

TECHNICAL DATA SHEET

Drei Bond 5204

Revision: 24.08.2018
Version: 1.005



PRODUCT PROPERTIES

Drei Bond 5204 is a middle-strength, anaerobic curing thread sealant. Allows vibration and shock resistant bondings. It replaces PTFE tape and yam and gives instant sealing against moderate pressures.

Very good resistance against oil, gas, water, hydrocarbons and other chemicals. In case of passive surfaces and/or low temperature curing can be accelerated by using activator Drei Bond 4011. Automatic application with Drei Bond dosing systems ensured.

PHYSICAL PROPERTIES

Composition	Methacrylate
Colour	Yellow
Viscosity at 25 °C	20,000 – 80,000 mPa·s, thixotropic
Specific weight	1.1 g/cm ³
Temperature range:	-55/+150° C
Gap filling	M56 / 2" / 0.30 mm

CURING PROPERTIES

Bolt M10 x 20 Zn – quality 8.8 – nut h = 0.8 d at 25° C

Handling time:	15 – 30 minutes
Functional cure time:	1 – 2 h
Full cure time:	3 – 6 h
Shear strength (ISO 10123):	6 – 13 N/mm ²
Locking torque Breakaway (ISO 10964)	18 – 24 Nm
Locking torque Prevailing (ISO 10964)	7 – 14 Nm

DIRECTIONS FOR USE

- This product is recommended for use on metal surfaces.
- Clean, dry and grease-free surfaces ensure the maximum strength.
- Clean soiled surfaces with Cleaner Drei Bond 3200, Drei Bond Super Cleaner or appropriate solvent. We disadvice the use of cleaners containing acetone.
- Apply product to fill completely the gap, assemble parts and hold on for curing time.
- Disassembly and removal of adhesive residues can be eased by heating to 200° - 250°C or the use of Drei Bond Super Cleaner.

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STORAGE

- 12 months at RT in unopened packaging.
- To avoid contaminations do not refill containers with used product.

SATEFY AND HANDLING

Please consult the Safety Data Sheet before use.

PACKAGE UNITS

- For manual application 50g bottle and 250g bottle
- For industrial use on inquiry

For automatic processing we recommend to use Drei Bond application systems from stand-by equipments to full automatic CNC-controlled dosing machines.

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