






### Features & Benefits

-  Rapid cure
-  Vibration resistant
-  Lubricates threads for easier assembly
-  Provides corrosion protection
-  WRAS drinking water approval

### Description

Permabond® A1042 is a rapid curing adhesive designed to lock and seal metal parts that subsequently may need to be dismantled for maintenance. The high vibration resistance makes Permabond A1042 particularly suited to replacing lock washers, split pins and other mechanical locking devices. The well proven chemical resistance of Permabond A1042 will reduce the effects of corrosion and make it suitable for sealing small hydraulic and pneumatic fittings.

### Physical Properties of Uncured Adhesive

Chemical composition	Acrylic
Appearance	Blue
Viscosity @ 25°C	8000 mPa.s (cP)
Specific gravity	1.08
UV fluorescence	Yes

### Typical Curing Properties

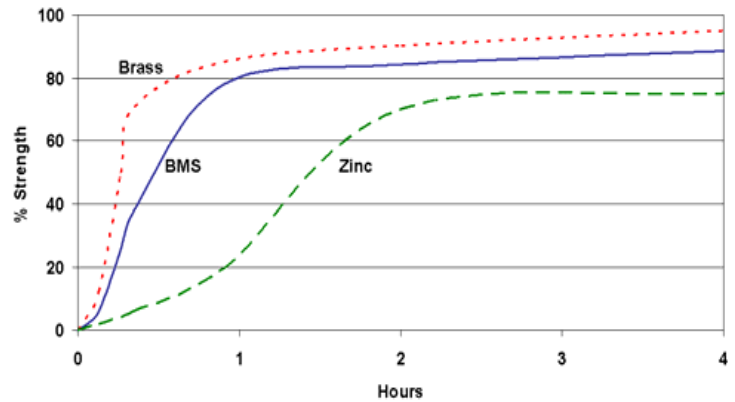
Maximum gap fill	0.12 mm <b>0.005 in</b>
Maximum thread size	M20 ¾"
Handling strength (steel)	5 minutes*
Working strength	30 minutes
Full strength	24 hours

\*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.

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.

No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care® program.

### Strength Development

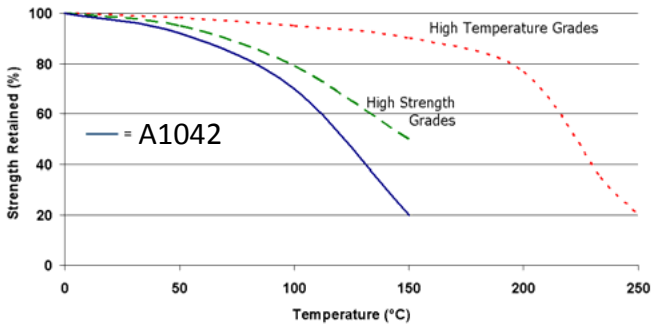


Cure times are typical at 23°C. Copper and its alloys will follow the faster cure while oxidised or passivated surfaces like stainless steel will tend towards the slower curve. Lower temperatures or large gaps will tend to extend the cure time. To reduce the cure time the use of Permabond A905, ASC10,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

### Typical Performance of Cured Adhesive

Torque strength (M10 steel ISO10964)	Break 16 Nm <b>140 in.lb</b> Prevail 7 Nm <b>60 in.lb</b>
Shear strength (steel collar & pin)	12 MPa <b>1700 psi</b>
Coefficient of thermal expansion	90 x 10 <sup>-6</sup> mm/mm/°C
Dielectric strength	11 kV/mm

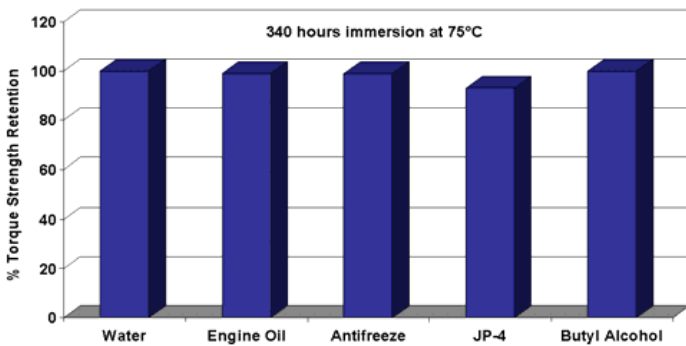
## Temperature Resistance



"Hot strength" shear strength tests performed on mild steel. 24hr cure at room temperature and conditioned to pull temperature for 30 minutes before testing.

A1042 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.

## Chemical Resistance



**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**

## Surface Preparation

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.

## Directions for Use

- 1) Prevent the tip from touching metal surfaces during application.
- 2) When working with through holes, dispense a bead of material across the contact length of the threads.
- 3) When working with blind holes, apply several drops down the threads to the bottom of the hole.
- 4) Assemble and torque the parts as necessary.
- 5) Replace lid to bottle to avoid contamination of remaining liquid adhesive.

## Storage & Handling

Storage Temperature	5 to 25°C (41 to 77°F)
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 Material Safety Data Sheet.	

### Contact Permabond:

**Europe:** Tel. +44 (0)1962 711661  
 UK Helpline: 0800 975 9800  
 Deutschland: 0800 10 13 177  
 France: 0805 11 13 88  
 info.europe@permabond.com

**US:** Tel. +1 732-868-1372  
 Helpline: 800-640-7599  
 info.americas@permabond.com

**Asia:** Tel. +86 21 5773 4913  
 info.asia@permabond.com

[www.permabond.com](http://www.permabond.com)

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.

No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care® program.