

ONEBOND FLANGE SEALANT 074

Description

The ONEBOND FLANGE SEALANT 074 is an Anaerobic adhesive designed to seal joints of pumps, gearboxes, engine casings and threaded joints. Typically used as a form-in-place gasket on rigid flanged connections. The ONEBOND 074 is designed to meet highest standard of health and safety as it does not carry on any hazard symbol on the label. The product cures when confined in the absence of air between metal surfaces and it is easily removable with standard tools. It provides a flexible film, resistant to vibrations, to warm environments over +150°C, oils, fuels and industrial fluids.

Typical physical properties

Composition:	methacrylate ester
Colour:	yellow thixotropic paste
Viscosity (+25°C - mPa s) @2.5 rpm:	80
Viscosity (+25°C - mPa s) @20 rpm:	15
Max gap fill:	0.3mm / 2"

Typical curing properties

Cure rate depends on the assembly gap, substrates and temperature. Full cure is reached in 24-36hours.

Typical properties of the cured adhesive

Bolt M10 x 20 Galvanized Steel @ +25°C:

Handling cure time:	20 minutes
Full cure time:	24 hours
Breakaway locking torque (ISO 10964):	3 N m
Lap Shear Strength:	2 MPa

Directions for use

The product is recommended for use on metal substrates.

Clean and degrease parts before bonding with acetone or isopropyl alcohol.

Apply product to fill completely the gap, assemble parts and hold on for curing time.

Liquid product can damage coating, some plastics and elastomers and give rise to stress-cracking events on some thermoplastics.

The product is not tested for use in oxygen rich systems and strong oxidizing materials.

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Storage

Store the material in a cool and dry place at temperature of +5°C/+25°C. To avoid contaminations do not refill containers with used product. Shelf life at 25°C is 12 months.

Safety, handling and disposal

Consult Material Safety Data Sheet before use.

Note

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