



LOCTITE® Heavy Duty Anti-Seize

December 2008

PRODUCT DESCRIPTION

LOCTITE® Heavy Duty Anti-Seize provides the following product characteristics:

| | |
|--------------------|---------------------------|
| Technology | Anti-Seize |
| Appearance | Grey paste ^{LMS} |
| Cure | Non-curing |
| Application | Lubrication |

LOCTITE® Heavy Duty Anti-Seize is a graphite/calcium fluoride formulation, which is free from lead, copper, sulfur, and their compounds. LOCTITE® Heavy Duty Anti-Seize contains no free metals and is compatible with stainless steel and other nickel alloys. Typical applications of this product includes bolts, screws, studs, pipe joints, nuts, plugs, bushings, extruding and forming dies, heat exchangers, shear blades, metal bending, mechanical packings, etc. It is used in chemical plants, oil refineries, power plants, paper mills, steel mills and foundries, synthetic fiber plants, ship and aerospace manufacturing and service, etc. This product is typically used in applications with an operating range of -29 °C to +1315 °C.

TYPICAL PROPERTIES

| | |
|-------------------------------|----------------------------|
| Specific Gravity @ 25 °C | 1.15 |
| Penetration, ISO 2137, 1/10mm | 270 to 370 ^{LMS} |
| Weight Per Gallon, lbs/gal | 9.6 to 10.6 ^{LMS} |

Flash Point - See MSDS

TYPICAL PERFORMANCE

An anti-seize lubricant used on a bolt helps to develop greater clamp load for the same torque compared to an unlubricated bolt. An additional benefit is greater uniformity in clamp load among a series of bolts. The relationship between torque and clamp load is expressed in the following equation:

$$T = K \times F \times D$$

T = Torque (N·m, lb.in, lb.ft)

K = Torque coefficient or nut factor, determine experimentally

F = Clamp load (N, lb.)

D = Nominal diameter of bolt (mm, in.)

| | |
|---|------|
| Torque coefficient, k: | |
| 12.7 mm steel bolts (grade 8) and nuts (grade 5) | 0.16 |
| 12.7 mm steel bolts (grade 8) and nuts (grade 5), solvent cleaned, not lubricated | 0.27 |

(In critical applications, it is necessary to determine the K values independently. Henkel corporation makes no warranty of specific performance on any individual fastener)

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Directions for use:

1. For best performance the mating surface should be clean and free of grease.
2. **Note: When grinding or wire brushing, use a dust mask.** Dust from cleaning threads may contain metal compounds. Inhalation may cause lung injury or other harm.
3. Apply thin coating to mating surfaces, assemble.
4. Do not use thinner.

Loctite Material Specification^{LMS}

LMS dated May 10, 2000. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

(°C x 1.8) + 32 = °F
 kV/mm x 25.4 = V/mil
 mm / 25.4 = inches
 μm / 25.4 = mil
 N x 0.225 = lb
 N/mm x 5.71 = lb/in
 N/mm² x 145 = psi
 MPa x 145 = psi
 N·m x 8.851 = lb·in
 N·m x 0.738 = lb·ft
 N·mm x 0.142 = oz·in
 mPa·s = cP

Note

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Reference 1.1