

ThredOn® T-Lok 900 provides a complete two-component epoxy system that includes base resin, catalyst and applicator. It is designed for use on all threaded joints and is especially applicable on drill casings and other pipe where the effective prevention of joint loosening and casing back-off is required.

Typical Characteristics:

Appearance	Liquid	Gray paste
NLGI	-	0-1
Penetration (ASTM D217)	-	330-365
Viscosity	400 cSt at 25°C	-
Specific gravity	1.0	1.4
Density (lb/gal)	8.0	11.7
Flash Point	>200 °F (93 °C)	250 °F (121 °C)
Temperature range	40 °F to 450 °F (4 °C to 230 °C)	
Pot life, 8oz kit	~40 min at 25 °C	
Full cure	2 days at 25 °C	
Break partial cure	2800 psi at 4 hours	
Break full cure	4000 psi	
Friction Factor (API 7A1)	1.2	

Storage

Store in cool dry area in original or equivalent container in accordance with all regulations. Do not expose to extreme heat or flame. Do not expose to extreme cold. Store at 40-104°F (5-40°C), away from strong oxidizers and acids.

Shelf-Life

When stored appropriately, shelf life is two years from date of manufacture.

Application and Use

Thoroughly mix the contents of both components using a putty knife (8 oz kit) or massaging the hinge pack vigorously (2 oz hinge pack). If T-LOK is too stiff for mixing readily, warm to 75°F (24°C). It is essential that the complete contents of both containers be mixed homogeneously.

Apply a thin, but consistent, layer of T-LOK around the first two-thirds (2/3) of the PIN (female) threads only. Do not use grease or thread dope. T-LOK is an efficient lubricant.

Pot life chart is shown to the right. Time periods shown are for length of time after entire contents of both containers have been mixed.

Volume	At 70 °F (21 °C)	At 90 ° - 100 ° F (32 ° -38 ° C)
2 & 8 Oz	45 Min	30 Min
1 US. Qt. or four 8 Oz kits	40 Min	25 Min

Casing Applications

T-LOK should attain maximum breakout strength before drilling-out operation commences. If bottom-hole temperature is 100°F (38°C), maximum strength is reached in 7-10 hours. If temperature is 150°F (66°C) or higher, maximum strength is attained in 4-6 hours following application.

Coverage

Casing OD (inches)	Number of Joints Each T-LOK 8 oz Kit Will Lock
4 ½	10
5 ½	6
6 5/8 or 7	4
7 5/8, 8 5/8, or 9 5/8	3
10 ¾, 11 ¾ or 13 3/8	2
16 or 20	1

EMERGENCY RELEASE

In case of emergency, T-LOK can be released by heating the joint from 500° to 600° F (260-315°C) and applying breakout torque immediately.

PLEASE NOTE: T-LOK does NOT cure reliably or uniformly below 40°F (4°C). At ambient temps below that, it needs to be heated.

DO NOT USE ON OXYGEN SERVICE.
Special packaging sizing available upon request.