700
INTER-LOCK™
PRIMER / ACTIVATOR
2 fl. oz. Bottle

INTER-LOCK™ Primer/Activator is a single component solvent based primer/activator designed to increase the cure speed of all IES Anaerobic Thread Lockers.

Ensures proper cure on inactive metals.

Ideal for cure below room temperature.

PHYSICAL PROPERTIES

Composition	Heptane Solution	**Specific Gravity**	.8 @ 25°C
Color	Green Liquid	**Drying Time**	30 - 70 seconds @ 20°C
Viscosity	2 cps @ 25°C	**Part Life On Product**	<30 Days

HANDLING PRECAUTIONS
Highly flammable product. Avoid product or product mist contact with naked flame and electrical equipment. Under no circumstances should Primer and Adhesive liquids be mixed together. Use only in well ventilated area. See MSDS.

APPLICATION METHOD
Spray or brush Primer on one or both surfaces. Porous or large surfaces should have Primer applied to both surfaces. Allow solvent to evaporate under good ventilation. Apply adhesive or sealant to one or both surfaces and assemble immediately.

STORAGE
INTER-LOCK Primer/Activator is highly flammable. Do not store near oxidizing agents or combustible materials. Store in cool, dry location in unopened container at 46°F to 82°F.

DIRECTIONS FOR USING #700 PRIMER/ACTIVATOR WITH IES THREADLOCKERS
For Assembly:
1. Clean all threads (bolt and hole) with a cleaning solvent such as *IES #1700 or #4700 Super Clean* and allow to dry.
2. Determine if the threads to be bonded are **Active** or **Inactive Metals** (refer to *TYPICAL CURING PERFORMANCE* section below). If material is an **Inactive Metal**, it may be necessary to coat all threads with *#700 INTER-LOCK Primer/Activator* and allow 30 seconds to dry. Priming is not required if the material is an **Active Metal**. If unknown, it is always best to use the primer.
3. Shake thread locker thoroughly before use.
4. To prevent the product from clogging in the nozzle, do not allow the tip of the thread locker bottle to touch metal surfaces during application.
5. **For Thru Holes**, apply several drops of thread locker onto the bolt at the nut engagement area. For Blind Holes, apply several drops down the female threads into the bottom of the hole. As threads are engaged, compressed air forces the product upwards into the threads.
6. Assemble and tighten as usual. When tightening to establish torque values, torque compensation is not required.

TYPICAL CURING PERFORMANCE
Cure Speed vs. Substrate
The rate of the cure will depend on the material used. IES Thread Lockers will react faster and stronger with **Active Metals**. However, **Inactive Metals** may require the use of *IES #700 Primer/Activator* to obtain maximum strength and cure speed at room temperature. See box below.

Cure Speed vs. Temperature
The rate of cure will depend on the ambient temperature.
Full cure is attainable in 24 hours at room temperature 22°C (72°F) or 1 hour at 93°C (200°F).

Cure Speed vs. Primer
To shorten fixture time or if an inactive surface is present, applying *IES #700 Primer/Activator* to the surface will improve fixture speed. *Example:* A 3/8-16 steel nut and bolt assembly will fixture in 5 minutes using a primer, while fixturing will occur in 20 minutes without a primer. Full cure in 24 hours for both procedures.

Active Metals	**Inactive Metals**
Soft Steel Iron	Some Platings
Copper	Anodized Surfaces
Brass	Titanium
Manganese	Zinc
Bronze	Pure Aluminum
Nickel	Stainless Steel
Aluminum Alloy	