

FastoTM

Your Adhesive Expert



ANAEROBIC ADHESIVES AND SEALANTS

Anaerobic Adhesives and Sealants

Fasto anaerobic adhesives and sealants are developed to maximize efficiency and to minimize the need for machinery maintenance in your facility. Curing only in the absence of oxygen and in the presence of metal ions, Fasto anaerobic adhesives are a solvent-free, room-temperature cure, one component system designed to deliver metal-to-metal bonds that resist shock and vibrations.

Fasto adhesives are unique due to their different strength properties and may be categorized as being high, medium, or low-strength, making selection of the appropriate product simple within a given category of use. General uses of Fasto anaerobic adhesives include locking and sealing of fasteners, retaining cylindrical assemblies like shaft-gear, shaft-bearing, shaft-pulley, rotors & many more, gasketing of flanges and sealing of pipes.

Threadlocking

Vibration often causes self-loosening of threads, our Fasto anaerobic adhesives provide a simple solution to this problem. When the appropriate Fasto threadlocker is applied and the parts are then assembled, the threadlocker fills the voids in the threads, locking bolts in place and creating a corrosion-stopping seal.

Fasto threadlockers are designed to eliminate the need for mechanical aids like washers, check nuts etc, in securing threads.

When choosing which Fasto threadlocker to use, consideration should be made for the various strength classes available, together with the substrate and size of the threads to be bonded. While most Fasto threadlockers are designed to be non-removable, low-strength grades are available to allow future disassembly. Fasto threadlockers are also available in a variety of viscosities, from wicking-grade to gel.

Retaining Bearings, Shafts, Studs and Flanges

Fasto retaining compounds durably and reliably retain cylindrical assemblies like shaft-gear, shaft-bearing, shaft-pulley, rotors & many more. Generally speaking, the need to dismantle such joints is not required, and Fasto retaining compounds are designed for high strength to meet this requirement. When Fasto retaining compounds are used, it is possible to achieve uniform stress distribution throughout the joint, making it possible to withstand dynamic and static loads with equals ease.

Additionally, use of Fasto retaining compounds confers the following advantages on the joints they bond:

- Small gaps can be bridged, which allows for less costly part designs
- Friction corrosion is avoided
- Allows assembly of parts with different elongation figures.

Sealing Gaskets

Fasto gasket makers help eliminate pre-cut or compression gaskets. Used to fill the voids between metal flanges, Fasto gasket makers create a seal that protects the joint against corrosion. Because Fasto gasket makers are available in different strengths, it gives part designers freedom to design different types of joints-for example, one that is easy to disassemble, or one with the higher mechanical resistance conferred by simple choosing a higher-strength gasket maker. Fasto gasket makers are resistant to many common oils and gases, and permit sealing tests of up to 1 bar immediately after the parts are fully assembled.

Another great advantage of Fasto gasket makers is that they eliminate joint settlement. Compared to traditional rigid flanges, there is no need to re-tighten the flange bolts, and creeping and shimming effects are eliminated. Fasto gasket makers also allow you to reduce inventory by providing a single liquid solution to all your gasketing needs.

Sealing Pipes

In addition to sealing fine threads, Fasto pipe sealants can also seal pipe fittings. Thanks to their ability to withstand most chemicals, these sealants provide a complete seal between threads, offering many advantages over traditional sealing methods like PTFE tape or hemp. Depending on which sealant has been selected, initial leak tests may be carried out immediately, though early testing should not exceed 1 -2 bar. After curing is complete, pressure can be maximized, and the sealant will hold until the joint is destroyed.

As with any anaerobic adhesive or sealant the substrates to be bonded and their design have a huge influence on which Fasto pipe sealant is most appropriate for use. For example, larger threads need more adhesive to fill their larger voids, and will give higher torque values once the sealant is fully cured. In this instance, a low-strength Fasto pipe sealant should be selected, especially if easy disassembly is required.

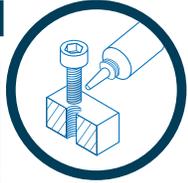
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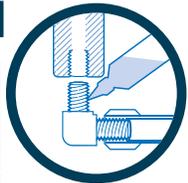
Threadlocking

Product	Features	Description	Typical Properties	Ordering Information*
Fasto A122	High Performance Low Strength	Fasto A122 is recommended for low-strength threadlocking of adjustment screws, countersunk head screws, and set screws; on collars, pulleys, tool holders and controllers. It can also be used for low strength metals such as aluminium and brass.	Fastener Size (inch) Up to 1/4 Cure Time (Fixture/Full Strength)** 10 min. / 24 hr. Breakaway/Prevail Torque (Nm) 13 / 9 Temperature Resistance for Continuous Service (°C) -50 to 150	50 ml - ANTL0122 250 ml - ANTL0322
Fasto A143	High Performance Medium Strength	Fasto A143 is fast curing threadlocking compound thus reduces or eliminates the need of primers. It is effective on all types of metal threaded fasteners. It prevents loosening of fasteners on vibrating parts such as pumps, motors, gear boxes and machine tools. Removable with hand tools.	Fastener Size (inch) Up to 3/4 Cure Time (Fixture/Full Strength)** 15 min. / 24 hr. Breakaway/Prevail Torque (Nm.) 19 / 10 Temperature Resistance for Continuous Service (°C) -50 to 150	50 ml - ANTL0143 250 ml - ANTL0343
Fasto A162	High Performance High Strength	Fasto A162 is a high strength product that can be applied to fasteners up to 3/4" (20mm) before assembly. Localized heating and hand tools are required to separate parts. Solvents will not weaken the adhesive bond.	Fastener Size (inch) Up to 3/4 Cure Time (Fixture/Full Strength)** 15 min. / 24 hr. Breakaway/Prevail Torque (Nm.) 25/ 25 Temperature Resistance for Continuous Service (°C) -50 to 150	50 ml - ANTL0162 250 ml - ANTL0362
Fasto A170	High Performance Permanent Strength	Fasto A170 is fast curing threadlocking compound. It can be used on all metal fasteners where regular removal for maintenance is not required. It is recommended for permanent locking of studs on engine blocks and pump housings.	Fastener Size (inch) Up to 3/4 Cure Time (Fixture/Full Strength)** 15 min. / 24 hr. Breakaway/Prevail Torque (Nm.) 29 /33 Temperature Resistance for Continuous Service (°C) -50 to 150	50 ml - ANTL0170 250 ml - ANTL0370
Fasto A172	High Viscosity High Temperature	Fasto A172 is high viscosity and high temperature threadlocking compound. High viscosity allows its usage on fasteners size upto 1 1/2".	Fastener Size (inch) upto 1 1/2 Cure Time (Fixture/Full Strength)** 15 min. / 24 hr. Breakaway/Prevail Torque (Nm.) 26/26 Temperature Resistance Service (°C) -50 to 200 (continuous) -50 to 230 (intermittent)	50 ml - ANTL0172 250 ml - ANTL0372
Fasto A190	Very Low Viscosity Wicking Capability	Fasto A190 is very low viscosity threadlocking compound. It can be used for locking after assemblies are completed. It can also be used for interference fit assemblies and for porosity sealing.	Fastener Size (inch) upto 1/2 Cure Time (Fixture/Full Strength)** 15 min. / 24 hr. Breakaway/Prevail Torque (Nm.) 16/16 Temperature Resistance for Continuous Service (°C) -50 to 150	50 ml - ANTL0190 250 ml - ANTL0390



Threadsealing

Product	Features	Description	Typical Properties	Ordering Information*
Fasto A742	High Performance Medium Strength	Fasto A742 is liquid thread sealant, recommended for sealing fine threads of Hydraulic/ Pneumatic connections. It seals upto burst pressure of pipe. A742 offers excellent chemical resistance also.	Pipe Thread Size (inch) Upto 3/4 Temperature Resistance for Continuous Service (°C) -50 to 150 Viscosity (cPs) 500 Cure Time (Fixture/Full Strength)** 15 min. / 24 hr.	50 ml - ANTS0142 250 ml - ANTS0342
Fasto A777	High Performance Medium Strength	Fasto A777 is formulated to lock and seal medium to coarse straight and tapered pipe threads on pipes Ø15mm to Ø80mm. Fasto A777 gives an almost instant low pressure seal (upto 2 bar after 20mins.) and when fully cured seals up to the bursting pressure of the pipe (10,000 psi).	Pipe Thread Size (inch) upto 3 Temperature Resistance for Continuous Service (°C) -50 to 150 Viscosity (cPs) 48000 / 15000 (thixotropic) Cure Time (Fixture/Full Strength)** 15 min. / 24 hr.	50 ml - ANTS0177 250 ml - ANTS0377
Fasto A765	High Performance Low Strength	Fasto A765 gives low strength break and prevail torque on assembled joints, thus enabling easier disassembly and servicing, which is further helped by the lubricity of A765. Fasto A765 is suitable for most straight and tapered pipe threads of medium to coarse pitch, from Ø15mm to Ø80mm pipe. Fasto A765 will not cure outside the joint and is virtually non-fouling in most types of pipe systems.	Pipe Thread Size (inch) upto 3 Temperature Resistance for Continuous Service (°C) -50 to 150 Viscosity (cPs) 300,000 / 80,000 (thixotropic) Cure Time (Fixture/Full Strength) 100 min. / 24 hr.	50 ml - ANTS0165 250 ml - ANTS0365



Gasketing

Product	Features	Description	Typical Properties	Ordering Information*
Fasto A473	High Performance Slow Curing	Fasto A473 is recommended for sealing rigid & semi-rigid metal flanges. It is slow curing. It can be used for sealing large gearbox flanges, pump housing, machinery covers, etc. It offers initial pressure resistance of 0.5 bar after 20 mins.	Gap Fill (mm) 0.35 Temperature Resistance for Continuous Service (°C) -50 to 150 Cure Time (Fixture/Full Strength)** 30 min. / 24 hr. Viscosity (cPs) 500,000 / 110,000 (thixotropic)	50 ml - ANFS0173 250 ml - ANFS0373



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Fasto A410	High Performance High Temperature	Fasto A410 is high temperature flange sealant for making & dressing gaskets in rigid assemblies. It permits clamp load to be maintained for leak-proof assemblies. It offers excellent solvent & chemical resistance. It offers initial pressure resistance of 0.5 bar after 20 mins.	Gap Fill (mm)	0.50	50 ml - ANFS0110 250 ml - ANFS0310
			Temperature Resistance for Continuous Service (°C)	-50 to 150	
			Cure Time (Fixture/Full Strength)**	15 min. / 24 hr.	
			Viscosity (cPs)	60000 / 425000 (thixotropic)	
Fasto A474	High Performance Fast Curing	Fasto A474 is recommended for sealing rigid & semi-rigid metal flanges. It is fast curing flange sealants that gives instant sealing. It can be used for sealing gearbox casings & side covers, pump housing, machinery covers, etc. It offers initial pressure resistance of 0.5 bar after 20 mins.	Gap Fill (mm)	0.35	50 ml - ANFS0174 250 ml - ANFS0374
			Temperature Resistance for Continuous Service (°C)	-50 to 150	
			Cure Time (Fixture/Full Strength)**	15 min. / 24 hr.	
			Viscosity (cPs)	31000 / 105000 (thixotropic)	

Retaining

Product	Features	Description	Typical Properties		Ordering Information*
Fasto A338	High Performance High Strength	Fasto A338 is high strength & high viscosity retaining compound for bonding cylindrical assemblies with clearance. It provides very high bond strength. Typical applications include retaining of locking sleeves, bearings, pulleys, sprockets, gears onto shafts. Fasto A338 is also used for retaining rotors, plugs and many more cylindrical assemblies	Gap Fill (mm)	0.25	50 ml - ANRC0138 250 ml - ANRC0338
			Temperature Resistance for Continuous Service (°C)	-50 to 150	
			Cure Time (Fixture/Full Strength)**	15 min. / 24 hr.	
			Shear Strength	27 N/mm2	
Fasto A348	High Temperature Fast Curing	Fasto A348 is high temperature and fast curing retaining compound. A348 is designed to augment the strength of press fit assemblies. It is mainly used for high strength cylindrical assemblies like gears & rotors on shafts.	Viscosity (cPs)	2500	50 ml - ANRC0148 250 ml - ANRC0348
			Gap Fill (mm)	0.20	
			Temperature Resistance Service (°C)	-50 to 150 (continuous) -50 to 175 (intermittent)	
			Cure Time (Fixture/Full Strength)**	10 min./24 hr.	
Fasto A320	High Viscosity High Temperature	Fasto A320 is suitable for high strength and high temperature retaining applications that require large gap filling. Fasto A320 is formulated for bonding cylindrical parts, to give high strength bonds. Fasto A320 is designed to augment the strength of slip fit assemblies and for use on loose-fitting or worn parts, where larger gap fill is required.	Shear Strength	26 N/mm2	50 ml - ANRC0120 250 ml - ANRC0320
			Viscosity (cPs)	600	
			Gap Fill (mm)	0.40	
			Temperature Resistance for Continuous Service (°C)	-50 to 230	
Fasto A301	Low Viscosity High Strength	Fasto A301 is suitable for high strength retaining applications that require minimum gap filling. Typical applications include bonding gears onto shafts. A301 is designed to augment the strength of press fit and interference fit assemblies. It can also be used for augmenting the strength of existing pres-fits.	Cure Time (Fixture/Full Strength)**	15 mins/ 24 hrs	50 ml - ANRC0101 250 ml - ANRC0301
			Shear Strength	24 N/mm2	
			Viscosity (cPs)	7500 / 20000 (thixotropic)	
			Gap Fill (mm)	0.20	
Fasto A301	Low Viscosity High Strength	Fasto A301 is suitable for high strength retaining applications that require minimum gap filling. Typical applications include bonding gears onto shafts. A301 is designed to augment the strength of press fit and interference fit assemblies. It can also be used for augmenting the strength of existing pres-fits.	Temperature Resistance for Continuous Service (°C)	-50 to 150	50 ml - ANRC0101 250 ml - ANRC0301
			Cure Time (Fixture/Full Strength)**	20 min/ 24 hrs	
			Shear Strength	21 N/mm2	
			Viscosity (cPs)	125	



Primer

Product	Features	Description	Typical Properties		Ordering Information*
Fasto AP49	High Performance Anaerobic Activator	<ol style="list-style-type: none"> 1. Activate inactive surfaces. 2. Speed cure times for faster return to service. 3. Speed curing through larger gaps and deep threads. 4. Substantially speed cure times on cold parts. 5. Act as a cleaning agent 	Viscosity (cPs)	15	200 ml -AP0349 (aerosol)
			Drying Time	15 s	

Primer is optional with:

Active surfaces: Brass, copper, bronze, iron, soft steel, nickel

Primer is required with:

Inactive surfaces: Aluminium, stainless steel, magnesium, zinc, black oxide, cadmium, titanium, others.

* Also available in bulk pack

** Fixture time is time in which adhesive achieves handling strength.