

TECHNICAL DATA SHEET

Drei Bond 5204

Revision: 19.04.2021
Version: 1.006



PRODUCT PROPERTIES

DB 5204 adhesive is a single-component anaerobic adhesive with medium strength class, designed for securing and sealing threaded connections up to 3". It features high vibration resistance.

Recommended for use in industrial facilities. This product holds DVGW (NG-5146AU7072) certificate, allowing its use in gas appliances and systems, as well as certificates for drinking water systems issued by the National Institute of Public Health – National Institute of Hygiene (Poland) and the Water Regulations Approval Scheme (WRAS).

It is resistant to most industrial utilities according to the card "Resistance of Drei Bond Anaerobic Products to Liquids, Gases and Solids".

The product is also resistant to ammonia vapours and gaseous ammonia.

PHYSICAL PROPERTIES

Appearance	liquid
Colour	yellow
Specific weight 25 °C	1,1 g/ cm ³
Viscosity at 25 °C	20 000 – 80 000 mPa·s Brookfield
Gap filling	M80 – 0,30 mm

CURING PROPERTIES

Bold M 10 x 20 Zn – quality 8.8 – nut h = 0.8 d at +25°C:

Handling cure time:	15 – 30 minutes
Functional cure time:	1 – 3 h
Full cure time:	6 – 24 h

Curing rate depends on the gap, assembly clearance, material surfaces and temperature. The use of Drei Bond activator speeds up the curing process.

PROPERTIES IN THE CURED STATE

Shear strength (ISO 10123)	6 – 13 N/mm ²
Locking torque (ISO 10964)	
Breakaway	18 – 24 Nm
Prevailing	7 – 24 Nm
Temperature range:	-55 °C to +150 °C

CHEMICAL RESISTANCE

According to the document "Resistance of Drei Bond anaerobic products to liquids, gases and solids".

TECHNICAL DATA SHEET

Drei Bond 5204

Revision: 19.04.2021
Version: 1.006



STORAGE

- 12 months at RT in unopened packaging.

PACKAGE UNITS

- For manual application 50 ml, 250 ml
- For industrial use 20 kg

DIRECTIONS FOR USE

- Contaminated surfaces should be mechanically cleaned and degreased using Drei Bond Cleaner 3200. The prepared surfaces should be dry.
- Apply a small amount of the adhesive to the thread surface at the joint.

When sealing threaded connections, apply the adhesive to the first three turns of the external thread, evenly over the entire circumference.

- When bonding blind threads, cover the internal thread.
- For form-fit connections, assemble with a rotating motion.
- For press-fit connections, apply the adhesive to both surfaces.
- After 1 minute, do not move the bonded components, as this may break the bonds being formed.
- Increased temperature and the use of an activator accelerate the curing process.
- Heating the bond above +100°C facilitates disassembly and removal of old adhesive residue.

Drei Bond 5930 or 5900 activator should be used in the following cases:

- bonding components at temperatures below +15°C,
- bonding passive components,
- when it is necessary to shorten the technical assembly time.

For automatic processing we recommend to use Drei Bond application systems from stand-by equipments to full automatic CNC-controlled dosing machines.

All information provided is based on our extensive tests and practical experience. The data are given for information only. Drei Bond cannot assume responsibility for the results obtained by others which methods are not under our control. It is user's responsibility to determine suitability for user's purpose of any product mentioned herein. Drei Bond disclaims all warranties expressed or implied, including warranties of fitness for a particular purpose, arising from sale or use of Drei Bond products.