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# Three Bond International, Inc.

## Technical Data Sheet

### **TB1322 - ANAEROBIC SEALANT**

#### **Information**

TB1322 is a high performance, red, and high strength 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. Used mostly for locking bolts permanently.

#### **Typical Properties**

##### **1. Uncured State**

| Property         | Units      | Value     |
|------------------|------------|-----------|
| Appearance       | -          | Red       |
| Viscosity        | mPa•s (cP) | 150 (150) |
| Specific gravity | -          | 1.11      |

##### **2. Cured Material**

| Property                  |          | Units                      | Value        |
|---------------------------|----------|----------------------------|--------------|
| Recommended Clearance     |          | mm                         | 0.005 ~ 0.01 |
| Max Clearance             |          |                            | 0.15         |
| Curing Speed<br>(20-25°C) | Workable | Hour                       | 2            |
|                           | Final    |                            | 24           |
| Shear Strength            | Fixing   | MPa (kgf/cm <sup>2</sup> ) | 23.0 (240)   |
|                           | Screw    |                            | 14.0 (140)   |
| Curing Time               | 80°C     | Minutes                    | 30           |
|                           | 100°C    |                            | 20           |
|                           | 120°C    |                            | 10           |
| Service Temperature       |          | °C                         | -40 ~ 150    |

| Property                |                    |       | Units        | Value      |
|-------------------------|--------------------|-------|--------------|------------|
| Retaining Torque<br>M10 | Break Loose Torque | Fe    | N·m (kgf·cm) | 22.0 (230) |
|                         | Prevailing Torque  |       |              | 38.0 (380) |
|                         | Break Loose Torque | SUS   |              | 11.0 (110) |
|                         | Break Loose Torque | Al    |              | 11.0 (110) |
|                         | Break Loose Torque | Brass |              | 11.0 (110) |
|                         | Break Loose Torque | Zn-Cr |              | 5.5 (56)   |
|                         | Break Loose Torque | Ni    |              | 19.0 (200) |

*These are typical results and not specifications.*