



Three Bond International, Inc.

Technical Data Sheet

TB 1305N ANAEROBIC ADHESIVE

Information

TB1305N is a high performance, thixotropic, single fluid, solventless, anaerobic adhesive. TB1305N is a high strength type anaerobic adhesive. It will not set so long as it is in contact with air. It cures rapidly once contacts to metal and in absence of air.

Applications

Used mostly for locking bolts permanently.

Typical Properties

1. Uncured State

Properties		Units	Value
Appearance		-	Green
Viscosity		mPa·s (cP)	700 (700)
Specific Gravity		-	1.09

2. Cured Material

Properties		Units	Value
Set Time		Minutes	< 3
Curing Speed	Workable	Hours	1
	Final		12
Curing Time	80°C	Minutes	20
	100°C		15
	120°C		10
Recommended Clearance		mm	0.01 ~ 0.02
Maximum Clearance			0.3

3. Cured Material

Properties			Units	Value
Service Temperature			°C	-40 ~ +150
Retaining Torque, M10.	Steel	Breakloose	N·m (kgf·cm)	46.0 (470)
		Prevailing		23.0 (240)
	SUS	Breakloose		35.0 (360)
	Al	Breakloose		25.0 (260)
	Brass	Breakloose		30.0 (310)
	Zn-Cr	Breakloose		14.0 (140)
	Ni	Breakloose		14.0 (140)
Shear Strength	Compression		MPa(kgf/cm ²)	45.0 (460)
	Twist			29.0 (300)

These are typical properties and not product specifications