

TECHNICAL DATA SHEET

Drei Bond 4011

Revision: 26.06.2025
Version 1.002



PRODUCT PROPERTIES

Drei Bond 4011 is an activator for anaerobic adhesives and sealants. When used, it accelerates the curing time of anaerobically curing adhesives to approximately 20–120 seconds. The curing time depends primarily on the type of adhesive used, the gap between the parts and the ambient temperature.

The use of Drei Bond 4011 is especially recommended for passivated, oxidized metallic and, generally, inactive surfaces.

When using Drei Bond 4011, the product should be applied to the inactive surface (usually on one side) and the parts should only be joined after the activator has fully evaporated (after a few seconds). Please note that the use of activators may reduce the final strength of the adhesive.

PHYSICAL PROPERTIES

Appearance	green
Viscosity at +25 °C	1 – 2 mPa·s
Density at +25 °C	≈ 0.8 g/ml
Flash point	+21 °C
Activation effect	≈ 24 h (in case the parts are stored properly and well protected against dust and other contaminations, the activation effect can persist for up to 3 months)

DIRECTION FOR USE

- Clean, dry and grease-free surfaces ensure the maximum strength.
- Clean contaminated surfaces with Cleaner Drei Bond 3200, Drei Bond Super Cleaner or appropriate solvent. We disadvise the use of cleaners containing acetone.
- Ensure sufficient evaporation time after cleaning parts.
- Apply a thin layer of activator to the inactive surface. Apply the adhesive to the opposite surface and assemble the parts promptly.
- Only activate both sides if the gap is large.
- Disassembly and removal of adhesive residues can be facilitated by heating to 200 – 250 °C and using Drei Bond Super Cleaner.

