



Product code : C9818A

TRABASIL TA2

DESCRIPTION

TRABASIL TA2 is a one-component anaerobic curing adhesive based on acrylic ester. This product cures when confined in the absence of air between close surfaces.

AREAS OF APPLICATION

TRABASIL TA2 can be used for assemblies of parts subjected to high temperatures (up to 220 °C) and to high shear stresses.

TECHNICAL DATA

Appearance before curing	Green, viscous liquid
Appearance after curing	Green, hard plastic
Odor	Soft, characteristic
Viscosity at 25 °C	Brookfield RVT / spindle 2 / 20 rpm : 1,250 ± 125 mPa.s
Density at 25 °C	1.125 ± 0.025
Solubility	Chlorinated solvents
Maximum gap for application	0.20 mm
Cure speed without activator	5 to 30 min (MC-S-50001)
Final setting without activator	4 h (MC-S-50001)
Cure speed with activator	5 to 10 min (MC-S-50047)
Final setting with activator	2 h (MC-S-50047)
Shearing resistance	20 to 35 MPa (12.7 mm diameter, 11.1 mm high cylindrical test samples ; 0.05 mm gap 8 µm roughness) according to ISO 10123 standard
Temperature resistance	-50 to +220 °C
Resistance to lubricant oils and organic solvents	Good
Resistance to water, hydrolic fluids, acids and bases	Good
Specific data	Break torque (ISO 10964) : 20 to 35 N.m (Grade A M10 nuts and bolts with fine pitch threads) Prevail torque (ISO 10964) : 15 to 30 N.m (average of torque readings at 90, 180, 270 and 360 °)

ADVICE

See also material safety data sheet

INSTRUCTIONS FOR USE

Substrate preparation :

Clean and dry parts using the cleaner TRABASIL L, removing dirt and grease. Let evaporate.

Apply activator TRABASIL T only in the following cases :

- When one or both pieces are made of an inactive material (plastic), a low-activity material (stainless steel, pure aluminium, etc.), or a material with a treatment (nickel, zinc, etc.).
- When ambient temperature is lower than 8 °C.
- When the gap is near to the maximum allowable gap for application.
- When it is necessary to accelerate curing.

Application :

Apply a small quantity of adhesive to one end of one of the pieces to ensure distribution when assembling it.

Note: excess of product that remains in contact with air does not cure and does not contribute to bonding. It may be easily removed with a cloth or rinsed off with solvent.

STORAGE AND SHELF LIFE

18 months under 25 °C in closed original packagings

PACKAGING

50 g polyethylene bottles

SAFETY

Irritant. Read material safety data sheet before use.

PRECAUTIONS FOR USE

Avoid any contamination by preventing direct contact of the application nozzle with metal or pre-activated pieces.

Do not return the product to the original bottle.

Do not allow metal bits or shavings entering into the bottle.

Avoid exposure to radiation from electric welding.

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

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