Technical Data Sheet

LOXEAL 86-72

Description

Very high temperature (+230° C) resistant, high strength anaerobic adhesive for locking and sealing thread connections and fitted parts.
High viscosity and thixotropic effect allow larger tolerances.
Highly resistant to corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals.
DIN DVGW approved thread sealant for gas (according to DIN EN 751-1 Reg. Nr. NG - 5146AT0264).

Physical properties

* Composition:	anaerobic methacrylate
* Colour:	opaque red, thixotropic
* Fluorescence:	under blue light
* Viscosity (25°C - mPa.s)	5.000 – 28.000
* Specific weight (25°C - g/ml):	1,1
* Gap filling:	M56 2 " - 0,30 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.

Curing properties

Zinc plated bolt M 10 x 20 - quality 8.8 - Nut h = 0,8.d at 25*C

* Handling cure time:	20 - 40 minutes
* Functional cure time:	3 - 6 hours
* Full cure time:	24 hours
* Shear strength(ISO 10123):	10 - 20 N/mm²
* Locking torque (ISO 10964):	
breakaway:	25 - 35 N.m
prevailing:	45 - 70 N.m
*Retained torque at 150 °C:	70 – 80%
* Temperature range:	-55 +230°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 150/250°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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