PRODUCT SPECIFICATION

MXLOC® 510

Anaerobic Adhesive (Sealing)

Description:

MXLOC® 510 is designed for the sealing of gaskets. The product is a single component anaerobic, thixotropic acrylic based adhesive. The product cures when confined in the absence of air between close fitting metal surfaces. It seals close fitting joints between flanges and fixed metal faces and will flex with minor movement from the flange.

Typical Properties:

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Base	Acrylic
Chemical Form	Dimethacrylate ester
Colour	Red
Fluorescence	No
Cure	Anaerobic
Secondary Cure	Activator
Specific Gravity @ 25°C	1.1
Working Temperature	-54°C-200°C
Fixture Time	1-2 hours
Viscosity at 25°C	200,000-750,000 cP *(High, Thixotropic)*
Strength	Medium
Application	Sealing
Shelf Life	12 Months

Bond Strength:

(Shear Strength, Steel Pins & Collars, ISO10123, cured for 24 hours at 20-25°C)

Substrate	Typical Strength (N/mm^2)
Steel	8

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Cure Performance:

Cure Speed vs Substrate

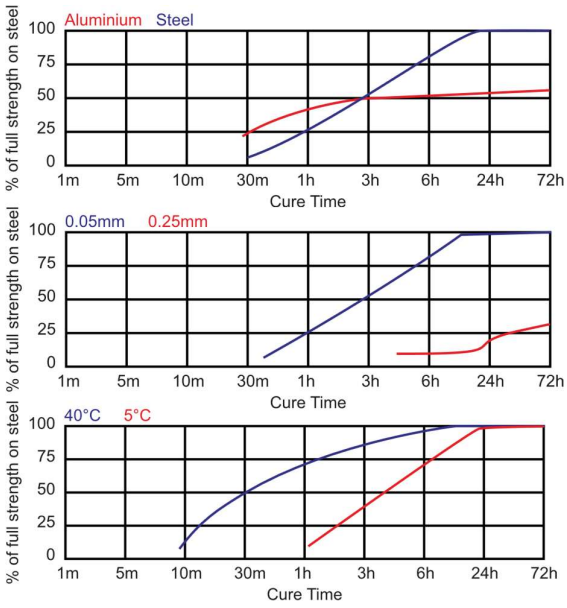
The rate of cure is dependent on the substrate used. The graph to the right shows the breakaway strength developed with time on steel collars and pins compared to different materials and tested according to ISO 10123

Cure Speed vs Bond Gap

The rate of cure is dependent on bond gap. The graph to the right shows shear strength developed with time on steel collars and pins compared to different controlled gaps and tested according to ISO 10123

Cure Speed vs Temperature

The rate of cure is dependent on the ambient temperature. The graph to the right shows shear strength developed with time on steel collars and pins compared to different controlled gaps and tested according to ISO 10123



Chemical/Solvent Resistance:

(Aged under conditions indicated and tested at 22°C)

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Motor oil (MIL-L-46152)	125	100	100	100
Unleaded Petrol	22	95	60	60
Water/Glycol 50/50	87	160	110	110

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General Information:

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with Chlorine or other strong oxidising materials**. For information on the safe handling of this product, consult the Safety Data Sheet, (SDS)**. 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.

Directions For Use:

1. For optimum performance, surfaces should be clean and free of grease (internal and external).
2. If the material is an inactive metal, consider using MXLOC® Activator.
3. Shake the product thoroughly before use.
4. Apply as a continuous bead to the surface.
5. Assemble and tighten as required.
6. To prevent the clogging of the nozzle, do not let the tip touch the metal surfaces during application.

Handling & Storage:

Storage: Keep products in the unopened container in a cool dry location. The product is best when stored at 8 to 24°C.Do not freeze. Keep the container tightly closed until ready for use.
Handling: Material removed from containers may be contaminated during use. Do not pour back any product to the original container. Misuse of product will void all warranties.

Disclaimer:

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