

### Product Description

**MXLOC<sup>®</sup> 42** is designed for sealing and locking of metal fasteners. The product is a blue color, medium 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<sup>®</sup> 42** offers the following characteristics:

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

**MXLOC<sup>®</sup> 42** 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
<b>Specific Gravity @ 25 °C</b>	1.1
<b>Viscosity @ 25 °C</b>	900 – 1,400 cPs
<b>Flash Point</b>	See MSDS
<b>Fixture Time</b>	15 mins
<b>Full cure Time</b>	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

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

	Typical Value
Breakaway Torque M10 steel bolts & nuts ISO 10964	21 Nm
Prevail Torque M10 steel bolts & nuts ISO 10964	16 Nm
Breakaway Torque M10 Zinc phosphate bolts & nuts ISO 10964	16 Nm
Prevail Torque M10 Zinc phosphate bolts & nuts ISO 10964	7 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.

**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.

**Disclaimer:** The data contained herein are furnished for informational purposes only and are believed to be reliable. However, Cartell Chemical Co., Ltd does not assume responsibility for any results obtained by persons over whose methods Cartell Chemical Co., Ltd has no control. It is the user's responsibility to determine the suitability of Cartell Chemical Co., Ltd's products or any production methods mentioned herein for a particular purpose, and to adopt such precautions as may be advisable for the protection of property and persons against any hazards that may be involved in the handling and use of any Cartell Chemical Co., Ltd's products. Cartell Chemical Co., Ltd specifically disclaims all warranties express or implied, including warranties of merchantability or suitability for a particular purpose arising from sale or use of Cartell Chemical Co., Ltd's products. Cartell Chemical Co., Ltd further disclaims any liability for consequential or incremental damages of any kind including lost profits.