

PRODUCT DESCRIPTION

Fasto A348 is a single component, high strength anaerobic retaining compound. A348 is a fast curing grade that develops high strength quickly and will withstand higher service temperatures than standard products.

A348 cures when confined in the absence of air between close-fitting metal surfaces.

TYPICAL APPLICATIONS

A348 is suitable for medium strength retaining applications that require small gap filling. Fasto A348 is formulated for bonding cylindrical parts, to give high strength bonds. Typical applications include mounting gears and rotors onto shafts. A348 is designed to augment the strength of press fit assemblies. Once applied, parts slip together easily, lubricated by the adhesive.

A348 prevents corrosion of assembling parts.

PROPERTIES OF UNCURED MATERIAL

	Value
Chemical type	Dimethacrylate / Triacrylate
Appearance	Green
Specific Gravity	1.08
Viscosity cPs ¹	600
Shear Strength ² (N/mm ²)	26
Fixture Time ³ (min.)	10
Full cure (hours)	24
Flash Point (°C)	>100
Max Gap Fill (mm)	0.2
Operating Temperature Range (°C)	
Continuous	-50 to +150
Intermittent	-50 to + 175

1 Brookfield LVF Spindle 2, 2.5rpm

2 On mild steel pin and collar, ISO 10123

3 ISO 10964.

TYPICAL CURING PERFORMANCE

Typical Speed:

15 mins	~10% strength
45 mins	~50% strength
24 hours	100% strength

Cure speed vs. Temperature

All figures 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. The larger the gap between surfaces, the slower the cure speed. Maximum recommended gap for A348 is 0.20mm, which will give approximately the cure schedule as detailed in the properties table.

Cure speed vs. Substrate

Cure speed and strength vary according to the substrates. When used on mild steel and brass components. Fasto A348 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 Anaerobic 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 A348 is suitable for use at temperatures up to 175°C intermittently. At 130°C the bond strength will be ~50% of the strength of at 21°C.

Heat ageing

Fasto A348 retains over ~80% full strength when heated to 100°C for 90 days then cooled and tested at 21°C.

Chemical / Solvent Resistance

Fasto A348 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 curing. 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

Optimal storage conditions are between 8°C and 21°C. Storage outside this temperature range can adversely affect product properties and may affect the stated shelf life.

Packaging

Bottles: 50 ml & 250ml.

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.

LIMITATIONS

Fasto A348 is not recommended on certain plastics as stress cracking can sometimes result. Some anti corrosion chemicals inhibit the cure system in this type of anaerobic.

Trails are recommended to establish whether cleaning of the parts is necessary.

Fasto AP49 Activator may be required on planted parts.

NOTES

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