

# SHANKS FOR DIE SETS

# MILLION GREASE/DIE ADHESIVE

—POLYUREA EP GREASE / LOCTITE No.638—

**RoHS**

**MSK**      **MSKS (With hexagon hole)**      **MSKTP (With hexagon hole and taper)**

S45C

B	C	L	ML	M	MSKTP		Catalog No.					
					L1	L2	Type	D—M	MSK	MSKS	MSKTP	
12	2	50	40	M18×P1.5	10	28	MSK MSKS MSKTP	25—18	Quotation			
		55		M22×P1.5	12	30		25				
17	3	60	60	M30×P2	13	32		32				
		65			15	32		38				
								50				

**Order**      **Catalog No.**  
MSK 50

**Days to Ship**      **Quotation**

**Price**      **Quotation**

**Alterations**      **Catalog No.** — (MLC)  
MSKTP 38 — MLC40  
**Quotation**

Alteration	Code	Spec.	1Code
	MLC	ML dimension change M ≤ MLC < ML 1mm increments	Quotation

MILLION GREASE (Polyurea EP grease)      **RoHS**

**MGS—80** (80g)  
**MGS—400** (400g)

Material name	Composition ratio
Base oil: refined mineral oil	Approx. 75%
Thickener: polyurea	Approx. 10%
Additive	Approx. 15%

**Application**

- For lubrication of guide units of punch die and forming die.
- For lubrication of mechanical sliding part.

**Features**

- It is a polyurea EP grease composed of molybdenum, EP additive, polymer, antioxidant and antirust agent, which uses polyurea EP thickener and refined mineral oil having good thermal stability as its base oil.
- It has superior oxidation stability, water-proof performance, adhesiveness, heat resistance, mechanical stability, and particularly excellent extreme pressure (EP) property due to specially added molybdenum.
- Because special polymer is added, it is highly adhesive, waterproof and retentive so that it can be applied to where grease dips easily (such as vertical sliding surface).

**Precautions for use**

- Inflammation may occur if it enters eyes, be sure to wear goggles when it is used.
- Skin contact may cause inflammation, be sure to wear protective gloves when it is used.
- Be sure to wear protective gloves in order to prevent hands from being hurt by container falling-down.

Be sure to read above-mentioned precautions before use.

Die adhesive      **RoHS**

**LOC638—250**      **LOC638—50**  
—Loctite No.638—      —Loctite No.638—  
250ml      50ml

**Order**      **Catalog No.** — **Amount**  
LOC 638 — 50

**Days to Ship**      **Quotation**

**Price**      **Quotation**

Volume (g)	Exterior	Service temperature range	Consistency (25°C)	Catalog No.	¥ Base unit price	¥ Volume discount unit price
					1piece	2piece ~
80	Yellow threads	-20 ~ 150°C	320	MGS—80	Quotation	
400				MGS—400		

**Order**      **Catalog No.**  
MGS—80

**Days to Ship**      **Quotation**

**Price**      **Quotation**

Fluid color	Main ingredient	Viscosity (cP)	Service temperature range (°C)	Catalog No.	Volume (mL)	Base unit price 1~4 pieces
Green	Anaerobic resin	2500	-55~125	LOC638	250 50	Quotation

**Applications (LOC638)**

- Can be used for bonding knock bushings (KNLB, KNLBB), die set bushings (LBB, LDB) and stripper guide bushings (SGBL, SGBZ, SGHZ, SGBF, SGFZ).

Strength	Recommended clearance at one side (mm)	Hardening time (hours at room temp.)		Hardening method
		Active surface	Inert surface	
Shear strength 25~35 (N/mm <sup>2</sup> )	0.01~0.03 <sup>Note(1)</sup>	1~3	3~6	Room temperature

- (1) Generally, when a die part is press-fit, it is bonded with a clearance of 0.01~0.03mm on one side.  
 (2) This is the time required until a serviceable strength (50% hardening) is reached.  
 Active surfaces are steel, copper alloys, aluminum alloys, and similar surfaces. Inert surfaces are stainless steel, zinc, heat-curing resins, plated surfaces, and similar surfaces.  
 (3) Service temperature range : -55~125°C  
 ⚠ Degreasing is recommended before application of Loctite adhesives.