

Overview of anaerobic adhesives



Drei Bond	Strength class	Colour	Viscosity [mPa.s/25°C]	Thixotropy	max. thread diameter / gap filling [mm]	Fixture time [min] or [sec]	Functional cure time [h]	Full cure time [h]	Temperature range [°C]	Shear strength [N/mm ²]	Locking torque ISO 10964[Nm]	Application Properties
1385NT	High	Green	3000 - 4000	Low	M36/1.5" - 0.20 mm	1 - 18 min	1 - 3 h	2 - 24 h	-55 to +175°C	25 - 30 (ISO 10123)	30 - 40	Fast curing, stable at high temperatures, high-strength. Specially developed for threaded and joint connections that are subjected to high temperatures. Immediate sealing for difficult material combinations such as polyamide plugs in a cylinder head or as a V2A core hole cover in an aluminium engine block. Medium thixotropic setting enables larger processing tolerances. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. Very good chemical resistance against oils, gases, water, hydrocarbons and other industrial media, etc
5330	High	Green	3000 - 8000		M56/2" - 0.30 mm	10 - 40 min	6 - 12 h	24 - 36 h	-55 to +200°C	15 - 25 (ISO 10123)	25 - 35	High-strength, vibration-proof, thermal shock resistant metal thread sealing and securing, KTW (drinking water) and DVGW (gas) tested, up to M56/2". For all non-detachable threaded connections. Also suitable for oxygen gas lines up to 20 bar at +60°C. Very good chemical resistance against oils, gases, water, fuels, refrigerants and other industrial media, etc.
5510	Low	White	17000 - 70000	Low	2" - 0.30 mm	20 - 40 min	1 - 3 h	5 - 24 h	-55 to +150°C	4 - 6 (ISO 10123)	6 - 11	Securing and sealing of metal pipeline connections, up to 2". Low-strength, improved friction value ($\mu=0.10$). Suitable for gas, liquefied petroleum gas, compressed air, petrol, oil, industrial liquids, CFC, drinking water and other chemicals. Low friction coefficient guarantees simple assembly. Thixotropic setting prevents the sealant from running away before and during initial curing. The product replaces PTFE tape. Cured product provides an elastic film that is shock-resistant and vibration-proof. Normal disassembly ensured even years later. Only 50% loss of strength at 110°C.
5520	High	Ivory	25000 - 42000	High	M56/2" - 0.30 mm	20 - 40 min	3 - 6 h	24 h	-55 to +150°C	15 - 25 (ISO 10123)	35 - 50	High-strength and vibration-proof sealant for securing and sealing threaded and pipe connections. High viscosity and high thixotropy enables larger tolerances. Very good resistance against heat, corrosion, vibration, water, gases, oils, hydrocarbons and many other chemicals.
5300	Medium to high	Green	3 - 8		M5 - 0.07 mm	10 - 20 min	1 - 3 h	3 - 24 h	-55 to +150°C	8 - 12 (ISO 10123)	10 - 25	High capillary action. For sealing hairline cracks and porous areas of castings and mouldings. For retrospective sealing of threaded connections including fixing screws. Only <40% loss of strength at 150°C. Medium- to high-strength. Very good resistance against heat, corrosion, vibration, water, gases, oils, hydrocarbons and many other chemicals.
1385	High	Green	400 - 600		M20/¾" - 0.15 mm	1 - 18 min	1 - 3 h	2 - 24 h	-55 to +175°C	25 - 30 (ISO 10123)	25 - 35	Fast curing, stable at high temperatures, high-strength. Specially developed for threaded and joint connections that are subjected to high temperatures. Typical applications include fixing cogs and sprockets to drive shafts and rotors to shafts of electric motors. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. Also suitable for oxygen gas lines up to 20 bar at +60°C. Only 50% loss of strength at 175°C.
5454NT	High	Green	3000 - 4000	Low	M36/1.5" - 0.20 mm	1 - 18 min	1 - 3 h	2 - 24 h	-55 to +175°C	25 - 30 (ISO 10123)	30 - 40	Fast curing, stable at high temperatures, high-strength. Specially developed for threaded and joint connections that are subjected to high temperatures. Immediate sealing for difficult material combinations such as polyamide plugs in a cylinder head or as a V2A core hole cover in an aluminium engine block. Medium thixotropic setting enables larger processing tolerances. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. Very good chemical resistance against oils, gases, water, hydrocarbons and other industrial media, etc.

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1305	High	Green	300 - 800		M20 - 0.15 mm	10 - 20 min	1 - 3 h	5 - 24 h	-55 to +200°C	15 - 20 (ISO 10123)	25 - 35	Stable at high temperatures, high-strength. Securing of bolts, screws/nuts and fastening elements with thread. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. Only 50% loss of strength at 150°C.
1388	High	Green	6000 - 12000	HT	2" - 0.30 mm	15 - 30 min	3 - 6 h	6 - 24 h	-55 to +150°C	15 - 25 (ISO 10123)	40 - 50	High-strength and vibration-proof sealant for securing and sealing large screw connections (M25 and larger). High viscosity and high thixotropy enables larger tolerances. Very good resistance against heat, corrosion, vibration, water, gases, oils, hydrocarbons and many other chemicals.
1344	Medium	Blue	450 - 600		M20/¾" - 0.15 mm	10 - 20 min	1 - 3 h	3 - 24 h	-55 to +150°C	8 - 12 (ISO 10123)	12 - 18	Sealant for all normal detachable pneumatic and hydraulic threaded connections and small pipelines. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. The product replaces PTFE tape. Very good resistance against heat, corrosion, shock, vibration, water, gases, liquefied petroleum gases, oils, hydrocarbons and many other chemicals. Only 50% loss of strength at 100°C.
5314	Medium to high	Blue	1700 - 9000	LT	M36 - 0.25 mm	10 - 20 min	1 - 3 h	3 - 24 h	-55 to +200°C	9 - 13 (ISO 10123)	18 - 23	Thread lock for all normal detachable nuts and bolts. Temperature-resistant up to 200/250°C. Also suitable for oily surfaces. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. Very good resistance against heat, corrosion, vibration, water, gases, oils, hydrocarbons and many other chemicals. Only 35% loss of strength at 200°C.
1303	High	Green	120 - 180		M12 - 0.10 mm	5 - 10 min	1 - 3 h	3 - 24 h	-55 to +150°C	17 - 22 (ISO 10123)	24 - 35	For securing and sealing non-detachable built-in parts, shafts/hubs, bushings, pulleys and rotors with little clearance. Very good resistance against heat, corrosion, vibration, water, gases, oils, hydrocarbons and many other chemicals. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. Only 50% loss of strength at 125°C.
1342	Low	Blue	600 - 800		M20/¾" - 0.15 mm	15 - 30 min	1 - 3 h	5 - 24 h	-55 to +150°C	3 - 5 (ISO 10123)	5 - 8	Low-strength, suitable for screws, bolts and nuts up to M20 that are subject to vibrations and which must be easy to dismantle. Can also be used as corrosion protection for large threaded connections.
5205	Medium	Red	1200 - 1800		M20/¾" - 0.15 mm	10 - 20 min	1 - 3 h	3 - 24 h	-55 to +150°C	8 - 12 (ISO 10123)	12 - 18	Sealant for all normal detachable pneumatic and hydraulic threaded connections and small pipelines. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. The product replaces PTFE tape. Very good resistance against heat, corrosion, shock, vibration, water, gases, liquefied petroleum gases, oils, hydrocarbons and many other chemicals. Only 50% loss of strength at 100°C.
5204	Medium	Yellow	20000 - 80000	LT	M56/2" - 0.30 mm	15 - 30 min	1 - 2 h	3 - 24 h	-55 to +150°C	6 - 13 (ISO 10123)	18 - 24	Medium-strength, vibration-proof and shock-resistant anaerobic thread sealant. The product replaces PTFE tape. Immediate sealing against moderate pressures. Very good chemical resistance against oils, gases, liquefied petroleum gases, water, hydrocarbons and many other industrial media. Thixotropic setting prevents the sealant from running away before and during initial curing. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature.

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1360	Medium	Brown	430 - 630		M20/¾" - 0.15 mm	10 - 20 min	1 - 3 h	3 - 24 h	-55 to +150°C	8 - 12 (ISO 10123)	12 - 18	Sealant for all normal detachable pneumatic and hydraulic threaded connections and small pipelines. Drei Bond solvent-free activator 5900 speeds up curing on passive surfaces and/or at low temperature. The product replaces PTFE tape. Very good resistance against heat, corrosion, shock, vibration, water, gases, liquefied petroleum gases, oils, hydrocarbons and many other chemicals. Only 50% loss of strength at 100°C.
5537	Medium	Green	3000 - 4000		1.5" - 0.25 mm	15 - 30 min	1 - 3 h	12 - 24 h	-55 to +150°C	10 - 14 (ISO 10123)	15 - 32	Medium-strength, vibration-proof and shock-resistant for sealing threaded connections up to 1.5". Very good chemical resistance against oils, gases, liquefied petroleum gases, water, hydrocarbons and other industrial media. 55% loss of strength at 100°C.

Overview of AN UV adhesives

Drei Bond	Strength class	Colour	Viscosity [mPa.s/25°C]	Thixotropy	max. thread diameter / gap filling [mm]	Fixture time [min] or [sec]	Functional cure time [h]	Full cure time [h]	Temperature range [°C]	Shear strength [N/mm ²]	Locking torque ISO 10964[Nm]	Application Properties
6066/10	Low	Colourless	30- 50		M5 - 0.07 mm	10 - 20 min	1 - 3 h	3 - 6 h	-55 to +150°C			Flexible, low viscosity and high capillary action. For securing and sealing fastening elements with thread even after assembly (anaerobic, curing in hours) as well as for sealing hairline cracks and porous areas of castings and mouldings (UV, curing in seconds). Very good resistance against heat, corrosion, vibration, gases, oils, hydrocarbons and many other chemicals. UV intensity should be 60 mW/cm ² minimum.
6060	High	Colourless	1200 - 1700		0.03 - 0.3 mm	5 - 10 sec (UV) 20 - 40 min (AN, Spiel < 0.1 mm)			-55 to +120°/150°C		20 - 30	UV/AN high-strength adhesive for metal assemblies. UV curing takes place within seconds and the components are fixed in position. It is cured anaerobically within hours between the metal bonding surfaces. Suitable for bonding/enclosing metal wires where shock resistance is required. The result is a thermoplastic with good tensile properties. We recommend UV lamps with a high intensity of at least 100 mW/cm ² between 365 nm and 420 nm.