

TECHNICAL DATA SHEET

BD-AA 277

1. DESCRIPTION:

BD-AA 277 is an anaerobic adhesive designed for permanent locking and sealing of threaded fasteners. BD-AA 277 cures in the absence of air between confined metal surfaces and prevents loosening and leakage caused by vibration and shock. AA277 is used where high strength is required especially in the locking and sealing of larger bolts sizes over M24.

CHARACTERISTICS:

Product Characteristics:

Chemical: Methacrylate Ester
Color and Appearance: Red Liquid
Viscosity: Medium,
Application: Threadlocking
Strength: High
Fluorescence: Positive under UV light
Cure: Anaerobic

Properties of Uncured Material:

Specific Gravity: 1.12
Viscosity @25°C, cps: 5000 - 8000
Flash Point: >90°C
Gap Filling: 0.25 mm

2. CURING AND STRENGTH PERFORMANCE:

The curing speed and the torque strengths depend on the substrates and the gap.

Fixture Time (M10 Black oxide
Bolts and steel nuts) Minutes: 10-20
Functional cure, Minutes: 2 hours
Full Cure: 24 hours
Breakaway torque, N.m. 30-35
(ISO 10964)
Prevailing torque, N.m. 30-35
(ISO 10964)

3. CHEMICAL RESISTANCE:

Solvent/Chemical	°C	% of Strength Retained		
		500h	1000h	5000h
Ethanol	22	95	95	90
Acetone	22	95	95	95
Motor Oil	125	100	100	100
Water/Glycol(50/50)	87	95	90	90
Brake Fluid	22	100	100	100
Unleaded Gasoline	22	100	100	100

4. DIRECTIONS FOR APPLICATION:

The surfaces must be clean without any contamination for best results. Shake the container before use. Do not allow the nozzle tip to touch the metal surface during application, that will avoid clogging in the nozzle. Apply enough material to cover the threads/application area.

5. STORAGE:

The product should be stored between 8°C to 28°C. Once removed from the container do not pour back into the container to prevent contamination.

6. ADDITIONAL INFORMATION

NOTE: Information contained herein is based on tests we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. The Company shall not be liable for any injury, loss, or damage in the use or handling of its chemical products since conditions and use are beyond our control. In every case, we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and suitability for their particular purpose under their own operating conditions. Statements concerning possible use of our products are not intended as recommendations to use our products in the infringement of any patent, or for any particular purpose or application. These products are intended for industrial use only.