

## LOXEAL 55-04

### Description

Medium viscosity anaerobic adhesive for thread locking of large diameter studs, nuts and bolts of all types that require to be dismantled.

Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.

### Physical properties

* Composition:	anaerobic methacrylate
* Colour::	red
* Fluorescence :	under blue light
* Viscosity (25°C - mPa.s):	1.500 – 8.600
* Specific weight (25°C - g/ml):	1,05
* Max diamter of thread/gap filling:	M36 - 0,25 mm
* Flash point:	> 100°C
* Shelf life 25°C:	1 year

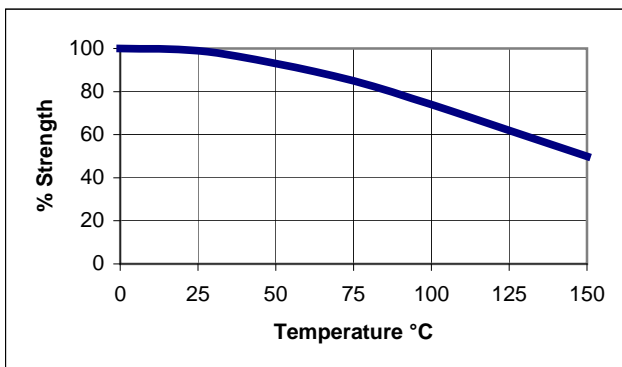
### Curing performance

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.

### Environmental resistance

The graph below shows the mechanical strength vs. temperature.

Steel specimen – ASTM 1002/DIN 53283



### Curing properties

Bolt M 10 x 20 - quality 8.8 - Nut h = 0,8.d at 25°C	
* Handling cure time:	10 - 15 minutes
* Functional cure time:	1 - 3 hours
* Full cure time:	3 - 6 hours
* Shear strength (ISO 10123):	10 - 15 N/mm <sup>2</sup>
* Locking torque (ISO 10964)	
breakaway:	20 - 25 N.m
prevailing:	40 - 50 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 500 h	Resistance after 1000 h
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Motor oil	125	Good	Discrete	Discrete
Gear box oil	125	Discrete	Discrete	Discrete
Gasoline	25	excellent	excellent	excellent
Water/glycol 50%	87	excellent	Good	Good
Brakes oil	25	excellent	excellent	excellent

\* 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 before bonding with Loxeal Cleaner 10.

Apply product to fill completely the gap, assemble parts and hold on for curing time. Liquid product can damage coating, some plastics and elastomers and late stress-cracking events might be induced if used with some thermoplastics.

For application on non metal materials, 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 parts with Acetone.

**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

**Note**

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