

Product Description

MXLOC[™] 577 is designed for the sealing and locking of metal fittings and pipes. The product is a single component anaerobic, thixotropic, acrylic based product. The product cures when confined in the absence of air between close fitting metal surfaces and prevents leakage and loosening from vibration and shock.

MXLOC[®] 577 offers the following characteristics:

Chemistry	Acrylic
Appearance (uncured)	Yellow liquid
Base chemical	Methacrylate ester
Cure	Anaerobic
Secondary cure	Activator
Components	Single – requires no mixing
Viscosity	High
Application	Thread sealing

MXLOC[®] 577 is suitable for uses in metals including steel, aluminum and among other metal substrates. It replaces traditional PTFE tapes and dopes.

Chemical and physical properties of the uncured material

	Typical Value
Specific Gravity @ 25 °C	1.1
Viscosity @ 25 °C	16,000 – 33,000 cPs
Flash Point	See MSDS
Fixture Time	30 mins
Full cure Time	24 hr

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

	Typical Value
Operating temperature (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	5 Nm

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.

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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