

Product Description

MXLOC[®] 62 is designed for sealing and locking of metal fasteners. The product is a red color, highly viscous single component acrylic based material. The product cures in the absence of air, the product can be further accelerated by the use of Activator 7649.

MXLOC[®] 62 offers the following characteristics:

Chemistry	Acrylic
Appearance (uncured)	Red liquid
Base chemical	Dimethacrylate ester
Fluorescence	Positive under UV
Cure	Anaerobic
Secondary cure	Activator
Components	Single – requires no mixing
Viscosity	Medium
Strength	Medium
Application	Threadlocking

MXLOC[®] 62 is suitable for uses in metals including steel, aluminum and among other metal substrates; in particular it is used zinc phosphate coated nut and bolt in heavy duty applications, such as nuts onto studs in pump housings and studs into motor housings.

Chemical and physical properties of the uncured material

	Typical Value
Specific Gravity @ 25 °C	1.1
Viscosity @ 25 °C	1,200 – 2,400 cPs
Flash Point	See MSDS
Fixture Time	15 mins
Full cure Time	24 hrs

Cure speed vs. substrate

The cure speed and full cure strength are substrate dependent.

Cure speed vs. temperature

The cure speed is dependent on the application temperature; the higher the temperature, the faster the cure.

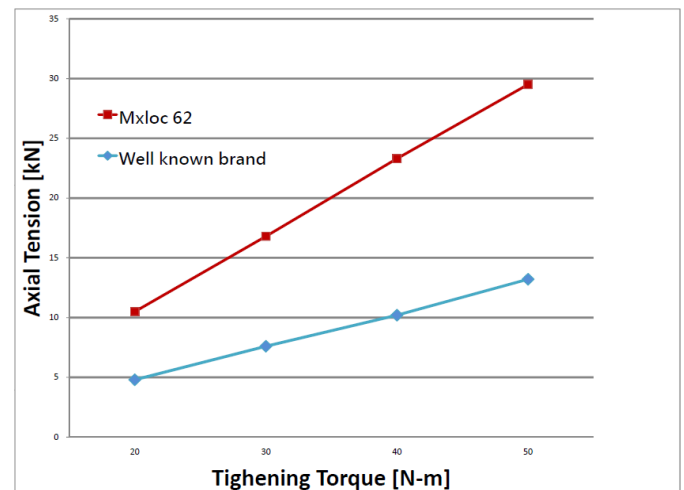
Typical performance of cured material

Operating temperature Typical Value
 (After 24 hr at 20-25°C on M10 steel nuts & bolts) -54 °C - 150 °C

	Typical Value
Breakaway Torque M10 steel bolts & nuts ISO 10964	28 Nm
Prevail Torque M10 steel bolts & nuts ISO 10964	32 Nm
Breakaway Torque M10 Zinc phosphate bolts & nuts ISO 10964	24 Nm
Prevail Torque M10 Zinc phosphate bolts & nuts ISO 10964	20 Nm

Axial Tension vs. Torque

Axial tension is just as important as torque strength in the new concept of fastening nuts and bolts, especially for a nut and bolt larger than M10.



Cure speed vs. activator

The product can be further accelerated by the use of Activator 7649 under the circumstances where the cure time is too long or large gaps are present. An activator can be applied to the surface to improve the cure speed.

General information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be use with chlorine or other strong oxidizing materials.

For information on the safe handling of this product, consult the Material Safety Data Sheet, (MSDS).

Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases these solutions can affect the cure and performance of the adhesive. This product is not recommended for use on certain plastics. Users are recommended to confirm compatibility of the product with such substrates.

Storage & Handling precaution

Keep adhesive in a cool and dry place. The storage temperature is recommended at 8 °C – 24 °C. For details, consult the Material Safety Data Sheet, (MSDS). Shelf life is twelve months from the date of manufacture in the original container under the optimal conditions.

1. Avoid contact with skin and eyes.
2. If contact with skin, rinse with water.
3. If adhesive gets into eye, keep eye open and rinse with water thoroughly. Seek medical attention immediately.
4. Keep the material out of children's reach.

Directions for use

For assembly

1. The substrate surfaces must be clean and free of grease.
2. Shake the product thoroughly before use.
3. If the cure speed is too slow, consider using activator.
4. Apply several drops to the nut & bolt.
5. Assemble and tighten as required.
6. To prevent the clogging of the bottle nozzle, do not let the tip touch the metal surfaces during application.

For disassembly & cleanup

1. Use localized heat (250 °C) to nut and bolt, disassemble while hot.
2. Use a wire brush to clean the charred product.

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