

LOXEAL 24-18

Description

Low strength anaerobic adhesive for thread locking of nuts, bolts and screws of all types that require to be easily dismantled. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.

Physical properties

* Composition:	anaerobic methacrylate
* Colour::	purple
* Fluorescence:	under blue light
* Viscosity (25°C - mPa.s):	800 - 1400
* Specific weight (25°C - g/ml):	1,05
* Max diameter of thread/gap filling:	M 24 / 0,20 mm
* Flash point:	> 100°C
* Shelf life 25°C:	1 years

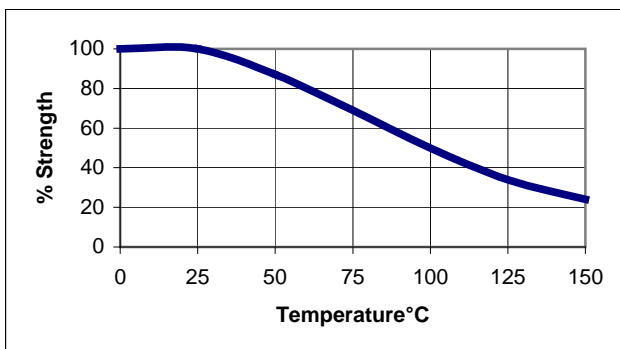
Curing performance

The rate of cure depends on the substrate used, on the gap and on the temperature. The functional strength is reached usually after 1-3 hours. The full cure takes 24 – 36 hours. In case of passivated surfaces and/or low temperature we recommend the usage of Loxeal Activator 11.

Environmental resistance

The graph below shows the mechanical strength vs. temperature.

Steel specimen – ASTM 1002/DIN 53283



Curing properties

Bolt zinc M 10 x 20 - quality 8.8 - Nut h = 0,8.d at 25°C

* Handling cure time:	15 - 30 minutes
* Functional cure time:	1 – 3 hours
* Full cure time:	5 - 10 hours
* Shear strength(ISO 10123):	3,0 - 5,0 N/mm ²
* Locking torque (ISO 10964):	
- breakway:	5 - 8 N.m
- prevailing:	2 - 5 N.m
* Temperature range:	-55 +150°C

Chemical resistance

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

Substance	°C	Resistance after 100 h	Resistance after 1000 h	Resistance after 5000 h
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Motor oil	125	excellent	good	good
Gear box oil	125	excellent	good	good
Gasoline	25	excellent	excellent	excellent
Diesel fuel	25	excellent	good	good
Water/glycol 50%	87	good	good	good
Brakes oil	25	excellent	excellent	good

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

Directions for use

The product is recommended for use on metal surfaces. Clean and degrease parts to bond with Loxeal Cleaner 10. Apply product in enough quantity to fill the gap. Put together parts and wait till product is cured. The product in liquid form may damage coated parts and elastomers and the contact with some thermoplastics may induce stress-crackings non immediately evidenced. For application on non metal parts, contact Loxeal Technical Service. For disassembly, use normal tools and eventually heat pieces at 150/250°C, remove any residue of cured product mechanically and clean pieces with Acetone.

Storage

Keep product in a cool and dry room at +25°C. To avoid contaminations do not refill containers with used product. For more information on applications, storage and handling contact Loxeal Technical Service

Safety and handling

Consult Material Safety Data Sheet

Note

The data contained herein, obtained in Loxeal laboratories, are given for information only. Loxeal cannot assume responsibility for the results obtained by others which methods are not under Loxeal control. It is the user's responsibility to determine suitability for the user's purpose of any product mentioned herein. Loxeal disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loxeal products. Loxeal specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.