

LOXEAL 85-02

Description

Fast curing high temperature resistant. High strength anaerobic adhesive for locking and sealing threaded connections and retaining of cylindrical parts. Medium thixotropic effect, allows larger machining tolerances. Highly resistant to corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals.

Physical properties

Composition: anaerobic methacrylate
 Color: green
 Fluorescence: under blue light
 Viscosity (+25°C - mPa s): 3000 - 4000 thixotropic
 Specific weight (+25°C - g/ml): 1,1
 Gap filling: M36 / 1- 1/2" - 0,20 mm
 Flash point: > +100°C
 Shelf life +25°C: 1 year in 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°C:

Handling cure time:

- Steel: 1 - 4 minutes
 - Zinc plated steel: 3 - 6 minutes
 - Aluminum: 6 - 18 minutes

Functional cure time: 1 - 3 hours

Full cure time: 2 - 4 hours

Locking torque (ISO 10964):

breakaway: 30 - 40 N m

prevailing: 55 - 70 N m

Shear strength (ISO 10123): 25 - 30 N/mm²

Impact strength (ASTM D950): 5 - 12 kJ/m²

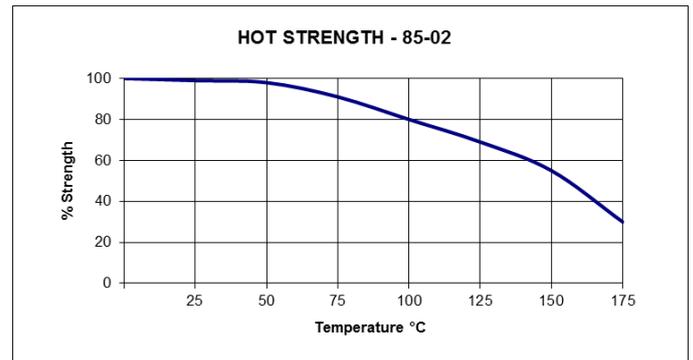
Temperature range: -55°C/+175°C

Environmental resistance

Hot strength

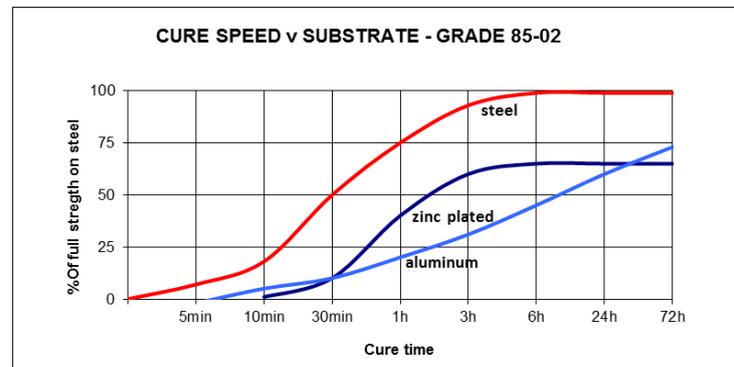
The graph below shows the mechanical strength vs. temperature.

Specimens - steel pin/collars tested in accordance with ISO 10123.



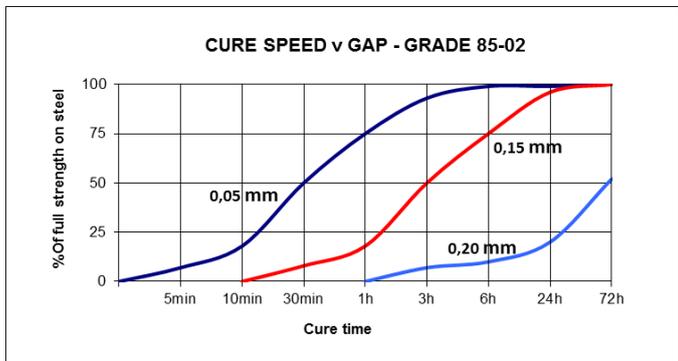
Cure speed v substrate

The graph hereunder shows the breakaway strength development of the product (with time) on steel pin/collars tested in accordance with ISO 10123 at +25°C.



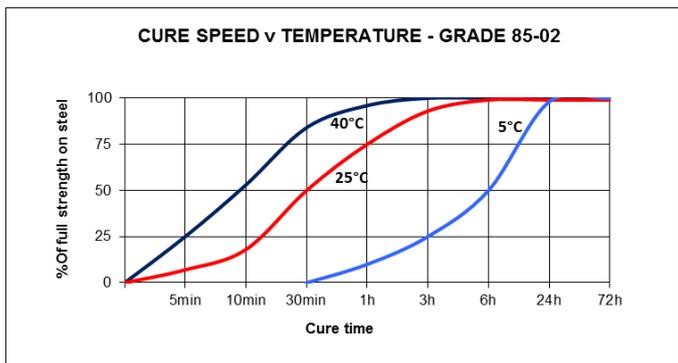
Cure speed v gap

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



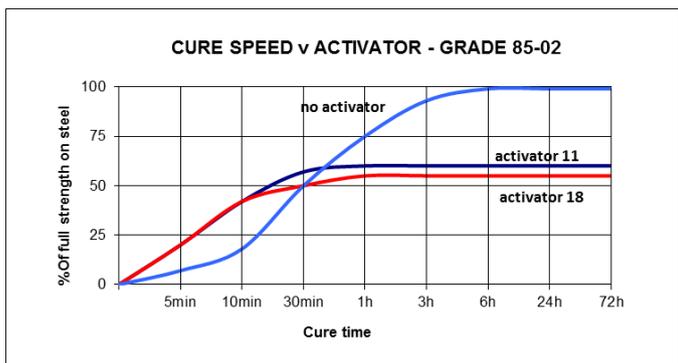
Cure speed v temperature

The following graph shows the breakaway strength of the product (as %) at different temperatures.
Specimens – steel pin/collars tested in accordance with ISO 10123.



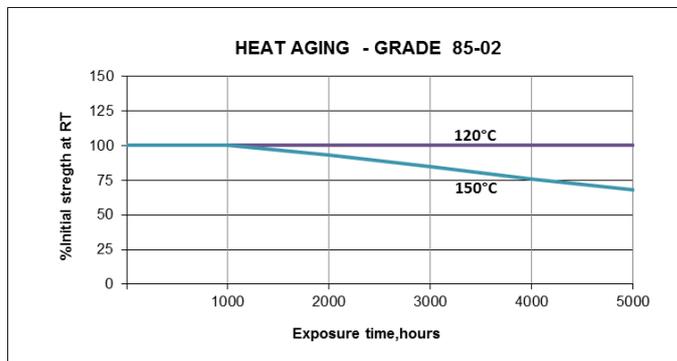
Cure speed v activator

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 and 18 respectively, compared to the ones with no activator.
Specimens – steel pin/collars tested in accordance with ISO 10123.



Heat aging

The graph below shows the strength resistance behavior as a function of temperature/time .
Specimens – steel pin/collars tested in accordance with ISO 10123, at + 25°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	excellent	excellent	excellent
Gear box oil	125	excellent	excellent	excellent
Gasoline	25	excellent	good	good
Water/glycol 50%	87	excellent	discrete	discrete
Brakes oil	25	excellent	good	discrete

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

Directions for use

1. Clean the surfaces with Loxeal Cleaner 10 and allow to dry.
2. Curing time may be slower if gaps are large and/or on inactive surfaces: the use of Loxeal Activator 11 can be considered to reduce it.
3. Shrink fitted assemblies: to heat the collar, apply the adhesive to the pin. To cool the pin, apply the adhesive to the collar. If both heating and cooling are required, apply the adhesive to the cooled part avoiding condensation.
4. Press fitting assemblies: apply the adhesive on the pin and collar and assemble to the required pressure using a press.
5. Slip fitted assemblies: apply the adhesive on the leading edge of the pin and on the inside of the collar. Assemble with twisting action to ensure full coverage.
6. Allow the parts to achieve functional strength before subjecting them to any service loads.

When used as a sealant: apply a bead of adhesive to 360° between the first and second male thread, screw the female giving the desired pre-torque. For large diameter fittings and threads, apply the adhesive on both parts.

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. 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.