	50 ml	06035
			1 lb.	06033
ISL-42		MEDIUM STRENGTH: Removable general purpose adhesive, for locking/sealing fasteners over 1/4" in diameter. May be disassembled with hand tools. • Meets MIL-A-46050C, Type II, Class 3*	10 ml	06054
			50 ml	06055
			1 lb.	06053
ISL-71		HIGH STRENGTH: Permanent, for locking/sealing fasteners up to 1" in diameter. Disassembly difficult. • Meets MIL-A-46050C, Type II, Class 2*	10 ml	06014
			50 ml	06015
			1 lb.	06013
ISL-90		HIGH STRENGTH: Penetrating permanent, for locking/sealing preassembled fasteners. Also used to seal weld and casting porosity. Disassembly difficult. • Meets MIL-A-46050C, Type II, Class 1*	10 ml	06024
			50 ml	06025
			1 lb.	06023

*NOTE: Mil Spec MIL-A-46050C for Section 3.2.1 compliance, the ISL products will be supplied colorless. Requests for dyed product should qualify this deviation from the specification.

NOTE: Shelf life of all ISL adhesives is one year stored at 70°F. Optimum shelf life obtained when stored unopened at 40°F.

PHYSICAL PROPERTY CHART - ISL-LOK™ Threadlocking Compounds

	Grade	ISL-22	ISL-42	ISL-71	ISL-90
Liquid State	Color	PURPLE	BLUE	RED	GREEN
	Generic Type: (Modified cyanoacrylates)	LOW STRENGTH	MEDIUM STRENGTH	HIGH STRENGTH (<1" FASTENERS)	WICKING
	Viscosity (cP)	85-160	1500-2000	130-250	10-25
	Fixture Time (Min.)	1-5	1-5	1-5	1-5
	Working time (Min.)	30	30	30	15
	Full Cure (hrs.)	24	24	24	24
	Gap Filled (inch)	.004	.008	.005	.002
	Specific Gravity (25°C)	1.03	1.06	1.05	1.05
	Flash Point (COC °F)	178	181	183	183
	Corrosivity (MIL-S-22473D)	NONE	NONE	NONE	NONE
	Shelf Life (R.T.)	1 YR. MIN.	1 YR. MIN.	1 YR. MIN.	1 YR. MIN.
	Soluble in:	Pacer X-8 Debonder™ Acetone, Nitromethane			
	Cured State	Locking Torque (in-lbs) Breakaway	39-91	58-151	116-180
Prevail		18-35	30-83	144-217	138-161
Tensile Shear Strength steel/steel, ASTM-D1002 (lb/in²)		700-900	1700-1900	2400-2600	1900-2100
Service Temperature		(-65 to 205°F) (-54 to 96°C)			
Linear Expansion (mm/°c)		10X10 ⁵	15X10 ⁵	8X10 ⁵	13X10 ⁵
Hardness: Rockwell		M60	M67	M69	M68
Decomposition Temperature (°F)		405	405	405	405
Dielectric Constant @ 1MHz		4.40	4.30	4.04	4.17
Soluble in:		Pacer X-8 Debonder™ Acetone, Nitromethane			

NOTE: Values are typical and should not be used as product specification.

INDUSTRIAL

Anaerobic Threadlocking • ANA-LOK™ Series Sealing & Retaining Compounds



Pacer ANA-LOK™ Anaerobic Compounds are formulated for use in threadlocking, sealing, joining, fastening and retaining of metal components. Unlike conventional anaerobics, ANA-LOK™ grades are non-surface sensitive, and do not require a primer to cure. Inventory costs are reduced by eliminating the need for mechanical locking devices such as plastic inserts, lock washers, set-screws, locknuts, and cotter pins. Machining and assembly costs are also reduced. The gap filling capability of the adhesives allows for greater tolerances between parts: no need to machine keyways, or drill holes for cotter pins prior to assembly. Once the parts are mated, they form a unitized assembly that resists vibration. In addition, the mated parts are sealed against attack from corrosion, internal rust, seizure, solvents, lubricants, gases and other chemicals. Use on METAL components only, for threadlocking, sealing, joining, fastening and retaining. • Meets MIL-S-46163A • ANA-LOK™ 42,77 and 90 also meets MIL-S-22473E.

			Size	Part #
ANL-22		LOW STRENGTH: Removable for locking/sealing small screws under 1/4" in diameter. May be disassembled with hand tools. • Meets MIL-S-46163A, Type II, Grade M	10ml	06110
			50 ml	06112
			250 ml	06111
			1 liter	06113
ANL-42		MEDIUM STRENGTH: Removable general purpose adhesive, for locking/sealing fasteners over 1/4" in diameter. May be disassembled with hand tools. • Meets MIL-S-46163A, Type II, Grade N	10ml	06120
			50 ml	06122
			250 ml	06121
			1 liter	06123
ANL-71		HIGH STRENGTH: Permanent, for locking/sealing fasteners up to 1" in diameter. Disassembly difficult. • Meets MIL-S-46163A, Type I, Grade K	10ml	06140
			50 ml	06142
			250 ml	06141
			1 liter	06143
ANL-77		HIGH STRENGTH: Permanent, for locking/sealing large bolts and studs for fasteners 1" in diameter and larger. Disassembly difficult; heat required. • Meets MIL-S-46163A, Type I, Grade L	10ml	06150
			50 ml	06152
			250 ml	06151
			1 liter	06153
ANL-90		HIGH STRENGTH: Penetrating permanent, for locking/sealing preassembled fasteners. Also used to seal weld and casting porosity. Disassembly difficult. • Meets MIL-S-46163A, Type III, Grade R	50 ml	06162
			250 ml	06161
			1 liter	06163
ANL-RC		HIGH STRENGTH: General purpose, retaining compound for retaining bearings, bushings, collars, keys and splines. Has .005" gap filling capability allows slip fit instead of press fit parts.	10ml	06170
			50 ml	06172
			250 ml	06171
ANL-RC/ HT		HIGH TEMPERATURE: Retaining compound for retaining bearings, bushings, collars, gears, and other cylindrical parts. Fills gaps to .015" and resists temperatures up to 450°F (232°C)	10ml	06180
			50 ml	06182
			250 ml	06181
			1 liter	06183

NOTE: Shelf life of all ANL adhesives is one year stored at 70°F. Optimum shelf life obtained when stored unopened at 40°F.

* Typical values based on 3/16"-16 phosphate steel bolts.

PHYSICAL PROPERTY CHART • ANL-LOK™ Threadlocking Compounds

	Grade	ANL-22	ANL-42	ANL-71	ANL-77	ANL-90	ANL-RC	ANL-RC/HT	
Liquid State	Generic Type: (Anaerobic)	LOW STRENGTH	MEDIUM	HIGH STRENGTH (<1" FASTENERS)	HIGH STRENGTH (>1" FASTENERS)	WICKING GRADE	RETAINING COMPOUND	RETAINING COMPOUND	
	Color	PURPLE	STRENGTH	RED	RED	GREEN	GREEN	GREEN	
	Viscosity (cP) ASTM 1084, 1824	900-5000	BLUE	450-550	6000-8000	10-25	100-300	800-1100	
	Fixture Time (Min.)	5-15	900-5000	5-15	5-15	1-10	5-25	10-15	
	Working time (hrs.)	2	5-15	2	2	1	2	2	
	Full Cure (hrs.)	24	2	24	24	24	24	24	
	Gap Filled (inch)	.010	24	.008	.010	.002	.005	.015	
	Specific Gravity	1.07	.010	1.10	1.11	1.08	1.08	1.12	
	Flash Point (°F, TOC)	219	1.11	219	219	219	219	212	
	Corrosivity (MIL-S-22473D)	NONE	219	NONE	NONE	NONE	NONE	NONE	
	Toxicity	LOW	NONE	LOW	LOW	LOW	LOW	LOW	
	Shelf Life (R.T.)	1 YR. MIN.	LOW	1 YR. MIN.	1 YR. MIN.	1 YR. MIN.	1 YR. MIN.	1 YR. MIN.	
	Soluble in:	Pacer X-8 Debonder,™ Acetone, Nitromethane							
Cured State	Locking Torque Breakaway (in-lbs) Prevail*	25-70	50-105	175-260	220-305	50-105	300-480	87-175	
	Shear Strength (lb/in ²)	15-60	60-130	215-305	170-260	170-350	220-440	174-347	
	Service Temperature	570-990	1140-2130	2840-4970	2840-4970	2130-3550	4260-5680	2500-3700	
	Linear Expansion (mm/°C)	(-65 to 205°F) (-54 to 96°C)							
	Hardness: Rockwell	15X10 ⁵	15X10 ⁵	8X10 ⁵	8X10 ⁵	7.3X10 ⁵	4.6X10 ⁵	2.41X10 ⁵	
	Decomposition Temperature (°F)	R25	R65	M110	M110	M89	M108	M112	
	Soluble in:	410	432	486	504	437	496	548	
		Pacer X-8 Debonder,™ Acetone, Nitromethane							

NOTE: Values are typical and should not be used as product specification.

Maintenance & Repair



RETAINING COMPOUNDS • ANL-RC

- High strength, general purpose retaining compound.
- For use on bearings, bushings, gears, and other cylindrical parts.



RETAINING COMPOUNDS • ANL-RC/HT

- High temperature retaining compound.
- For use on retaining bearings, bushings, collars, gears and other cylindrical parts.



HIGH PERFORMANCE PIPE SEALANT PLUS TEFLON®

- Seals instantly.
- Excellent chemical and temperature resistance.
- Prevents vibration loosening.
- Easy disassembly.



HYDRAULIC AND PNEUMATIC SEALANT™

- Works on all metal fittings.
- Compatible with gases, hydraulic fluids and solvents.
- Prevents vibration loosening while allowing easy disassembly.



HIGH PERFORMANCE UNIVERSAL FLANGE SEALANT™

- Excellent chemical and temperature resistance.
- Fills gaps to .025".
- Eliminates gasket set/wear.
- Reduces gasket inventory.

PRODUCT	SIZE	PART #	TEMP. RANGE	VISCOSITY	GAP FILL	CURE SPEED		TYPICAL APPLICATION
						PRIMED	UNPRIMED	
ANL-RC Retaining Compound	10 ml 50 ml 250 ml	06170 06172 06171	-65 to 300°F -54 to 149°C	LOW	.005"	(1-5) Minutes	5-25 Minutes	General purpose retaining of bearings, bushings, cylindrical parts.
ANL-RC/HT Retaining Compound	10 ml 50 ml 250 ml 1 liter	06180 06182 06181 06183	-65 to 450°F -54 to 232°C	HIGH	.015"	(1-5) Minutes	5-25 Minutes	High temperature applications, bearings, bushings, collars, gears and other cylindrical parts.
Pipe Sealant Plus Teflon®	50ml	08000	-65 to 300°F -54 to 149°C	HIGH	.015"	(15-30) Minutes	2-7 Hours	General purpose. Resists chemicals. Instant sealing.
Hydraulic/Pneumatic Sealant	50ml	08020	-65 to 300°F -54 to 149°C	MEDIUM	.015"	(5-15) Minutes	30-60 Minutes	Pipe threads, sealing, air, oil, gas to working pressure of fittings.
Universal Flange Sealant	50ml	08030	-65 to 300°F -54 to 149°C	HIGH	.025"	(15-30) Minutes	2-4 Hours	For use as a gasket or gasket dressing. Fills all imperfections.

NOTE: Values are typical and should not be used as product specification. • Teflon® is a registered trademark of Dupont

PREMIUM GRADE ACCELERATOR

Fastest acting grade cures and sets cyanoacrylate adhesive quickly. Use premium grade accelerator where you need the fastest cure possible. If using accelerator to speed the setting time of an adhesive, simply spray accelerator on one surface, apply a cyanoacrylate adhesive to the other side and mate the two surfaces. Accelerator can also be used in post application to cure fillets or small potting applications. All Pacer Accelerators are Freon™ free.

STANDARD GRADE ACCELERATOR

Use Standard Grade accelerator when the premium grade is too fast for your application. See above for application techniques.

X-8 DEBONDER™

Excellent for the removal of cyanoacrylate adhesive. Simply allow 20-30 seconds to soften and wipe away with a cloth or brush. X-8 Debonder is safe on most plastics, metals, fabrics, clothing dyes and work surfaces. Suggest small trial area prior to general use.

PHYSICAL PROPERTIES CHART

	PREMIUM	STANDARD
Color	Amber	Amber
Base	Acetone or Alcohol	Acetone or Alcohol
Viscosity	5 cP	5 cP
Flash Point	Flammable	Flammable
Specific Gravity	1.26	1.26
Toxicity (TLV)	350 ppm	350 ppm
On Part Life	5 min	5 min

INDUSTRIAL

Maintenance & Repair • Gasketing



Blue RTV Silicone Instant Gasket

- Low Volatile Formula - Sensor Safe •

Replaces most pre-cut gaskets. Will not foul computer sensors. May also be used to coat gaskets for reliable seal. Resists high pressure and temperatures from -80°F to 600°F (-62°C to 315°C). Resists oil, transmission fluid, water and antifreeze.

For use on water pumps, valve covers, oil pans, rear end housings, transmission pans, timing chain covers and thermostat housings.

80006 3.0 oz. Carded Tube 12/Case



Black RTV Silicone Instant Gasket

- Low Volatile Formula - Sensor Safe •

Forms gaskets in-place instantly. Replaces cork, paper, asbestos and felt pre-cut gaskets. Dries tough and flexible. Resists high pressure and temperatures from -80°F to 600°F (-62°C to 315°C). Resists oil, anti-freeze, grease and transmission fluid.

For use on oil pans, rear end housings, water pumps, valve covers, thermostat housings, electrical connections and wires. Seals windshields, sunroofs, doors, lights and hose connections.

80046 3.0 oz. Carded Tube 12/Case
80047 11.1 oz. Cartridge 12/Case
80049 7.25 oz. Power Can 6/Case



Red Hi-Temp RTV Silicone Instant Gasket

- Low Volatile Formula - Sensor Safe •

Specially formulated for high temperature applications to 700°F (370°C). Safe for all car models. Will not foul computer sensors. Resists high pressures to 5,000 psi. Resists oil, antifreeze, grease and transmission fluids. Dries flexible. Resists shrinking and cracking.

For use on exhaust manifolds, timing chain covers and most hi-temp applications.

80726 3.0 oz. Carded Tube 12/Case
80728 11.1 oz. Cartridge 12/Case
80729 7.25 oz. Power Can 6/Case



Aluminum RTV Silicone Instant Gasket

- Specially Formulated For Use On Imported Car Engines
- Low Volatile Formula - Sensor Safe •

Replaces most pre-cut gaskets by forming gaskets in-place. Will not foul computer sensors. May also be used as a gasket dressing. Resists high pressure and temperatures from -80°F to 600°F (-62°C to 315°C). Resists oil, antifreeze, grease and transmission fluids.

For use on water pumps, valve covers, oil pans, rear end housings, transmission pans, timing chain covers, thermostat housings and more.

79006 3.0 oz. Carded Tube 12/Case



Blue XS™ Advanced RTV Silicone Instant Gasket

Low-odor, non-corrosive, low volatile formula designed to replace or coat pre-cut gaskets on high performance engines manufactured after 1980. Will not foul oxygen sensors. Resists temperatures from -80°F to 600°F (-62°C to 315°C). Resists oil, transmission fluid, grease, water and antifreeze. Good adhesion to oily surfaces.

For use on oil pans, transmission housings, intake manifolds, cam shaft covers, valve covers and timing chain covers.

80003 3.0 oz. Carded Tube 12/Case



Copper XS™ Hi-Temp RTV Silicone Instant Gasket

Low-odor, non-corrosive, low volatile formula designed to replace or coat pre-cut gaskets on high performance, turbo-charged and 4-cylinder engines. Will not foul oxygen sensors. Resists temperatures from -80°F to 700°F (-62°C to 370°C). Resists oil, transmission fluid, grease, water and antifreeze. Good adhesion to oily surfaces.

For use on exhaust manifolds, oil pans, valve covers, intake manifold end seals, thermostat housings and water pumps.

78002 3.0 oz. Carded Tube 12/Case

Gasketing, Sealants, Cleaning, Cold Weld • Maintenance & Repairs



Pacer High Performance Universal Flange Sealant

A high performance gasketing compound cures only after parts are assembled. Can be used to coat gaskets for a reliable, high pressure seal. Resists automotive fluids including gasoline, water, oil, grease, anti-freeze and transmission fluids.

For use on water pumps, thermostat housings, transaxle casings, intake manifolds, gear boxes and transmission housings.

FG08030 50 mL (1.69 fl. oz.) Tube 10/Case



Pipe Sealant Plus Teflon®

Low strength for easy disassembly. Non migrating smooth paste resists temperatures from -65°F to 300°F (-54°C to 150°C). Lubricates threads to prevent galling; prevents corrosion. Resistant to shop solvents, water, gasoline, diesel fuels, oil and antifreeze.

For use on fuel fittings, brake and power steering fittings, oil and coolant lines, hydraulic lines and vacuum hoses.

FG08000 50 mL Tube 10/Case

*Teflon is a registered trademark of Dupont



Anti-Seize Lubricant

Environmentally and user safe formula. Meets or exceeds requirements of MIL-907E. Withstands temperatures from 0°F to 1800°F (5°C to 980°C). Prevents galling, seizing and corrosion. Contains no metallic particles. Lubricates assemblies exposed to heavy contact pressure. Resists water, ethanol, isopropanol, acetone and MEK.

For use on head bolts, manifold studs, spark plug threads, battery terminals, axle shafts, U bolts, lug nuts and wheel bearings.

33008 8.0 oz. Brush Top Bottle 6/Case



Gasket Remover

Removes all types of gasketing sealants and gasket makers. Softens burned-on pre-cut gaskets for easy removal. Minimizes sanding and scraping. Prevents damage to flanges.

For use on gasket and sealant residue from sealing surfaces.

80804 16.0 oz. Aerosol Can 12/Case



Brake & Parts Cleaner

Effective non-ozone depleting formula that works! Cleans parts and dissolves grease. Clean drying formula leaves no residue.

For cleaning rotors, drums, calipers, brake shoes and linings, springs, wheel cylinders and engine parts.

80990 20 oz. Aerosol Can 12/Case



Pro Weld™ Cold Weld Compound

Eliminates welding and brazing. Can be drilled, tapped, machined, sanded or filed. Sets in 15 minutes; fully cures in 12 hours. Resistant to gasoline, diesel fuels, motor oil, transmission fluid, hydraulic oil, water and antifreeze. Resists high pressure and temperatures to 300°F (150°C).

For repairing cracked transmission and rear end casings, cracked manifolds, radiator seams, casting defects and keyways.

64600 2 x 1.0 oz. Carded Tubes 12/Case



Pro Weld™ Quick Cold Weld Compound

Quick set epoxy steel fully cures in 4 minutes to resist temperatures up to 300°F (150°C). Can be drilled, tapped, machined, filed, or sanded. Resistant to gasoline, diesel fuel, oil, water and antifreeze.

For repairing cracked transmission and rear end casings, manifolds, radiator seams, casting defects and keyways.

64605 2 x 1.0 oz. Carded Tubes 12/Case

INDUSTRIAL

Industrial Epoxies • Anchor-Tite™ Epoxy Systems



Automotive/RV Adhesive Syringe

Anchor-Tite™ Automotive/RV Epoxy System Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. An advanced industrial strength, 2-part system that is strong and flexible when cured. Material works under or in the presence of water and remains waterproof. Extended working time (1 hr.) to position parts. Set time 3-4 hours. Formulated to repair, seal and adhere to numerous materials such as: Aluminum, Plastics, Brass, Chrome, Fabric, Leather, Rubber, Steel, Vinyl, Wood, Pumps, and Equipment.

Final cured color: Black
15204 1.0 oz. Syringe Applicator 48/Case



Household Adhesive Syringe

Anchor-Tite™ Household Epoxy System Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. An advanced industrial strength, 2-part system that is strong and flexible when cured. Material works under or in the presence of water and remains waterproof. Extended working time (1 hr.) to position parts. Set time 3-4 hours. Formulated to repair, seal and adhere to numerous materials such as: Ceramic, Fabric, Leather, Countertops, Linoleum, Metal, Plastic, Rubber, Vinyl, Wood, Shoes, Furniture, Tile, Tools, and Appliances.

Final cured color: Off-white
15205 1.0 oz. Syringe Applicator 48/Case



Marine Adhesive Syringe

Anchor-Tite™ Marine Epoxy System Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. An advanced industrial strength, 2-part system that is strong and flexible when cured. Material works under or in the presence of water and remains waterproof. Extended working time (1 hr.) to position parts. Set time 3-4 hours. Formulated to repair, seal and adhere to numerous materials such as: Boats, Skis, Wake Boards, Hoses, Canvas, Fabric, Vinyl, Fiberglass, Nylon, Plastic, Wood, Rope, and Neoprene.

Final cured color: Aqua
15206 1.0 oz. Syringe Applicator 48/Case



Pool/Spa Adhesive Syringe

Anchor-Tite™ Pool & Spa Epoxy System Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. An advanced industrial strength, 2-part system that is strong and flexible when cured. Material works under or in the presence of water and remains waterproof. Extended working time (1 hr.) to position parts. Set time 3-4 hours. Formulated to repair, seal and adhere to numerous materials such as: PVC Pipe, Skimmers, Collars, Grates, Tile, Metal, Masonry, Fittings, Valves, Tanks, Pumps, Patio Furniture, and Equipment.

Final cured color: Blue
15207 1.0 oz. Syringe Applicator 48/Case



Plumbing/Landscape Adhesive Syringe

Anchor-Tite™ Landscape & Plumbing Epoxy System Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. An advanced industrial strength, 2-part system that is strong and flexible when cured. Material works under or in the presence of water and remains waterproof. Extended working time (1 hr.) to position parts. Set time 3-4 hours. Formulated to repair, seal and adhere to numerous materials such as: PVC, ABS, Aluminum, Brass, Copper, Hoses, Ceramics, Wood, Fiberglass, Pipes, Aquariums, Sinks, Tubs, Masonry, Rocks, Fixtures, Statues, Ponds, Pottery, Lighting, Planters, Canvas, Tarps, and Gutters.

Final cured color: Green
15208 1.0 oz. Syringe Applicator 48/Case



Sport/Field Adhesive Syringe

Anchor-Tite™ Sports & Field Epoxy System Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. An advanced industrial strength, 2-part system that is strong and flexible when cured. Material works under or in the presence of water and remains waterproof. Extended working time (1 hr.) to position parts. Set time 3-4 hours. Formulated to repair, seal and adhere to numerous materials such as: Decoys, Tackle, Canvas, Campers, Trailers, Vinyl, Sports Equipment, Metal, PVC, Gun Stock, Wader Boots, Surf Boards, Wake Boards, Skis, Wood, Fiberglass, Leather, and Neoprene.

Final cured color: Off-white
15209 1.0 oz. Syringe Applicator 48/Case



Permanent Adhesive Patch

Anchor-Tite™ Patch is a very easy-to-use UV or sunlight activated repair patch. It is fiberglass-reinforced and creates long-lasting repairs. Can be cut to size and molded to a desired application shape. Will not rot or rust and can be drilled or tapped after cure. Accepts paint in 1 hour and can be sanded to a smooth finish. Perfect for making watertight, durable repairs on water tanks, roofs, flashing air conditioning units, PVC pipes, personal watercraft, boats, engine parts, fiberglass metal wood, concrete and more.

15300 Net Wt. 1.15 oz. (33g)
Size: 6 inches X 3 inches (150 X 75mm)



Industrial Epoxies • Epoxies



90 Second Set Epoxy Adhesive

90 Second Set Epoxy Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. A 2-part system that is strong when cured. 90 seconds positioning time for parts and can be handled in 10 minutes. Formulated to repair, seal and adhere to numerous materials.

Final cured color: Light Yellow
 SY-IN 1.0 oz. Syringe Applicator 48/Case



Quick Setting Epoxy Adhesive

Quick Setting Epoxy Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. A 2-part system that is strong when cured. 4-6 minutes positioning time for parts and can be handled in 30 minutes. Formulated to repair, seal and adhere to numerous materials.

Final cured color: Light Yellow
 SY-QS 1.0 oz. Syringe Applicator 48/Case
 TQ-S 2 X 1.0 oz. Carded tubes 48/Case
 15275 Single use pouches 48/Case
 07925 1 Gallon 1/Case



Super Strength Epoxy Adhesive

Super Strength Epoxy Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. A 2-part system that is strong when cured. 30 minutes positioning time for parts and can be handled in 7 hours. Formulated to repair, seal and adhere to numerous materials.

Final cured color: Light Yellow
 SY-SS 1.0 oz. Syringe Applicator 48/Case
 07935 1 Gallon 1/Case



Quick Setting Metal Epoxy Adhesive

Quick Setting Metal Epoxy Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. A 2-part system that is strong when cured. 4-6 minutes positioning time for parts and can be handled in 30 minutes. Can be drilled, tapped or filed when cured. Formulated to repair, seal and adhere to numerous materials.

Final cured color: Light Gray
 15212 1.0 oz. Syringe Applicator 48/Case



Plastic Fusion[®]

Plastic Fusion Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. A 2-part methyl methacrylate system that is strong, waterproof, and flexible when cured. 8 minutes positioning time for parts and can be handled in 1 hour. Formulated to repair, seal and adhere to numerous materials.

Final cured color: Light Yellow
 15277 1.0 oz. Syringe Applicator 48/Case



Gel Epoxy Adhesive

Gel Epoxy Adhesive automatically dispenses into equal parts with one push. Ready to mix and apply. A 2-part system that is strong when cured. 4-6 minutes positioning time for parts and can be handled in 1 hour. Material and substrate parts can be color matched by adding small amounts of colorant (i.e. latex, acrylic or oil paints or stains). Formulated to repair, seal and adhere to numerous materials.

Final cured color: Cream
 15213 1.0 oz. Syringe Applicator 48/Case

INDUSTRIAL

Part Number List • Industrial Products

***Special Order** **5gm.** **20gm.**
Minimum Run Required **2500** **500**

STANDARD GRADE SERIES

GRADE	DESCRIPTION	5 GR.	20 GR.	1 LB.
E-5	Ultra-low viscosity (2-10 cP); gap fill .002"	01015	01010	01013
E-40	Low viscosity (30-70cP); gap fill .003"	01025	01020	01023
E-100	Medium viscosity (80-120 cP); gap fill .004"	01035	01030	01033
E-1500	High viscosity (1300-1700 cP); gap fill .010"	*	01050	01053
E-2500	High viscosity (2200-2700 cP); gap fill .015"	*	01060	01063

ADVANCED TECHNOLOGY SERIES

GRADE	DESCRIPTION	5 GR.	20 GR.	1 LB.
HC-150	High clarity; medium viscosity (100-200 cP) gap fill .007"	*	03040	03043
HI-50	High impact; low viscosity (30-70 cP) gap fill .004"	*	05010	05013
HI-150	High impact; medium viscosity (100-200 cP) gap fill .004"	*	05020	05023
HI-500	High impact; high viscosity (400-600 cP) gap fill .010"	*	05110	05111
HP-10	High T-peel, impact, thermal shock resist. (5-15 cP) gap .002"	*	*	04213
HP-500	High T-peel, impact, thermal shock resistance (400-600 cP) gap fill .012"	*	04240	04243
HP-3000	High T-peel, impact, thermal shock resistance (2500-4500 cP) gap fill .015"	*	04260	04263
HP-5000	High T-peel, impact, thermal shock resistance (4000-6000 cP) gap fill .018"	*	04280	04283
MR-10	High moisture & humidity resistance (5-15 cP) gap fill .002"	*	FG04440	FG04443
MR-290	High moisture & humidity resistance (250-350 cP) gap fill .012"	FG04455	FG04450	FG04453
MR-3000	High moisture & humidity resistance (2500-4500 cP) gap fill .015"	*	FG04460	FG4463
NØ-150	No odor - No vapors (100-200cP) gap fill .006"	*	04120	04123
PX-5	Extended performance, plastics. Ultra low viscosity (2-10 cP); gap fill .002"	*	05070	05073
PX-50	Extended performance, plastics. Low viscosity (30-70 cP); gap fill .004"	05085	05080	05083
PX-500	Extended performance, plastics. High viscosity (400-600 cP); gap fill .012"	*	05090	05093
RX-5	Penetrant type, instant cure (2-10cP); gap fill .002"	04055	04050	04053
RX-50	Low viscosity (30-70 cP); gap fill .003"	04015	04010	04013
RX-100	Medium viscosity (80-120 cP); gap fill .004"	04025	04020	04023
RX-500	High viscosity, allows alignment, gap filler (400-600 cP); gap fill .015"	*	04040	04043
RX-700	Slow setting, high viscosity, (600-800 cP); gap fill .018"	*	04060	04063
RX-GEL	Slowest setting (45,000-85,000 cP); gap fill .025"	04075	04070	200 ml 04072
TX-5	High temp.; low viscosity (2-10 cP) gap fill .002"	*	05101	05102
TX-100	High temp.; medium viscosity (80-120 cP) gap fill .004"	*	05511	05512
TX-750	High temp.; high viscosity (650-850 cP) gap fill .012"	*	04504	04503

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Industrial Products - Part Number List

ACCELERATORS

DESCRIPTION	2 oz.	1 gal.
Standard Accelerator ACETONE	09431	09438
Premium Accelerator ACETONE	09421	09428
Premium Accelerator ALCOHOL	09531	09538

DISPENSING ACCESSORIES

DESCRIPTION	NO.
Sprayer kit (1 ea. - Bottle, Sprayer, Brush Cap)	07200
Bottle Kit (10 Bottles, Nozzles, Caps, Tips)	07300
X-TEND™ Dispensing tips (10 pcs.)	07400

THREADLOCKING COMPOUNDS

ANA-LOK™ (for metal only)		10 ML.	50 ML.	250 ML.	1 LTR.
ANL-22	Low strength, Purple (900-5000 cP); Removable	06110	06112	06111	06113
ANL-42	Medium strength, Blue (900-5000 cP); Removable	06120	06122	06121	06123
ANL-71	High strength, fine threads, Red (450-550 cP); Permanent	06140	06142	06141	06143
ANL-77	High strength, coarse threads Red (6000-8000 cP); Permanent	06150	06152	06151	06153
ANL-90	Penetrant-wicking, high strength, Green (10-25cP); Permanent	*	06162	06161	06163
ANL-RC	High strength, general purpose retaining compound for bearings, bushings, collars, keys and splines. (100-300 cP)	06170	06172	06171	*
ANL-RC/HT	High temperature retaining compound for bearings, bushings, collars, keys and splines. (800-1100 cP)	06180	06182	06181	06183

ISL-LOL™ (For metal, plastic, etc.)		10 ML.	50 ML.	1 LB.
ISL-22	Low strength, Purple (85-160 cP). Removable	06034	06035	06033
ISL-42	Medium strength, Blue (1500-2000 cP). Removable	06054	06055	06053
ISL-71	High strength, fine threads, Red (130-250 cP). Permanent	06014	06015	06013
ISL-90	Penetrant-wicking, high strength, Green (10-25 cP). Permanent	06024	06025	06023

SEALANTS

DESCRIPTION	50 ML.
Hydraulic and Pneumatic Sealant	08020
Universal Flange Sealant	08030
Pipe Sealant with Teflon®	08000

SPECIALTY CHEMICALS

DESCRIPTION	SIZE.	NO.
Anti-Seize Lubricant	8 oz. Btl.	33008
Cleaning Solvent - Brake and Parts Cleaner General purpose degreaser/cleaner	13 oz.	80990
X-8 Debonder	1 oz.	06100
	1 gal.	06101
Polypropylene Primer	1 gal.	09708

MAINTENANCE & REPAIRS

Blue RTV Silicone Instant Gasket	80006
Black RTV Silicone Instant Gasket	80046
Red Hi-Temp RTV Silicone Instant Gasket	80726
Aluminum RTV Silicone Instant Gasket	79006
Blue XS™ Advanced RTV Silicone Instant Gasket	80003
Copper XS™ Hi-Temp RTV Silicone Instant Gasket	78002
High Performance Universal Flange Sealant	FG08030
Pipe Sealant Plus Teflon®	FG08000
Anti-Seize Lubricant	33008
Gasket Remover	80804
Brake and Parts Cleaner	80990
Pro Weld™ Cold Weld Compound	64600
Pro Weld™ Quick Cold Weld Compound	64605

EPOXIES

ANCHOR-TITE™ Epoxy Systems	PART #
Automotive/RV	15204
Household	15205
Marine	15206
Pool/Spa	15207
Plumbing/Landscape	15208
Sports/Field	15209
Patch	15300

Epoxy Systems	SIZE	PART #
Quick Setting	1oz. syringe	SY-QS
Quick Setting Tubes	2 X 1.0 oz. carded tubes	T-QS
Clean & Simple Epoxy Pouches	(2) single use pouches	15275
	Gal.	07925
Super Strength	1oz. syringe	SY-SS
	Gal.	07935
Metal	1oz. syringe	15212
Plastic Fusion	1oz. syringe	15277
90 Second	1oz. syringe	SY-IN
Epoxy Gel	1oz. syringe	15213

CYANOACRYLATES

PACER	LOCTITE®
E-5	420
E-40	495
E-100	414/404
E-1500	416
E-2500	422
HC-150	460
HI-50	N/A
HI-150	N/A
HI-500	N/A
HP-10	N/A
HP-500	405/380
HP-3000	410
HP-5000	411
PX-5	N/A
PX-50	N/A
PX-500	N/A
RX-5	406
RX-50	N/A
RX-100	401
RX-500	447
RX-700	N/A
RX-50M Gel	454
TX-5	N/A
TX-100	N/A
TX-750	N/A

ANAEROBICS

PACER	LOCTITE®
ANL-22	222
ANL-42	242
ANL-71	271
ANL-77	277
ANL-90	290
ANL-RC	609/680
ANL-RC/HT	620
Pipe Sealant + Teflon	592

KITS / MISCELLANEOUS

PACER	LOCTITE®
ISL-22	N/A
ISL-42	425
ISL-71	N/A
ISL-90	N/A
Premium Accelerator	711
Standard Accelerator	N/A
X-8 Debonder	768
Sprayer Kit	N/A
Bottle Kit	N/A
X-TEND™ Tips	N/A

Conversion Tables • General Information

MULTIPLY	BY	TO OBTAIN
OUNCES	28.3495	GRAMS
GRAMS	0.03527	OUNCES
MILLILITERS	1000	LITERS
POUNDS	14.5833	FLUID OUNCES
FLUID OUNCES	0.0686	POUNDS
FLUID OUNCES	0.02957	LITERS
INCHES	2.54	CENTIMETERS
CENTIGRADE (°C+18)	1.8	°F
FAHRENHEIT (°F-32)	0.556	°C

STANDARD PACKAGE CONVERSIONS

10 ml = .34 fl. oz.
 50 ml = 1.69 fl. oz.
 250 ml = 8.45 fl. oz.
 1000 ml = 34.0 fl. oz.
 5 gms = .17 oz.
 20gms. = .70 oz.
 454 gms = 1 lb.
 °C x 1.8 + 32 = °F e.g. 100°C = 212°F temp.

THREADLOCKER USAGE CHART

SIZE (in.)	10 ml.	50 ml.	250 ml.	1 ltr.	1 lb.
1/4	400	2,000	10,000	40,000	18,920
5/16	220	1,100	5,500	22,000	10,406
3/8	134	670	3,350	13,400	6,338
7/16	105	525	2,625	10,500	4,967
1/2	74	370	1,850	7,400	3,500
9/16	56	280	1,400	5,600	2,649
5/8	45	225	1,125	4,500	2,129
3/4	30	150	750	3,000	1,419

ADHESIVE USAGE - PARTS/LB.

BONDLINE GAP (in.)	BOND AREA (SQ. INCHES)				
	1	2	4	8	20
.015"	1,940	946	475	240	95
.010"	2,955	1,420	710	355	140
.005"	5,915	2,840	1,420	710	285
.002"	14,190	7,100	3,550	1,655	710

PACER[®] TECHNOLOGY	APPLICATION PER 20 GRAM BOTTLE (Free Falling Drops)	APPLICATION PER POUND (Free Falling Drops)
	STANDARD GRADE SERIES	
E-5	770	17,500
E-40	685	15,550
E-100	635	14,415
E-1500	385	8,740
E-2500	270	6,100
ADVANCED TECHNOLOGY SERIES		
RX-5	770	17,500
RX-50	670	15,210
RX-100	635	14,415
RX-500	450	10,250
RX-700	415	9,450
RX-50M GEL	-	-
PX-5	770	17,500
PX-50	670	15,210
PX-500	450	10,250
TX-5	770	17,500
TX-100	635	14,415
TX-750	310	9,400
HC-150	570	13,000
HI-50	412	15,210
HI-150	570	13,000
HI-500	450	10,250
HP-10	745	16,700
HP-500	450	10,250
HP-3000	250	5,700
HP-5000	220	4,980
MR-10	745	16,700
MR-290	510	11,600
MR-3000	250	5,700
NO-150	570	13,000

Represented By:



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