

# TECHNICAL DATA SHEET

## Drei Bond 4FIX

Revision: 04.06.2018  
Version: 1.003



### PRODUCT PROPERTIES

General purpose anaerobic adhesive for locking and sealing of threads and flanges. Very clean and accurate dispensing. Very accurate and clean dispensing as a result of innovative packaging.

### PHYSICAL PROPERTIES

Chemical composition	Dimethacrylate
Colour	Green
Viscosity at 20 °C	4,000 – 8,000 mPa.s, thixotropic
Density at 20°C	1.12 g/cm <sup>3</sup>

### CURING PROPERTIES

Tensile strength M10 steel	60-80 min.
Max. gap fill	0.2 mm
Max. thread	1"
Final cure	24 h
Shear strength (DIN 54452)	10-20 N/mm <sup>2</sup>
Breakloose torque (DIN 54454)	20-40 N/mm <sup>2</sup>
Temperature range	-50 - +150°C

### DIRECTIONS FOR USE

- This product is recommended for use on metal surfaces.
- Clean, dry and grease-free surfaces ensure the maximum strength.
- Clean soiled surfaces with Cleaner Drei Bond 3200, Drei Bond Super Cleaner or appropriate solvent. We disadvise the use of cleaners containing acetone.
- Apply product to fill completely the gap, assemble parts and hold on for curing time.
- Disassembly and removal of adhesive residues can be eased by heating to 200° - 250°C or the use of Drei Bond Super Cleaner.

### STORAGE

- 12 months at RT in unopened packaging.
- To avoid contaminations do not refill containers with used product.

### SATEFY AND HANDLING

Please consult the Safety Data Sheet before use.

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### PACKAGE UNITS

- For manual application 35 g
- For industrial use on demand

For automatic processing we recommend to use Drei Bond application systems from stand-by equipments to full automatic CNC-controlled dosing machines.

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