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TECHNICAL DATA

Three Bond 1342
Anaerobic Adhesive & Sealant

Three Bond 1342 is a reactive acrylic monomer based anaerobic adhesive and sealant. The setting speed is fast while the fixing strength is low for parts that require frequent removal. Australian Gas Association Standard AG 208 approves it to 1000 kPa pressure.

Application

- For fixing and sealing of screws

Characteristics

Item		Units	Three Bond 1342	Remarks
Appearance			Blue, transparent liquid	
Viscosity		mPa·s	150	25°C
Shear Adhesive Strength (Fe/Fe)		kgf/cm^2	160	
Torque	Break-loose	kg·cm	92	Iron bolt &
	Prevailing	kg·cm	71	nut, 10 mm
Gap filling	Optimum	mm	0.005 - 0.01	
Ability	Maximum	mm	0.15	
Cure speed	Partial	h	2	25°C
	Full	h	24	
Useable Temperature Range		°C	-80 ~ 150	
Chemical Resistance			Excellent	

Curing Speed

Temperature (°C)	Curing time (min)	Remarks
80	30	
100	20	
120	10	

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Chemical Resistance

Test method: 5g of hardened Three Bond 1342 are immersed in various chemicals at 50°C for 3 months.

Chemicals	Three Bond 1342
Gear oil	4
Engine oil	4
Gasoline (lead-free)	4
Gasoline (leaded)	4
Freon	3
Water	5
Toluene	3
Trichloroethylene	3
2% caustic soda	3
2% hydrochloric acid	4
n-hexane	4
30% aqueous ammonia	3
LPG	4

5	Useable: Excellent Weight change factor: ± less than 0.5%
4	Useable: Good Weight change factor: ± 0.5 % to 2.5 %
3	Useable: Fair Weight change factor: ± 2.5 % to 5 %
2	Useable: Slightly poor depending upon conditions Weight change factor: ± 5 % to 10 %
1	Useable: Poor Weight change factor: over 10 %

Handling Precautions

- **Cleaning of Works**

While the presence of a small amount of oil on the surface of work does not affect the practical bonding strength, in order to fully utilise the performance of adhesive, it is essential to eliminate oil and dust completely from the work. Oil and grease can be effectively removed by cleaning with organic solvents such as trichloroethane. For the sake of safety, flammability and other reasons, trichloroethane is most recommended. One should avoid using kerosene, gasoline and light oil because they stick to the work.

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- **Storage**

Since adhesive sets through chemical reactions, storing it a higher temperature may shorten the service of life. If stored in a cool place, well ventilated and shaded from the sun, the adhesive kept in a specified container may remain usable for up to 6 months. If it is kept in a refrigerator at 5 ~ 10^0C, its life is extended to a year or longer.

Shelf Life

12 months unopened at 10-25^0C.

Packaging

Available in sizes of 5g, 50g and 250g.

Disclaimer

For Industrial Use Only

(Do not use for household purposes)

- The data contained in this report are obtained from experimental results, based on our test methods. We cannot assume absolute responsibility for accuracy and safety. Before using this product, use your own judgement to determine whether or not this product meets the requirements of the application and objectives. This includes the burden of responsibility and hazardous danger. The extent of the guarantee provides replacement for products, which are clearly unsatisfactory.
- We assume responsibility for neither injury nor property damages resulting from the misuse of this product.
- We do not assume responsibility without written notice or contract.

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