

PRODUCT DESCRIPTION

Fasto A162 is a high strength, anaerobic thread locker. A162 cures when confined in the absence of air on close-fitting metal surfaces. A162 is slightly oil tolerant, so it will bond some 'as received' parts, but best results are obtained with clean substrates. The thixotropic nature of the product prevents run off, dripping and migration after assembly. A162 prevents corrosion of assembled parts.

TYPICAL APPLICATIONS

Fasto A162 is suitable for most medium and coarse threaded screws, nuts and bolts. Fasto A162 is formulated to lock all metric and imperial nuts and bolts, preventing vibration loosening and leakage through the threads. A162 is typically used on mounting bolts, housing screws, etc. in crushers, diesel generators, agricultural machines, heavy engineering machineries and many more industrial & automobile assemblies.

PROPERTIES OF UNCURED MATERIAL

	Value
Chemical type	Dimethacrylate
Appearance	Blue
Specific Gravity	1.09
Viscosity ¹ cPs	7,000
Viscosity ² , cPs	2,000
Breakaway Torque ³ Nm	25
Prevail Torque ³ Nm	25
Fixture Time ⁴ (min.)	15
Full cure (hours)	24
Max Gap Fill (mm)	0.25
Operating Temperature Range (°C)	-50 to +150

¹ Brookfield RVT spindle 2, 2.5rpm

² Brookfield RVT spindle 2, 20rpm

³ On M10 black oxide steel bolt and M10 bright steel nut, ISO 10964

⁴ ISO 10964

TYPICAL CURING PERFORMANCE

Typical Speed:

30 mins	~10% strength
3 hour	~50% strength
24 hours	100% strength

Cure speed vs. Temperature

All figure relating to cure speed are tested at 21°C. Lower temperatures will result in slower cure. Heating the assembled part accelerates the curing process.

Activator Fasto AP49 should be used when the temperature is less than 5°C.

Cure speed vs. bond gap

The size of the bond gap greatly affects the speed of cure of anaerobic adhesives. Bond gap varies with thread type and size of the fastener. The larger the gap between surfaces, the slower the cure speed. Maximum recommended gap for Fasto A162 is 0.25mm.

Cure speed vs. Substrate

Cure speed and strength vary according to the substrates. When used on mild steel and brass components Fasto A162 will reach full strength more rapidly than on more inert materials such as stainless steel and zinc dichromate.

Anaerobic Adhesives only cure in the absence of air with metal part activation.

Cure speed vs. Activator

Where speed is too slow or the bond gap is very large, Fasto AP49 Activator may be used to accelerate cure speed. The use of an accelerator may reduce bond strength up to 30%.

Fasto recommends testing on the parts of measure the effect.

TYPICAL ENVIRONMENTAL RESISTANCE

Hot strength

Fasto A162 is suitable for use at temperatures up to 150°C. At 130°C the bond strength will be ~40% of the strength of at 21°C.

Heat ageing

Fasto A162 retains over 75% full strength when heated to 100°C for 90 days then cooled and tested at 21°C.

Chemical / Solvent Resistance

Fasto A162 exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen and chlorine lines.

DIRECTIONS FOR USE

Ensure parts are clean and dry and free from grease or oil. Apply adhesive to all the engaged area. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint. Product is normally hand applied from the bottle or tube. Dispensing systems are available for high volume assembly applications. Please contact your Fasto representative for further advice on dispensing solutions.

GENERAL INFORMATION

For safe handling of this product consult the Material Safety Data Sheet.

Storage

Fasto A162 has shelf life of 24 months from the date of manufacturing, if stored unopened at 21°C and away from direct sunlight.

Packaging

Bottles: 50 ml, 250ml and 1ltr. Available in bulk for use with dispensing system.
Please note: When packed an air space above the Product is vital to maintain stability.

DATA RANGES

The data contained in this data sheet may be reported as typical value and/or range. Values are based on actual test data and are verified on a regular basis.

NOTES

The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Fasto India and its agents cannot assume liability or responsibility for results obtained in the use of its product by persons whose methods are outside or beyond our control. It is the user's responsibility to determine the suitability of any of the products and methods of use or preparation prior to use mentioned in our literature and furthermore the user's responsibility to observe and adapt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.