

**Description**

Anaerobic adhesive for metals, high strength, to lock and seal threaded joints.

Approved for use with drinking water according to TZW-DVGW approved for gas-tight threaded joints according to EN 751-1 (DIN DVGW approval no. 5146AR0573-NG).

The product is certified (BAM-Berlin) for use as sealant in the presence of gaseous oxygen up to 20 bar at +60°C.

Can be used on all metals, both in free or forced matings.

Maintains the sealing properties up to +200°C.

High resistance to thermal shock, vibration, water, gas, oils, fuels, refrigerant fluids and other chemicals

**Physical properties**

Composition : anaerobic methacrylate  
Colour : green  
Fluorescence : under blue light  
Viscosity (+25°C - mPa s) : 2.200 - 4.000  
Specific weight (+25°C - g/ml) : 1,12  
Gap filling : M56/2" / 0,30 mm  
Flash point : > +100°C  
Shelf life +25°C : 1 year in original unopened packaging

**Curing performance**

Curing rate depends on the assembly gap, substrates 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, even if its use may reduce the final strength.

**Curing properties**

Bolt M10 x 20 Zn - quality 8.8 - nut h = 0,8 d at +25°C

Handling cure time : 10 - 40 minutes  
Functional cure time : 6 - 12 hours  
Full cure time : 24 - 36 hours  
Locking torque (ISO 10964) :  
breakaway : 25 - 35 N m  
prevailing : 40 - 55 N m  
Shear strength (ISO 10123) : 15 - 25 N/mm<sup>2</sup>  
Temperature range : -55°C/+200°C

**Chemical resistance**

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

Substance	°C	Resistance after 100 h	Resistance after 1000 h	Resistance after 5000 h
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Motor oil	125	excellent	excellent	excellent
Gear box oil	125	excellent	excellent	excellent
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 substrates. 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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