

Product Description

Bondchem AT04 is a high strength threadlocker, that cures anaerobically to lock all types of metal threaded fasteners where controlled torque/tension is required. **AT04** lubricates during assembly, securing the mating parts with high strength retention and chemical resistance, once fully cured.

Typical Applications

Bondchem AT04 is well suited to a number of applications including:

- Locking and sealing of large bolts and fasteners (>20mm diameter).
- Locking studs into motor housings.

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. Shake the product thoroughly before application.
4. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
5. Use suitable methods to assemble components, and tighten to required torque level.
6. Allow to fully cure before applying load.

Properties of Uncured Material

Resin	Dimethacrylate
Colour	Red
Viscosity @ 25°C	
Brookfield Sp 2 @ 20rpm	1500 - 3500 cps

Performance of Cured Material

Fixture Speed	30 Minutes @ 25°C
Fixture Speed with Primer	<5 Seconds
Full Cure Time	24 hours @ 20°C
Typical Breakaway Strength	22 Nm
Typical Prevailing Strength	32 Nm
Gap Fill	0.18mm
Temperature Range	-53°C to 148°C

Packaging

Bondchem AT04 is available in 10ml, 50ml, 250ml LDPE bottles. In addition, we can offer automated dispensing lines for the bulk dispensing of this material.

Storage & Shelflife

Bondchem AT04 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.