

Features & Benefits

- 💧 Allows alignment of parts during cure
- 💧 Does not shred or dry out
- 💧 Pressure seal to burst rating of the pipe
- 💧 Excellent chemical resistance

Approvals

KTW-BWGL Drinking Water Compliant /
WRAS Drinking Water Approval

Description

PERMABOND® A1058 is a highly viscous anaerobic sealant designed for use on threaded metal pipe connections carrying a wide variety of gases and liquids. Suitable for use on both parallel and tapered threads larger than 3/8" BSP, the delayed cure allows accurate alignment of components. A1058 can provide an instant pressure seal, minimizing down time and speeding up production processes. Unlike PTFE tape or hemp, it will not shred or dry out and so will provide a durable seal, helping to extend the life of the components.

Typical Physical Properties of Uncured Adhesive

Chemical composition	Acrylic
Appearance	White
Viscosity @ 25°C	300,000 mPa.s (cP)
Specific Gravity	1.1
UV fluorescence	Yes

Typical Curing Properties

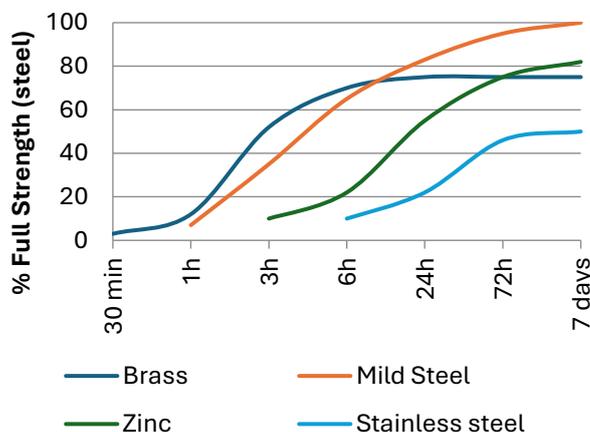
Maximum gap fill	0.5 mm 0.02 in
Maximum thread size	M56 2 in
Time taken to reach handling strength (M10 steel) @23°C*	90 minutes
Time taken to reach working strength (M10 steel) @23°C	2-4 hours
Full strength (M10 steel) @23°C	72 hours

*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

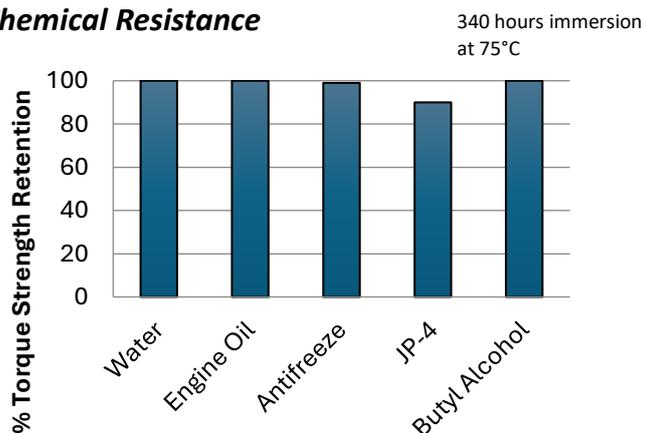
Torque strength (M10 zinc ISO 10964)	Break 8 N-m 70 in.lb Prevail 6 N-m 50 in.lb
Shear strength (Steel collar & pin ISO 10123)	8 MPa 1200 psi
Coefficient of thermal expansion	90 x 10 ⁻⁶ mm/mm/°C
Dielectric strength	11 kV/mm
Thermal conductivity	0.19 W/(m.K)

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.

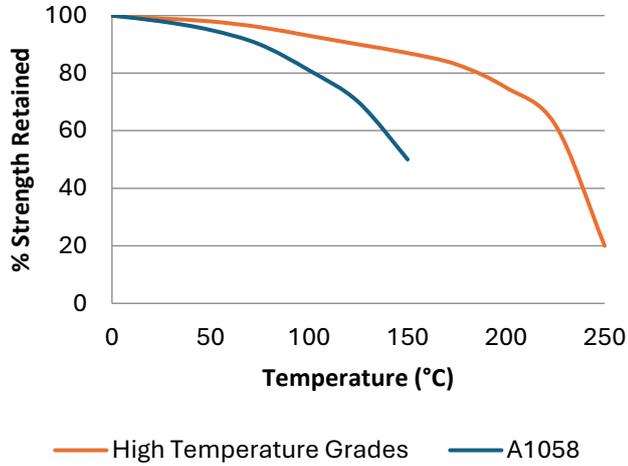
Chemical Resistance



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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® A1058 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

Best results are obtained on bare metal surfaces. Remove paint, hemp fibres, PTFE tape or any other surface contamination from the bond area that could inhibit the cure. The use of a suitable solvent-based cleaner (such as acetone or isopropanol) is recommended to remove oil, grease, and other contaminants. Allow the solvent to evaporate before applying the adhesive.

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 continuous bead around the circumference of the male thread (normally 1-2 threads back from the leading edge).
- 2) For taper/parallel threads ensure adhesive is positioned where the threads will engage fully. Gaps and cure times may be greater than expected with this joint configuration.
- 3) Ensure sufficient adhesive is applied to give a complete seal.
- 4) Tighten the components with suitable tools. Do not adjust. Allow the product to fully cure before using the part (lower temperatures or large gaps will extend the cure time).

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

Threadsealant directions for use:

<https://youtu.be/6Db9pLS7WCA>



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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