

### Description

Medium strength anaerobic adhesive for retaining of bearings, liners, bushes, keys and splines.  
Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.

### Physical properties

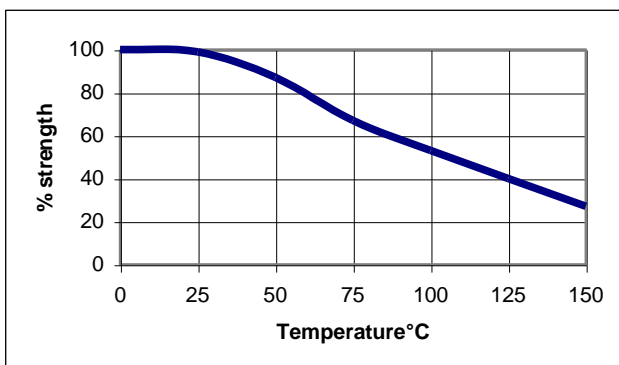
Composition : anaerobic methacrylate  
Colour : yellow  
Fluorescence : under blue light  
Viscosity (+25°C - mPa s) : 400 - 650  
Specific weight (+25°C - g/ml) : 1,05  
Gap filling : M20 - 0,12 mm  
Flash point : > +100°C  
Shelf life +25°C : 1 year in original unopened packaging

### 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.

### Environmental resistance

The graph below shows the mechanical strength vs. temperature.  
Steel specimen - ISO 4587



### Curing properties

Bolt M10 x 20 Zn - quality 8.8 - nut h = 0,8 d at +25°C  
Handling cure time : 10 - 20 minutes  
Functional cure time : 1 - 3 hours  
Full cure time : 3 - 6 hours  
Shear strength (ISO 10123) : 8 - 12 N/mm<sup>2</sup>  
Impact strength (ASTM D-950) : 1 - 5 kJ/m<sup>2</sup>  
Locking torque (ISO 10964)  
breakaway : 11 - 20 N m  
prevailing : 15 - 25 N m  
Temperature range : -55°C/+150°C

### Chemical resistance

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

Substance	°C	Resistance after 100 h	Resistance after 1000 h	Resistance after 5000 h
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

Substance	°C	Resistance after 100 h	Resistance after 1000 h	Resistance after 5000 h
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 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**

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.

ST5311e/4 09/12 Pag. 2/2