

### PRODUCT DESCRIPTION

MXBON® 13554 is designed for the sealing and locking of metal fittings and pipes. It provides solvent resistance on threaded fittings and pipe up to 50 mm in diameter. 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.

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Methacrylate ester
<b>Appearance</b> (uncured)	Red liquid
<b>Components</b>	One component – requires no mixing
<b>Viscosity</b>	Medium
<b>Cure</b>	Anaerobic
<b>Secondary Cure</b>	Activator
<b>Application</b>	Thread sealing

### NSF International

Registered to NSF Category S6 for use as a thread locking where there is no possibility of food contact in and around food processing areas. Note: This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

<b>Specific Gravity @ 25 °C</b>	1.0
<b>Flash Point -</b>	See SDS
<b>Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP)</b>	
<b>Spindle 3, 20 rpm</b>	1,500 to 3,500
<b>Shelf life</b>	24 months unopened when stored at 8 to 24°C

### TYPICAL PERFORMANCE OF CURED MATERIAL

#### Adhesive Properties - Torque

Cured for 72 hrs @ 25 °C

Breakaway Torque, ISO 10964, Unseated:

Bonding Identical Substrate	N.m	lb.in.
M10 steel nuts and bolts	19	167

Prevail Torque, ISO 10964, Unseated:

Bonding Identical Substrate	N.m	lb.in.
M10 steel nuts and bolts	27	238

### 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 to 24 °C. For details, consult the Safety Data Sheet, (SDS). Shelf life is two years 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.

### Note

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