



A70 STUDLOCK

Anaerobic Adhesive

Technical Data Sheet



GLUE MONSTER ADHESIVES RANGE

Description:

A high strength, anaerobic adhesive for the permanent retention and sealing of threaded fasteners, sleeves and bearings. It is resistant to fuels, oils, hydraulic and refrigeration fluids.

Features & Benefits:

- ◆ **High bond strength.**
- ◆ **Resistant to fuels and oils.**
- ◆ **Lubricating properties.**
- ◆ **Permanent fixing - cannot be disassembled.**
- ◆ **Protects against corrosion.**
- ◆ **Withstands vibration.**

Uses

Bond It A70 STUDLOCK can be used for fixing and sealing of plugs, through bolts and studs into castings, etc. It eliminates split pins, double nutting and spot welds and is vibration proof. Also acts as a lubricant during assembly to ensure accurate torquing and protection against corrosion. Use of A70 STUDLOCK improves throughput and efficiency.

Limitations

Oily or greasy surfaces should not be bonded with A70 STUDLOCK. It is designed for metal to metal bonding. Users should satisfy themselves as to the products efficiency when used in conjunction with engineering rubbers and plastics. The strength of the Studlock bond will be substantially lower on stainless steel. On certain grades it may not work at all without the use of an activator. It is the user's responsibility to check suitability of this product with their particular application. Not recommended for use in oxygen rich systems and should not be used with chlorine or other strong oxidising materials.

Preparation

Remove heavy oil and grease contamination. Best results are obtained on clean parts. Shake thoroughly before use.

Application

Coat threads and ensure the adhesive is present at locking position. The adhesive starts to cure on exclusion of air from the bonding system. Observe handling and strength times stated below.

Bonding Times

Assuming room temperature is +20°C and a 0.15mm fastener gap size, handling time: initial strength approximately 10 minutes; full working strength 6-12 hours; ultimate cure 24 hours. The rate of

cure depends on the substrate used, bond gap and temperature. Smaller bond gaps and higher temperatures will generally achieve full bond strength faster.

Cleaning

Clean away excess adhesive with a dry cloth. Once dried, it is best removed mechanically with a wire brush.

Size

Available in 50ml and 25ml plastic bottles.

Colour

Green in colour.

Shelf Life

Minimum 12 months from date of manufacture when stored at +20°C in unopened bottles.

Storage Conditions

Store in a closed upright container between +5°C and +20°C in dry dark conditions. At low temperatures the shelf life will be prolonged. Protect from frost and direct sunlight.

Disposal of Containers

Do not leave empty containers where residue could be harmful to children, animals or the environment. Replace lids and remove any containers to a central disposal point in accordance with local regulations.

Health & Safety

Caution: Hydroquinone Monomethyl Ether, Acetyl, Phenylhydrazine.

Please refer to separate safety data sheet (SDS) for full handling, use and storage instructions. Keep out of reach of children. It is the user's responsibility to determine suitability for use. If in doubt, contact our Technical Department for advice.

Note: this information is for general guidance only, since site conditions and labour are beyond our control.

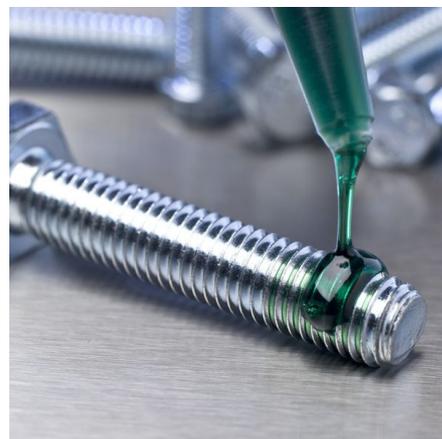
Specification Summary

LIQUID

Chemical Composition	Dimethacrylate monomer base
Appearance	Green liquid, capable of fluorescence
Viscosity	400-600 cPs
Density	1.06g/cm ³

CURED ADHESIVE Typical properties - tested on mild steel nut & bolt

Gap Filling	Up to 0.25mm
Breakaway Torque	26Nm
Prevail Torque	36Nm
Service Temperature Range	-55°C to + 150°C
Resistant to	Fuels, motor oils and hydraulic fluids
Commodity Code	350610000



Product / Order Details

Code	Colour	Fill	Barcode	UFI
BIA7025	Green	25ml	5060021367709	38U0-R0W2-J003-TNP3
BIA7050	Green	50ml	5060021360328	38U0-R0W2-J003-TNP3



Part of the Bond It Glues & Adhesives Range

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Note: The data presented in this leaflet is in accordance with the present state of our knowledge, but does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies raw materials are also being used. The recommendations do not absolve the user from the obligation of investigating the possibility of infringement of third parties rights and, if necessary clarifying the position. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the products for a particular purpose.



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