

### Description

Anaerobic adhesive, fast curing, medium strength threadsealant for metal joints. It replaces PTFE tape and yarn. It contains polymeric additives with low friction coefficient simplifying the spin of threaded joints. It provides instant sealing against low pressure or against high pressure within one hour. It seals against gas, air, water, LPG, hydrocarbons, oils and many chemicals, including refrigerants. Pasty consistency avoids dripping during application and curing. It provides a flexible cured film, which is heat and vibrations resistant in the temperature range from -55°C to +150°C. Approved for gas - Gaz de France.

### Physical properties

Composition: anaerobic methacrylate  
 Colour: white  
 Viscosity (+25°C - mPa s): 25.000 - 90.000 thixotropic  
 Friction coefficient  $\mu$ : 0.13  
 Specific weight (+25°C - g/ml): 1,05  
 Fluorescent: under blue light  
 Flash point: > +100°C  
 Shelf life +25°C: 1 year in unopened packaging  
 Gap filling: M 56/ 2"/0,30 mm

### Curing performance

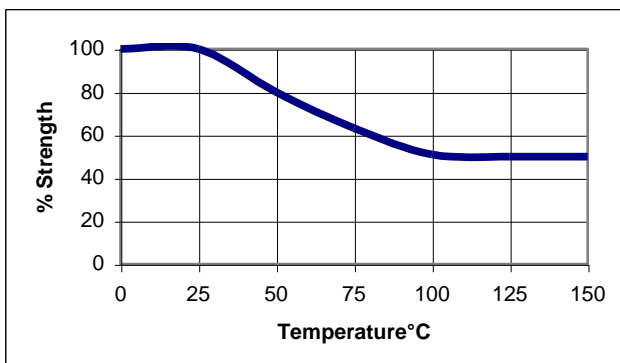
Curing rate depends on the assembly clearance, material surfaces and temperature. Functional strength is usually reached in 1 - 3 hours and full curing takes 24 - 36 hours. In case of passive surfaces and/or low temperature, a fast cure can be obtained using Loxeal Activator 11.

### Curing properties

Bolt M10 x 20 Zn - quality 8.8 - nut h = 0,8 d at +25°C  
 Handling cure time: 5 - 10 minutes  
 Functional cure time: 0.5 - 1 hours  
 Full cure time: 3 - 6 hours  
 Locking torque (ISO 10964):  
 - breakaway: 18 - 25 N m  
 - prevailing: 10 - 20 N m  
 Shear strength (ISO 10123): 6 - 13 N/mm<sup>2</sup>  
 Temperature range: -55°C/ +150°C

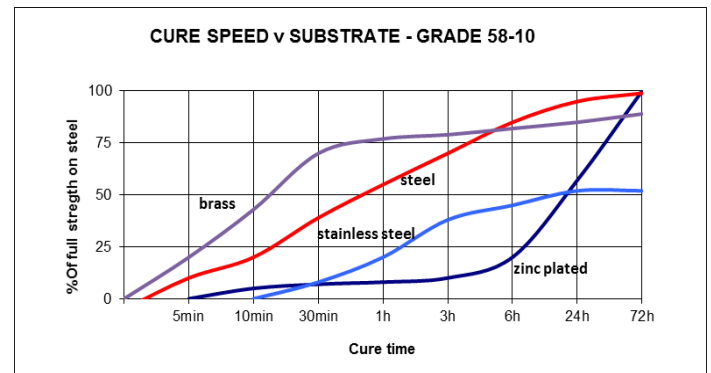
### Environmental resistance

The graph below shows the mechanical strength vs. temperature. ISO 10964 - Bolt M10 x 20 Zn - quality 8.8 - nut h = 0,8 d at +25°C - pre-torque 5 N m.



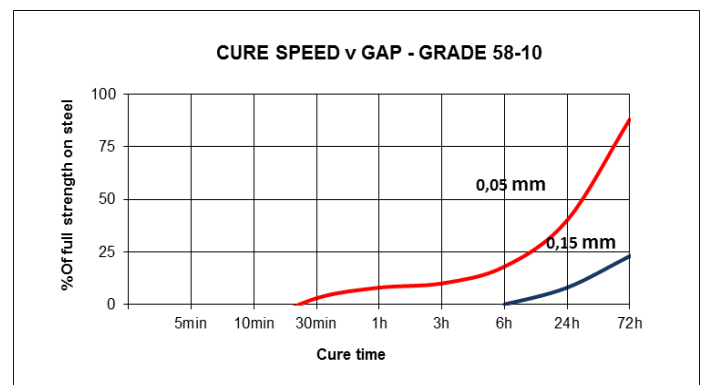
### Cure speed vs substrate

The graph below shows the breakaway strength developed with time on M10 x 20 steel specimen on different substrates. Tested according to ISO 10964 at +25°C.



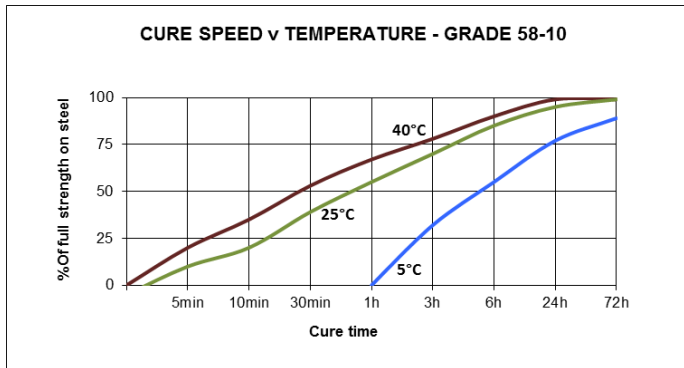
### Cure speed vs gap

The graph below shows the product shear strength (as %) at different increasing controlled gaps. Steel pins/collars, tested in accordance with ISO 10123 at +25°C.



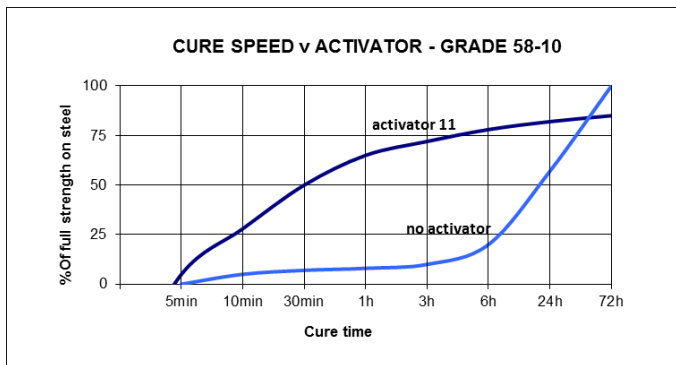
**Cure Speed vs Temperature**

The following graph shows the breakaway strength of the product (as %) at different temperatures. Steel nuts/bolts M10 x 20, tested according to ISO 10964.



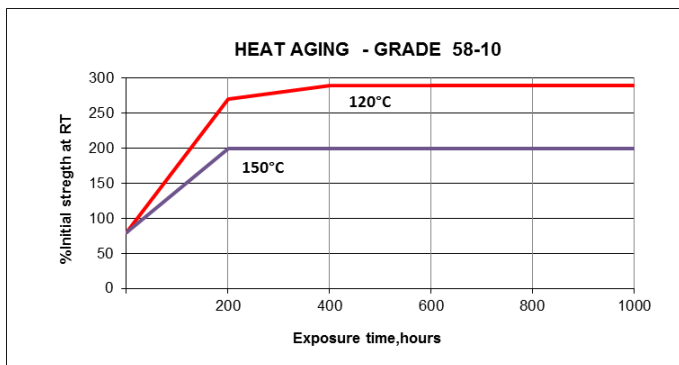
**Cure Speed vs Activator**

Polymerization could be slowed down by substrate nature, large gaps; cure speed can be improved by applying appropriate activator to the substrate(s). The following graph shows the breakaway strength of the product (as %) and the cure speed developments using our activator 11 compared to the ones with no activator. Zn nuts/bolts M10 x 20, tested according to ISO 10964 at a temperature of +25°C.



**Heat ageing**

The graph below shows the strength resistance behavior as a function of temperature/time. Zn nuts/bolts M10 x 20 - (pre-torque of 5 N m, cured 7 days at +25°C) - aged at temperature indicated and tested at +25°C according to ISO 10964.



**Chemical resistance**

Aged under conditions below after 24 hours from polymerisation at indicated temperature.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
Motor oil	125	excellent	excellent	excellent
Gear box oil	125	excellent	excellent	good
Gasoline	25	slight	slight	slight
Water/glycol 50%	87	excellent	excellent	excellent
Brakes oil	25	slight	slight	slight

\*For information on resistance with other chemicals, contact Loxeal Technical Service.

**Directions for use**

Loxeal Threadsealing are anaerobic resins that cure when confined between two metal surfaces in absence of air (ex. threaded joint).

Some recommendations for best results:

- Clean the threads with Loxeal Cleaner 10 and allow drying before assembling (water, oil or dirtiness prevent sealant's full adhesion on threaded parts).

- Apply a bead of product along the entire circumference between the first and the second thread of the male in sufficient quantity to fill the entire threaded surface.

For product with higher viscosity, apply a small amount on the female thread too, to ensure the correct filling of the threaded joint during assembly.

- Rotate occasionally back and forth during the manual screwing to adjust the distribution of the product on the threads.

- Once the screwing is complete, seal the joints with usual torque down by the product's specific handling cure time.

Handling cure time (mentioned above on page 1/3) depends on the type of substrate and relates to the following use conditions:

- Steel, carbon or cast iron fittings
- Environmental temperature at 25°C
- Gap within specific tolerances

Shorter handling cure time relates to the following:

- Brass or bronze fittings
- Summer temperatures
- Small gaps

While longer handling cure time relates to the following:

- Inox or passivated (chrome, etc) fittings
- Winter temperatures (temperatures close to 0°C may prevent the curing)
- Large gaps

If the above conditions happen, we recommend the usage of Loxeal Activator 11.

**Disassembly and cleaning**

To disassemble the pieces, use conventional tools. When possible, disassembly is made easier by heating pieces at +150°C/+250°C and hot disassembling them.

Remove the cured product mechanically and finish cleaning with Acetone.

**Warnings**

This adhesive is not approved for usage with neither pure nor with gaseous oxygen.

It is not suitable for applications on plastics.

The liquid product may damage paints and elastomers. If the product gets in contact, even accidentally, with some thermoplastics, stress cracking of the plastics could happen.

**Storage**

Keep product in a cool and dry room at no more than + 25°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxeal Technical Service

**Safety and handling**

Consult Material Safety Data Sheet before use.

**Note**

The data contained herein, obtained in Loxeal laboratories, are given for information only; if specifics are required, please contact Loxeal Technical Department.

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