



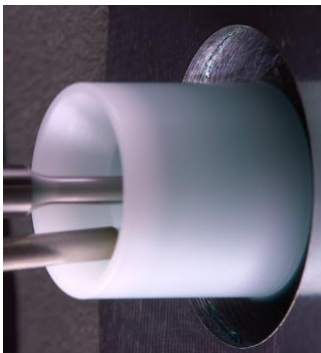
Adhesives

Drei Bond 1390HT - A special kind of anaerobic adhesive

Johanna Wiethaler (M. Sc., DVS®/EWF-Klebfachingenieur)

Anaerobic adhesives are an integral part of almost all branches of industry. They seal threads or secure screw and joint connections against unintentional loosening. Depending on the application and possible application, you can choose from various strength and viscosity ranges. The prerequisite for this is active metallic surfaces, and passive materials can often be connected with an anaerobic adhesive using a suitable activator. Depending on the adhesive, a very small gap of 0.07mm - 0.5mm is required for curing, which ensures that oxygen is excluded.

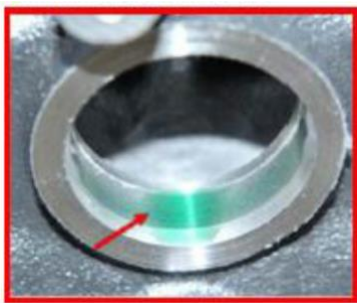
A large number of our anaerobic adhesives are used in the automotive industry. A classic location is the securing and sealing of core hole covers in the cylinder head and crankshaft housing. The adhesive is dosed radially into the hole before the lid is pressed into the hole.



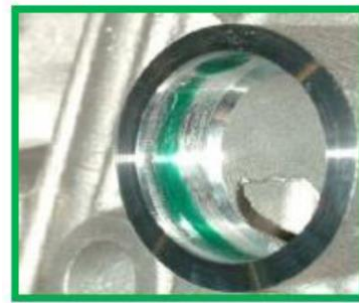
The requirements for the adhesive are high:

- oil resistance to various oils and cooling lubricants
- temperature resistance from -40 ° C to + 180°C
- fluorescent property for the order control system
- **high stability after radial application using a rotor spray**

After repeated leaks, the last point has certainly proven to be critical. With the help of various experiments, it was found that in the case of high hall temperatures or components that are still warm, the adhesive converges downwards after gravity is applied. The result of this is that there is no longer any adhesive in a large part of the hole and therefore cannot perform the sealing function. For this reason, we have developed a special anaerobic adhesive - **Drei Bond 1390HT**. In addition to all of the above, it has the ability to maintain its stability up to 40 ° C and not to run.



Many anaerobic adhesives
(HQM Induserv)



Drei Bond 1390HT

This further development clearly shows that the entire process must be considered when using an adhesive. After switching to the Drei Bond 1390HT, the leaks were significantly reduced and it was more cost efficient.