

Product Description

Bondchem AT06 is a high strength anaerobic threadlocker for permanent bonding of threaded metal assemblies. AT06 is designed for metal fasteners greater than 25mm in diameter, locking and sealing against leakage and corrosion. Once cured AT06 resists attack from lubricants and most industrial liquids and gasses.

Typical Applications

Bondchem AT06 is well suited to a number of heavy duty applications including:

- Locking large diameter studs with coarse threads.
- Reclaiming worn stud holes.
- Permitting reduced casting thickness, eliminating cracked casings due to interference fit stresses

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 @ 30rpm	400 - 600 cps
Cure System	Anaerobic

Performance of Cured Material

Fixture Speed	10 Minutes @ 20°C
Fixture Speed with Primer	<10 Seconds
Full Cure Time	24 hours @ 20°C
Typical Breakaway Strength	33 Nm
Typical Prevailing Strength	33 Nm
Gap Fill	0.15 mm
Temperature Range	-53°C to 150°C

Packaging

Bondchem AT06 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 AT06 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.