

Product Description

Bondchem AT03 is an oil tolerant medium strength threadlocker, that cures anaerobically to lock all types of metal threaded fasteners. **AT03** is designed for applications that require future disassembly with standard hand tools, and offers excellent temperature and solvent resistance once cured. **AT03** is also thixotropic, which aids assembly by reducing the migration of the liquid adhesive following application. This grade can even cure rapidly on plated, oily metal, or inactive surfaces.

Typical Applications

Bondchem AT03 is well suited to a number of applications including:

- Replacing lock washers and plastic inserts.
- Locking machine tool access bolts.
- Locking and sealing gear box and drive shaft bolts.
- Securing conveyor roller bolts.
- Locking bearing cover cap screws.

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 cure fully before applying load.

Properties of Uncured Material

| | |
|-------------------------|-------------------|
| Resin | Modified Acrylate |
| Colour | Blue |
| Viscosity @ 25°C | |
| Brookfield Sp 2 @ 20rpm | 1300-3000 cps |

Performance of Cured Material

| | |
|-----------------------------|------------------------|
| Fixture Speed | 5 to 10 Minutes @ 25°C |
| Fixture Speed with Primer | <1 Second |
| Full Cure Time | 24 hours @ 20°C |
| Typical Breakaway Strength | 24 Nm |
| Typical Prevailing Strength | 5 to 7 Nm |
| Gap Fill | 0.04mm |
| Temperature Range | -53°C to 148°C |

Packaging

Bondchem AT03 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 AT03 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