PERMABOND® A025
Anaerobic Retainer
Technical Datasheet

Features & Benefits

- Excellent temperature resistance
- Excellent chemical resistance

Approvals

KTW-BWGL Drinking Water Compliant / WRAS Drinking Water Approval

Description

PERMABOND® A025 is an anaerobic adhesive formulated to provide permanent locking and sealing of metal parts such as bearings, gears, studs and other threaded components.
It has been designed for applications where joints have to withstand temperatures up to 200°C or where the maximum degree of chemical resistance is required. These features allow machining tolerances to be relaxed and mechanical locking devices to be eliminated, with consequent cost savings.

Typical Physical Properties of Uncured Adhesive

Chemical composition	Acrylic
Appearance	Orange
Viscosity @ 25°C	750 mPa.s ***(cP)***
Specific Gravity	1.1
UV fluorescence	Yes

Typical Curing Properties

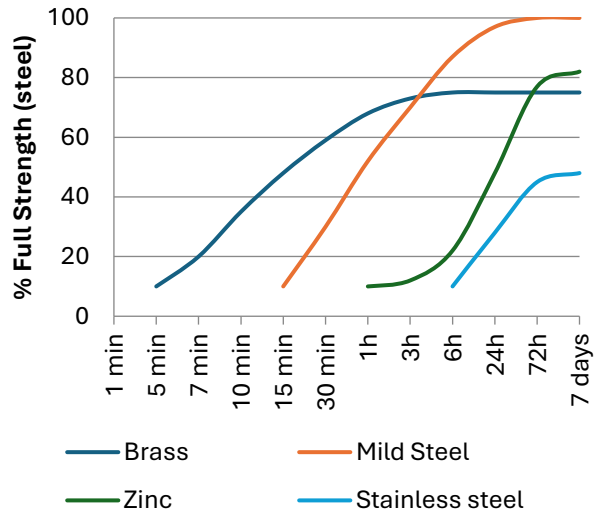
Maximum gap fill	0.2 mm ***0.008 in***
Maximum thread size	M20 ***¾ in***
Time taken to reach handling strength (M10 steel) @23°C*	15-30 minutes
Time taken to reach working strength (M10 steel) @23°C	2 hours
Full strength (M10 steel) @23°C	24 hours

**Handling time at 23°C / 73°F. Copper and its alloys will make the adhesive cure more quickly, while oxidised or passivated surfaces (like stainless steel) will reduce cure speed. To reduce curing time, use Permabond® activator A905 or ASC10. Alternatively, increasing the curing temperature will reduce curing time.*

Typical Performance of Cured Adhesive

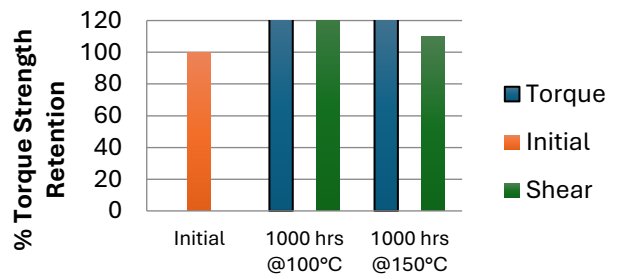
Torque strength (M10 steel ISO 10964)	Break 13 N·m ***115in.lb*** Prevail 23 N·m ***200 in.lb***
Shear strength (Steel collar & pin ISO 10123)	8 MPa ***1200 psi***
Coefficient of thermal expansion	90 x 10^{-6} mm/mm/°C
Dielectric strength	11 kV/mm
Thermal conductivity	0.19 W/(m.K)

Strength Development



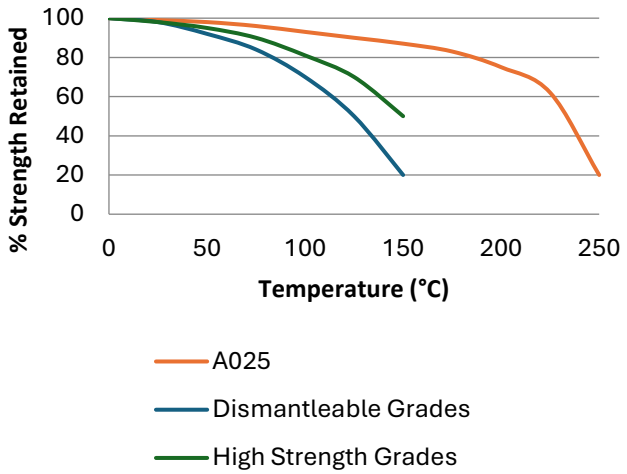
**Cure times are typical at 23°C. Copper and its alloys will follow the faster cure while oxidised or passivated surfaces like stainless steel will tend towards the slower curve. Lower temperatures or large gaps will tend to extend the cure time. To reduce the cure time the use of Permabond® A905, ASC10, or heat can be considered.*

Environmental Resistance



FOR PROFESSIONAL OR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN

Hot Strength



**"Hot strength" Breakaway strength on M10 Zinc plated bolts according to ISO 10964. Cured at 23°C for 24 hours then conditioned for 30 minutes at testing temperature.*

Permabond® A025 can withstand higher temperatures for brief periods (such as for paint-baking and wave soldering processes) provided the joint is not unduly stressed.

This product is not recommended for use in contact with oxygen, oxygen rich systems and other strong oxidizing materials. This product may adversely affect some thermoplastics and users must check compatibility of the product with such substrates before using.

Surface Preparation

Though the anaerobic adhesives will tolerate a slight degree of surface contamination, best results are obtained on clean, dry and grease free surfaces. The use of a suitable solvent-based cleaner (such as acetone or isopropanol) is recommended.
In general, roughened surfaces (~25µm) give higher bond strengths than polished or ground surfaces.
To reduce the curing time, especially on inactive surfaces (such as zinc, aluminium and stainless steel), the use of Permabond® A905 or ASC10 can be considered.

Directions for Use

1) Apply a circumferential bead; preferentially to the female component. Assemble with a twisting action.
2) For larger components use thixotropic products to prevent run off.
3) Take care to ensure adhesive does not enter ball races or other mechanisms.

NB: Adhesive outside of a closed joint (i.e., excess material) will remain uncured due to air contact. Adhesive inside the joint will cure solid. Ensure the adhesive viscosity is suitable for your thread size.

Video Link

Retaining compound directions for use:
https://youtu.be/MUODE5ZfrZ8

Storage & Handling

Storage Temperature	5 to 25°C ***(41 to 77°F)***
Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Safety Data Sheet.	

This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.

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