

A2542 – Technical Data Sheet



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Description

A2542 is designed for the sealing and locking of metal fittings and pipes. The product is a single component anaerobic, medium strength thixotropic, acrylic based product. The product cures when confined in the absence of air between close fitting metal surfaces and prevents leakage and loosening from vibration and shock. A2542 is particularly suitable for uses including the sealing and locking of large studs and bolts (M25 & larger).

Characteristics

Base	Methacrylate ester
Viscosity	1200-2750 cps
Fixture Time	4 hours
Colour	Brown
Specific Gravity (25°C)	1.06
Flash point	See MSDS

Typical Performance of Cured Material

	Typical value
Operating temperature (After 24hr at 20-25°C on M10 steel nuts and bolts)	-54°C to 150°C
Breakaway torque M10 steel bolts and nuts ISO 10964	15 Nm
Prevail torque M10 steel bolts and nuts ISO 10964	9 Nm

Chemical / Solvent Resistance

Aged under conditions indicated and tested @ 22°C.

Environment	Temp	% of initial strength		
	°C	100 h	500 h	1000 h
Motor oil (MIL-L-46152)	125	85	85	75
Leaded Petrol	22	100	100	100
Brake Fluid	22	100	100	100
Water/Glycol 50/50	87	100	85	85
Acetone	22	95	95	95
Ethanol	22	95	95	95

Directions for use

1. For optimum performance surfaces should be clean and free of grease (internal and external).
2. If the material is an inactive metal consider using activator.

3. Shake the product thoroughly before use.
4. Apply several drops to the bolt and nut.
5. Assemble and tighten as required.
6. Properly tightened fittings will seal to moderate pressures instantly. For maximum resistance allow a minimum of 24 hours to cure.

Disassembly

1. Remove with standard hand tools.
2. In circumstances where hand tools do not work, use localised heat to bolt or nut, disassemble while hot.

Cleaning

To remove cured product use a combination of solvent and abrasion such as a wire brush.

Precaution

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder.
3. Do not try to remove forcibly.
4. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
5. Keep well out of reach of children.
6. This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be use with chlorine or other strong oxidising materials.
7. Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases these solutions can affect the cure and performance of the adhesive.
8. This product is not recommended for use on certain plastics.

Please consult the A2542 Health & Safety Data Sheet for statutory regulation information.

Information relating to the products of Bondrite Adhesive Limited is based on tests carried out under laboratory conditions. If any of our products are not used in accordance with our instructions or are used under conditions which vary from our laboratory, they may not perform in accordance with any information provided and Bondrite shall not have any liability in this case. Bondrite will accordingly provide samples of our products, on request and free of charge, for Customers to carry out their own tests as to suitability of our product for their purposes and as used in their intended environment.

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