

Technical Data Sheet

# **LOXEAL 83-55**

Registered Quality and Environment Management System Company

# Description

High strength anaerobic adhesive for locking and sealing of studs, nuts, bolts and threaded fasteners not requiring dismantling. It can be used on all metals either on free or forced matings.

It provides high resistance to heat, corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals.

## **Physical properties**

Composition : anaerobic methacrylate

Colour: red
Viscosity (+25°C - mPa s): 450 - 650
Specific weight (+25°C - g/ml): 1,1
max diameter of thread/ gap filling: M 20/0,15 mm
Flash point: > +100°C
Shelf life +25°C: 1 year in original unopened packaging

## **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  $+25^{\circ}$ C: Handling cure time: 10 - 20 minutes Functional cure time: 1 - 3 hours Full cure time: 5 - 10 hours

Locking torque (ISO 10964):

- breakaway : 25 - 35 N m - prevailing : 50 - 65 N m Shear strength (ISO 10123) : 15 - 20 N/mm² Temperature range : - 55°C/+150°C

#### 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°C/+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 before use.

#### Note

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