

TECHNICAL DATA SHEET FOR A03

A03

PRODUCT DESCRIPTION

A03 is designed for the sealing and locking of threaded fasteners which may require disassembly with standard hand tools. The product is a single component anaerobic, medium strength thixotropic, acrylic based thread locker. The product cures when confined in the absence of air between close fitting metal surfaces and prevents leakage and loosening from vibration and shock.

A03 CHARACTERISTICS

Technology	Acrylic
Appearance (uncured)	Blue liquid
Chemical Form	Dimethacrylate ester
Fluorescence	Positive under UV
Cure	Anaerobic
Secondary cure	Activator
Components	Single – requires no mixing
Viscosity	Thixotropic, medium
Strength	Medium
Application	Threadlocking

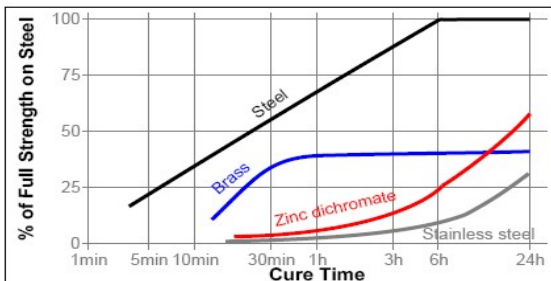
A03 is particularly suitable for uses on less active substrates such as plated surfaces, where disassembly is required with hand tools.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Specific Gravity @ 25°C	1.0
Viscosity @ 25°C	1200-1500 cPs
Flash Point	See MSDS
Fixture Time	10 - 15 mins

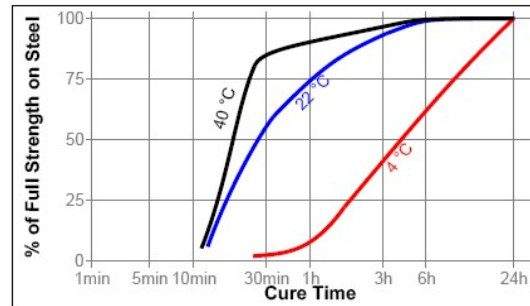
CURE SPEED VS. SUBSTRATE

The rate of cure is dependent on substrate used. The graph below shows the breakaway strength developed with time on M10 steel bolts and nuts compared to different materials and tested according to ISO 10964.



CURE SPEED VS. TEMPERATURE

The rate of cure is dependent on the ambient temperature. The graph below shows the breakaway strength developed with time at different temperatures on M10 steel bolts and nuts and tested according to ISO 10964.



CURE SPEED VS. ACTIVATOR

Where the cure speed is unacceptably long or large gaps are present. An activator can be applied to the surface which will improve cure speed.

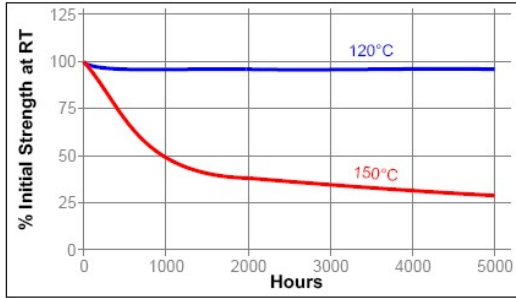
TYPICAL PERFORMANCE OF CURED MATERIAL

Operating Temp °C	Typical Value -54°C - 150°C
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(After 24 hr at 20-25°C) on M10 steel nuts & bolts)

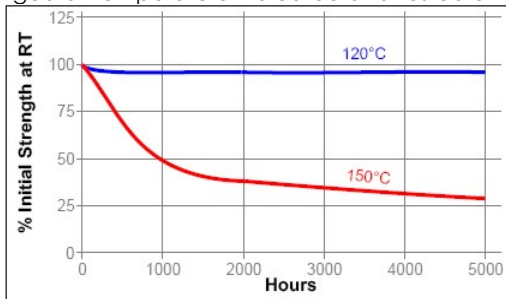
	Typical Value
Breakaway Torque M10 steel bolts & nuts ISO 10964	17Nm
Prevail Torque M10 steel bolts & nuts ISO 10964	5Nm

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Heat aging

Aged at temperature indicated and tested at 22°C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength			
		100h	500 h	1000 h	5000 h
Motor oil (MIL-L-46152)	125	100	95	90	85
Leaded Petrol	22	95	95	95	95
Brake Fluid	22	95	95	95	90
Water/Glycol 50/50	87	80	80	80	80
Acetone	22	100	90	90	90
Ethanol	22	95	95	90	90

DIRECTIONS FOR USE

1. For optimum performance surfaces should be clean and free of grease.
2. If the material is an inactive metal consider using activator.
3. Shake the product thoroughly before use.
4. Apply several drops to the bolt & nut.
5. Assemble and tighten as required.
6. To prevent the clogging of the nozzle, do not let the tip touch metal surface during application.

FOR DISASSEMBLY

1. Remove with standard hand tools.
2. In circumstances where hand tools do not work, use localized heat to bolt or nut, disassemble while hot.

FOR CLEANUP

1. To remove cured product, use a combination of solvent and abrasion such as a wire brush.

PRECAUTION

1. Use proper ventilation, avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder.
3. Do not try to remove forcibly.
4. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
5. Keep well out of reach of children.

STORAGE

Keep adhesive in a cool, dry place (20-25°C). For long term storage, refrigeration (5°C or 40°F) is recommended unless otherwise labelled. To prevent contamination of unused material, do not return any product to its original container. For specific shelf life information, contact Adhesive Dispensing Ltd

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Adhesive Dispensing Ltd
55 Alston Drive
Bradwell Abbey
Milton Keynes, UK
MK13 9HB

Telephone Number:
+44(0)1908 686660

Fax Number:
+44(0)1908 686836