Technical Datasheet AS31

Product Description

Bondchem AS31 is a medium strength high viscosity anaerobic sealant, or gasket maker. **AS31** provides resistance to low pressures immediately after assembly of the mating flange faces. **AS31** is also thixotropic, which reduces the migration of the liquid adhesive following application onto the component surface.

Typical Applications

Bondchem AS31 is designed to seal the joint between metal faces and flanges, such as valve covers, water pumps and gearbox casings. **AS31** can be used with or without pre-cut, pre-formed gaskets.

Instructions For Use

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive (see Compatibility Chart) apply suitable **Bondchem primer**.
3. Apply a continuous bead of AS31 to one of the mating metal faces.
4. Use suitable methods to assemble components, and tighten quickly to avoid shimming.
5. If required, run a low pressure test to confirm a full seal has been made, before the product is left to cure.For ultimate pressure and solvent resistance, allow the material to cure fully prior to use.

Properties of Uncured Material

Resin	Dimethacrylate
Colour	Orange
Viscosity @ 25ºC	
Brookfield Spindle 5 @ 20rpm	23,000 to 35,000 cps
Cure System	Anaerobic

Performance of Cured Material

Fixture Time	<12 minutes @ 22ºC
Fixture Time with Activator	<10 Minutes
Full Cure Time	24 hours @ 22ºC
Temperature Range	-53ºC to 120ºC
Breakaway Torque	6Nm
Prevailing Torque	4Nm

Packaging

Bondchem AS31 is available in 50ml and 250ml LDPE tubes. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

Storage & Shelflife

Bondchem AS31 should be stored in a cool dry area, out of direct sunlight. Stored correctly, this grade can offer a 12 month shelf life from manufacture.

Health and Safety in Use

Irritant: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water. For full Health and Safety information please consult the MSDS