

## TECHNICAL DATA

### ThreeBond 1303

### Anaerobic Adhesive – High Strength

**Three Bond 1303** is a powerful high polymer adhesive and sealant. It can be applied to prevent threaded parts from getting loose, leakage and for fixing tiny space between threaded parts. It can also be used as an adhesive and sealant.

#### Features

1. Low viscosity
2. Quick setting at room temperature.
3. When applied to threads and joints, the adhesive hardens quickly at the normal temperature.
4. Good reactivity
5. Adhesive readily reacts and hardens even an inert materials such as surface plated with zinc chromate, chromium and nickel-chromium without adding accelerator.
6. High break loose torque.

#### Characteristics

Item	Units	Characteristics	Remarks
Appearance	-	Green, transparent	
Viscosity (at 25°C)	mPa.s	150	Rotary type viscometer
Specific Gravity	-	1.10	At 25 °C
Fixing time (15%)	min	<10	At 25 °C, Steel screw
Final Hardening	hours	<24	At 25 °C
Break Loose Torque (M10xP1.5) Tightening torque 0 N.m	N.m	>20	
Prevailing Torque (M10xP1.5) Tightening torque 0 N.m	N.m	>25	
Serviceable Temperature	°C	-40 ~ +150	
Optimum clearance	mm	0.01 ~ 0.02	
Maximum clearance	mm	0.005 ~ 0.1	At 25 °C
Maximum bolt size	-	M20	

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## Handling Precautions

### *Cleaning of Works*

While the presence of a small amount of oil on the surface of work does not affect the practical bonding strength, in order to fully utilise the performance of adhesive, it is essential to eliminate oil and dust completely from the work. Oil and grease can be effectively removed by cleaning with organic solvents such as trichloroethane. For the sake of safety, flammability and other reasons, trichloroethane is most recommended. One should avoid using kerosene, gasoline and light oil because they stick to the work.

### *Storage*

Since adhesive sets through chemical reactions, storing it at a higher temperature may shorten the service of life. If stored in a cool place, well ventilated and shaded from the sun, the adhesive kept in a specified container may remain usable for up to 6 months. If it is kept in a refrigerator at 5 ~ 10°C, its life is extended to a year or longer.

### *Shelf Life*

12 months unopened at 10-25°C.

### *Packaging*

In packaging sizes of 50g and 250g.

## Disclaimer

**For Industrial Use Only**

(Do not use for household purposes)

- The data contained in this report are obtained from experimental results, based on our test methods. We cannot assume absolute responsibility for accuracy and safety. Before using this product, use your own judgement to determine whether or not this product meets the requirements of the application and objectives. This includes the burden of responsibility and hazardous danger. The extent of the guarantee provides replacement for products, which are clearly unsatisfactory.
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- We do not assume responsibility without written notice or contract.