



LOXEAL®

ENGINEERING ADHESIVES

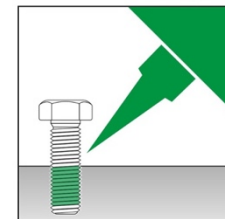
PUT IT ON & GO TO SLEEP



HIGH STRENGTH THREADLOCKING ADHESIVE

LOXEAL 86-72

Technical Data



Overview:

Loxeal® 86-72 Very High Temperature Resistant (230°C), High Strength Anaerobic Adhesive for locking and sealing thread connections and fitted parts. High viscosity and thixotropic effect allow a larger tolerances. High resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.

Health & Safety Approval

DIN DVGW approved thread sealant for gas (according to DIN EN 751-1 Reg. Nr. NG – 5146AT0264)

Physical Properties:

Adhesive Type:	Anaerobic Methacrylate
Colour:	Opaque Red
Specific Weight (+25°C g/ml):	1.1
Viscosity at +25°C (mPas):	5,000 – 28,000
Gap Filling:	M56 / 2" / 0.30 mm
Flash Point:	> +100°C
Shelf Life:	12 months at 25°C 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.

Storage:

We recommend to store this product in a cool and dry place at temperature not exceeding +25°C. To avoid contaminations, do not refill containers with used products. For more information on applications, storage and handling, contact Loxeal Technical Service.

Safety and Handling:

Consult the Safety Data Sheet before use.

Curing Properties:

Bolt M10 x 20 ZN – quality 8.8 – nut h = 0.8 d at +25°C	
Handling cure time:	20 – 40 minute
Functional cure time:	3 – 6 hours
Full cure time:	24 hours
Locking torque (ISO 10964):	
- Breakaway:	25 – 35 Nm
- Prevailing:	40 – 70 Nm
Shear Strength (ISO 10123):	10 – 20 N/mm ²
Temperature range:	-55°C to +230°C

Direction 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 the gap completely, 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 to +250°C, remove any residue of cured product mechanically and clean parts with acetone.

Note:

The data contained herein, obtain 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 the sale or use of Loxeal products. Loxeal specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.

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