

## Instructions for LOXEAL GLUE

All the LOXEAL adhesives in our product line are anaerobe adhesives which are hardening without the presence of oxygen. The hardening of the glue is a catalytic process initiated from the lack of oxygen and the presence of free cobber ions which are present in most metals. This means however that joints of e.g. stainless steel or other inactive metals needs an activator (A11) before glued, because inactive metals contain hardly any free cobber ions – these are added when using the activator.

The glues in our product line can be divided into three sections:  
Thread sealant, Thread locking and Retaining.

### THREAD SEALANT

LOXEAL thread sealant locks and seals thread joints against water, heat, gas, air, oil, hydrocarbons and many chemicals. LOXEAL is heat- and vibration stable. The sealants are available in various degrees of locking.

Various types: 18-10, 53-14, 58-11, 86-72.

1. Wipe the joint you want sealed with a cloth to remove oil and dirt - you do not have to use any detergent.
2. Add glue on the outside thread in a suitable amount; make sure to cover all the first 3 -4 threads.
3. Assemble the joint. After 20-30 min. the joint is handling-dry. After 1-3 hours the joint is hardened and ready for use. The glue is fully cured after 24 hours.  
Beware: When using the 86-72 the harden time can be up to 6 hours.  
The hardening time depends mainly of temperature and thread-tolerances.

### THREAD LOCKING

LOXEAL thread locking is ideal for locking nuts, threaded pins, screws and other thread connections. Thread joints are secured against loosening caused by vibrations and or mechanical stress.

Various types: 55-03, 83-54, 86-72.

1. Wipe the joint you want sealed with a cloth to remove oil and dirt - you do not have to use any detergent.
2. Add glue on the outside thread in a suitable amount; make sure to cover all the 3 -4 threads.
3. Assemble the joint. After 20-30min. the joint is handling-dry. After 1-3 hours the joint is hardened and ready for use. The glue is fully cured after 24 hours.  
Beware: When using the 86-72 the harden time can be up to 6 hours.  
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### RETAINER

LOXEAL retainer is suitable for the assembly of bearings, bushings, gears and cylindrical parts. LOXEAL bearing retaining increases the strength of press fit parts and allows slide fitting. Prevent loosening of large of large gap parts, corrosion and fluid leakage.

Various types: 53-11, 82-33.

1. Wipe the joint you want sealed with a cloth to remove oil and dirt - you do not have to use any detergent.
2. Add glue on the outside thread in a suitable amount; make sure to cover all the first 3 -4 threads.
3. Press the parts together. After approximately 20 min. the joint is handling dry. After 1-3 hours the joint is hardened and ready for use. The glue is fully cured after 24 hours.

The hardening time depends mainly of temperature and thread-tolerances.

#### **ACTIVATOR**

1. Wipe the joint you want sealed with a cloth to remove oil and dirt - you do not have to use any detergent.
2. Add activator on the surfaces you want to seal in a suitable amount.
3. Wait a few seconds, apply the glue as described above from point 2 and press the parts together. After approximately 1 to 2 min. the joint is handling dry. After 5-15 min. the joint is hardened and ready for use.  
The hardening time may vary depending on temperature and thread-tolerances.