

LOXEAL 15-36

Description

Anaerobic sealant for thread connections allowing easy dismantling of parts. DIN-DVGW approved for gas (Reg. nr. NG 5146AT0263). Upon curing will give an elastic film to replace yarn, P.T.F.E. tapes, and solid gaskets for the sealing of gas, air, water, LPG, oils, hydrocarbons and many chemicals. Easy to dismantle. Shocks and vibrations resistant, it will keep unaffected properties of sealing in the range of temperature from -55°C to +180°C.

Physical properties

Composition:	anaerobic methacrylate
Colour:	blue
Viscosity (+25°C - mPa s):	3.000 - 6.000
Specific weight (+25°C - g/ml):	1,02
Fluorescent:	under blue light
Max diameter of thread/gap filling:	M 56 / 2" / 0,30 mm
Flash point:	>+100°C
Shelf life:	1 year at +25°C in unopened packaging

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.

Curing properties

Bolt M10 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 hours
Full cure time:	5 – 10 hours
Locking torque (ISO 10964)	
- breakaway:	8 – 14 N m
- prevailing:	4 – 8 N m
Shear strength (ISO 10123):	4 – 6 N/mm ²
Temperature range:	-55°C/+180°C

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 +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 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. Loxeal ensures abiding quality of supplied products according to its own specifics. Loxeal cannot assume responsibility for the results obtained by others which methods are not under Loxeal control. It is user's responsibility to determine suitability for 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.