

특징 및 이점

- 쉬운 도포
- 텍소트로 픽
- 실온 경화
- 고강도
- 탁월한 내 화학성
- 음용수 접촉을 위한 WRAS 목록

설명

Permabond® A134는 금속 부품의 영구고정 및 밀봉 용도로 설계된 고강도 험기성 제품입니다. “non-drip” 제형으로 직경이 큰 피팅, 거친 나사산 또는 제품 손상에 의해 공차가 큰 부품 개조에 적합합니다. A134는 부식방지 특성을 제공해 혹독한 환경에서 부품의 수명 연장에 도움이 됩니다.

미경화 접착제의 물리적 특성

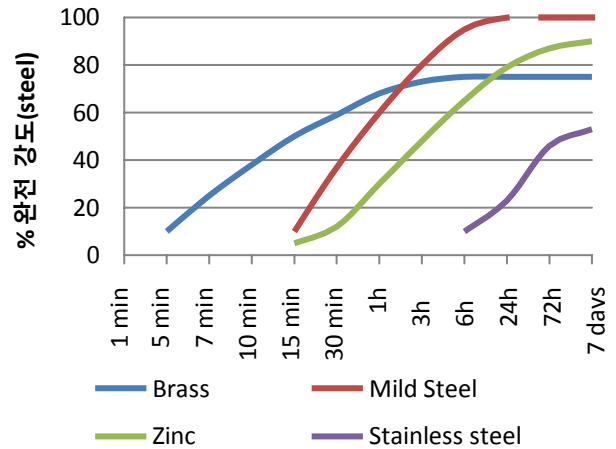
화학 조성	아크릴
외관(색상)	녹색
점도 @ 25°C	2 rpm: 70,000 mPa.s (cP) 20 rpm: 8,000 mPa.s (cP)
비중	1.1
UV 형광검사	가능

대표적인 경화 특성

최대 갭필	0.5 mm 0.02 in
최대 나사 크기	M80 3"
취급 강도 도달 시간 (M10 steel) @23°C	15 분*
작업 강도 도달 시간 (M10 steel) @23°C	1 시간
완전강도 (M10 steel) @23°C	24 시간

*Handling time at 23°C / 73°F. Copper and its alloys will make the adhesive cure more quickly, while oxidised or passivated surfaces (like stainless steel) will reduce cure speed. To reduce curing time, use Permabond activator A905 or ASC10. Alternatively, increasing the curing temperature will reduce curing time.

강도 발달



*Cure times are typical at 23°C. Copper and its alloys will follow the faster cure while oxidised or passivated surfaces like stainless steel will tend towards the slower curve. Lower temperatures or large gaps will tend to extend the cure time. To reduce the cure time the use of Permabond A905, ASC10, or heat can be considered.

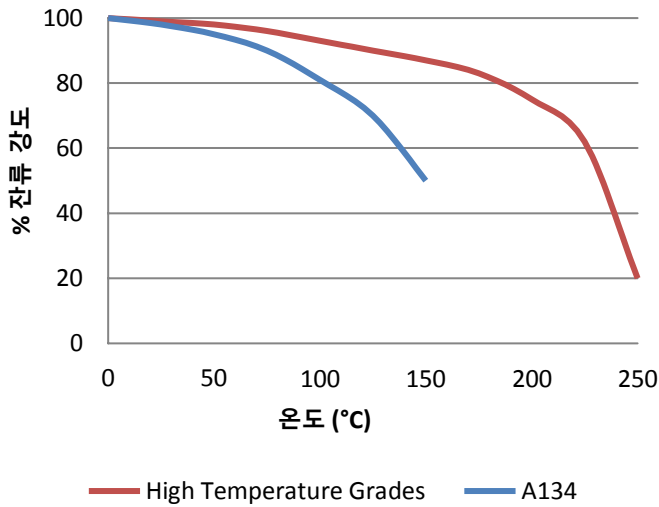
경화된 접착제의 대표적인 성능

토크 강도 (M10 steel ISO10964)	Break 30 N·m 270 in.lb Prevail 50 N·m 450 in.lb
토크 강도 (M10 Zn plated ISO10964)	Break 25 N·m 220 in.lb Prevail 45 N·m 400 in.lb
전단 강도 (steel collar & pin ISO10123)	21 MPa 3000 psi
열팽창 계수	90 x 10 ⁻⁶ mm/mm/°C
유전 강도	11 kV/mm
열 전도도	0.19 W/(m.K)

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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고온 강도



"Hot strength" Breakaway strength on M10 Zinc plated bolts according to ISO 10964. Cured at 23°C for 24 hours then conditioned for 30 minutes at testing temperature.

A134 can withstand higher temperatures for brief periods (such as for paint baking and wave soldering processes) providing the joint is not unduly stressed. The minimum temperature the cured adhesive can be exposed to is -55°C (-65°F) depending on the materials being bonded.

표면 처리

Though the anaerobic adhesives will tolerate a slight degree of surface contamination, best results are obtained on clean, dry and grease free surfaces. The use of a suitable solvent-based cleaner (such as acetone or isopropanol) is recommended. In general, roughened surfaces (~25µm) give higher bond strengths than polished or ground surfaces. To reduce the curing time, especially on inactive surfaces (such as zinc, aluminium and stainless steel), the use of Permabond A905 or ASC10 can be considered.

사용 방법

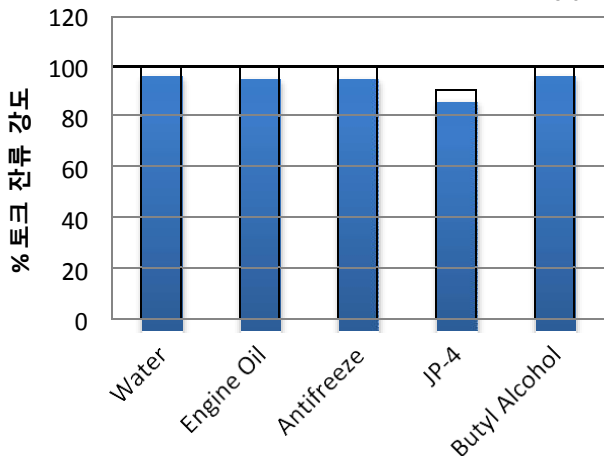
- 1) 암나사 내부에 접착제를 적당량 도포합니다.
트위스트 방식으로 조립합니다.
- 2) 대형 부품이라면 제품이 흘러나가지 않도록 텍스트로픽 제품을 사용합니다.
- 3) 볼 레이스 또는 기타 기구물에 제품이 유입되지 않도록 유의합니다.

비디오 링크

리테이닝 컴파운드 사용방법
<https://youtu.be/MUODE5ZfrZ8>



내화학성



This product is not recommended for use in contact with oxygen, oxygen rich systems and other strong oxidizing materials. This product may adversely affect some thermoplastics and users must check compatibility of the product with such substrates before using.

보관 및 취급

보관 온도	5 - 25°C (41 - 77°F)
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Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Safety Data Sheet.

This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.

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