

HYLOMAR HYLOLOC 406

Pre applied thread-locking compound

Description

Hylomar Hyloloc 406 is a pre -applied anaerobic thread-locking compound, which is water based, non-hazardous, clean and easy to use.

Hylomar Hyloloc 406 has excellent performance qualities providing low on torque, high break - loose strength and prevailing torque characteristics.

Typical Properties

Material	Water based Methacrylate
Mixing Ratio	5 parts Microcaps to 100 parts of Water based Resin.
Colour	Red or Blue
.pH	Slightly Alkaline (9 - 9.2)
Odour	Negligible
Specific Gravity	1.05
Boiling Point	100°C
Temperature Range	-50°C to +150°C
Installation Torque Required	Minimal, less than 2Nm
Break-loose torque; M10 Dacromet	20 Nm average after 24 hours
Prevailing torque;	13 Nm
Break-loose torque; M10 Phosphated	26 Nm average after 24 hours
Prevailing torque;	28 Nm
Break-loose torque; M10 BZP	24 Nm average after 24 hours
Prevailing torque;	33 Nm
Shelf Life on Parts	1 Year when stored in a cool, dry environment away from direct heat or sunlight

Information given in this publication is based upon technical data gained in our own and other Laboratories and is believed to be true. However the material is used in conditions beyond our control thus we can assume no liability for results obtained or damages incurred through the application of the data present herein.

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Mixing Method

Hyloloc 406 is a two component mix, comprising of:

- a) Water-based binder & Methacrylate resin
 - b) Microencapsulated curing agent
1. Thoroughly mix the Water-based resin, to eliminate any separation.
 2. When the water-based resin is smooth and homogenous, slowly add the encapsulated Curing agent and mix until fully dispersed (approximately 5 minutes).
 3. **NB. Only mix the curing agent at low speed, taking care not to break the microcaps.**
 4. The Hyloloc 406 is now ready for use.

Method of Application

1. Apply an even coating of Hylomar Hyloloc 406 to the threaded component, taking care not to coat the first 2 or 3 threads.
 2. Dry the coated component in an air-circulating oven for 30 minutes at 60°C. **It is essential that temperatures over 65°C are not reached. As this will cause premature curing of the compound.**
 3. Allow to cool then store the components in a cool dry place* until required.
- *4.It is essential that the dried components are stored in a sealed airtight container, to eliminate atmospheric moisture.**

NB. Mixed Hyloloc 406 has a pot life of 24 hours. Any material left after 24 hours must be discarded.

Typical Applications

Hylomar Hyloloc 406 eliminates the need for applying anaerobic thread-locking compounds at the point of assembly, giving higher production rates and eliminating operator inconsistencies.

Hylomar Hyloloc 406 can inhibit corrosion of mating components due to its sealing action.

Handling and Safety Properties

Risk Phrases: R36/38

Safety Phrases: S26 and S28

However, components coated with Hylomar Hyloloc 406 and allowed to dry are not classified as hazardous.

Packages

Hylomar Hyloloc 406 is available in 5 litre Kits for bulk application. For other packaging please contact the Sales desk.

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