

Product Description

Bondchem AT05 is a high strength anaerobic threadlocker, designed to permanently lock metal threaded components. AT05 locks fasteners up to 25mm in diameter, sealing against leakage and corrosion. AT05 is thixotropic, which reduces the migration of the liquid adhesive following application. Once cured, the AT05 resists attack from most fuels, lubricants and even most industrial gasses.

Typical Applications

Bondchem AT05 is designed for ultimate strength metal fastener applications such as studs into motor housings. The AT05 can eliminate the need to double nut, or weld critical heavy duty assemblies. Due to the viscosity of AT05, it is suited to both fine and medium threaded metal parts, that will not require periodic disassembly.

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	Green
Viscosity @ 25°C	
Brookfield Sp 2 @ 20rpm	400-600cps
Cure System	Anaerobic

Performance of Cured Material

Fixture Speed	<10 Minutes @ 20°C
Fixture Speed with Primer	<5 Seconds
Full Cure Time	24 hours @ 20°C
Typical Breakaway Strength	33 Nm
Typical Prevailing Strength	33 Nm
Gap Fill	0.018mm
Temperature Range	-53°C to 148°C

Packaging

Bondchem AT05 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 AT05 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