

LOCTITE®

Solution Guide



West McLaren Mercedes
TECHNOLOGY PARTNER

LOCTITE®

www.loctite.com

Phone: 01707 358800 · Fax 01707 358900

Hertfordshire AL7 1JB

Watchmead · Welwyn Garden City

Henkel Loctite Adhesives Limited

For detailed product performance information and application guidelines, please refer to technical data or contact Henkel Loctite.

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A Henkel Company

Making the Right Choice

With this solution guide you can easily select the best Henkel Loctite product to solve engineering problems throughout industry, in original equipment manufacture as well as maintenance and repair.

It has been developed to make your product selection quick, easy and right first time. You may navigate this guide to find solutions from several different starting points:

- The problem solving section
- Henkel Loctite product categories
- A product list including ordering information

For more information about our products or us just "hit" the Henkel Loctite website – www.loctite.com.

This will give you – anytime day or night – further information on all of our products including those described here.

Also you have access to our most up-to-date literature and news about solutions to industrial problems using Henkel Loctite, addressing segments such as Industrial OEM,

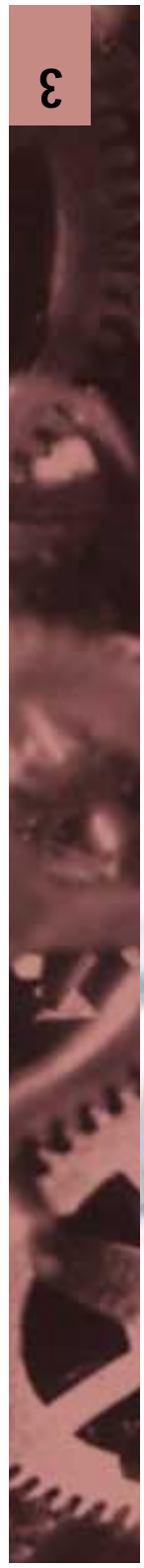
Automotive, Electronics, Maintenance and Repair.



For additional information visit our Web Site, at: www.loctite.com



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What's the Problem?

Nuts, Bolts, Studs, Threaded Parts



- ? Nuts, bolts, studs and other threaded parts loosening
- ? Need to prevent threads corroding and seizing

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Threadlocking

Fluid Pipe Systems



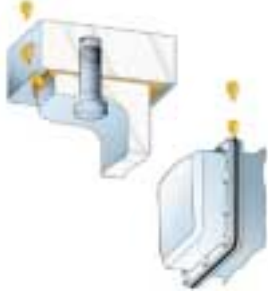
- ? Leaks from hydraulic, air, coolant, oil or other threaded fittings
- ? Need to prevent threads corroding and seizing
- ? Blockages caused by debris from traditional tape and hemp/paste sealants
- ? Need to lock and seal valves, gauges, taps and fittings in any position without leaks

See also Emergency Repair Products on page 46

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Pipe and Thread Sealing

Flanges Leaking



- ? Bolted flanges leaking
- ? Fretting corrosion and/or bolt fatigue
- ? Bolts loosen as gaskets relax
- ? Need to stop movement between the flanges

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Gasketing

Bearings, Bushes, Shafts, Cylindrical Parts



- ? Loose bearings, bushes, shafts or cylindrical parts that have become oval
- ? Prevent reoccurrence of fretting corrosion and wear, in coaxial assemblies
- ? Need to increase strength
- ? Simplify assembly process

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Retaining

Joining Small Parts



- ? Join different materials rapidly
- ? Bond parts temporarily during positioning or repair
- ? Re-use broken parts
- ? Need to speed up production

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Instant Bonding

Joining Plastic and Glass to each other and themselves and to Metals



- ? Need to secure small parts in plastic, glass, metal
- ? Need cure on command
- ? Need fast curing on a semi or fully automated production line
- ? Need to pot/seal

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UV Bonding

What's the Problem?

Structural Bonding

Page 22

? Strong durable joints between different materials

? Replace welding/ riveting - with a corrosion-free, reduced stress joint




Flexible Sealing and Bonding

Page 24

? Impact and vibration-resistant joint

? Permanently flexible bonding of different materials

? Joints have large gaps or are subject to high temperatures



Lubrication

Page 26

? Need to combat wear and seizing caused by friction

? Resist high temperatures and tough operating conditions




Surface Treatment and Rust Prevention

Page 34

? Prevent corrosion after assembly or during storage

? Guard against electro-chemical effects

? Protect welds at high temperatures



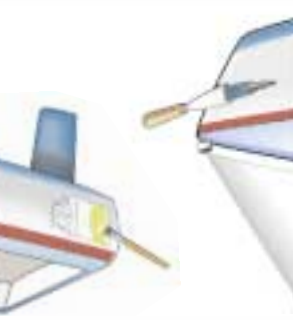
Fibre-reinforced Plastic Repair

Page 36

? Repair, restore, and join FRP parts or assemblies

? Waterproof filling and sealing of FRP, wood, metal

? Durable structural repairs



Metal Filled Compounds

Page 38

? Re-build, restore, repair metal parts and assemblies

? Make castings, moulds and fixtures



What's the Problem?

Wearing Compounds

Page 40

? Repair or prevent erosion, sliding abrasion, wear and corrosion in equipment such as pump housings, chutes cyclones etc.
 ? Protect against cavitation



Wear

Cleaning

Page 42

? Cleaning parts prior to using adhesives/sealants
 ? Have to remove cured resins, adhesives/sealants, old gaskets, and other compounds without surface damage
 ? Cleaning electrical contacts
 ? Cleaning hands, removing ink, paint, resin and hard-to-shift dirt - with or without water



Cleaning Parts and Hands

Surface Preparation Activators and Primers

Page 44

? Slow adhesive/ sealant cure on oily, contaminated, inert or passivated parts
 ? Working in a cold environment
 ? Poor adhesion to the substrate



Slow Adhesive/ Poor Adhesion

Emergency Repair Products

Page 46

? Damaged rubber such as conveyor belt surfaces
 ? Fill over-sized holes, smooth rough welds, repair nonstructural defects
 ? Make a new O ring - in situ. Emergency plugging and sealing of burst or leaking pipes



Emergency Repair

Equipment

Page 48

? Apply thick or thin products easily, cleanly, accurately and without waste
 ? Cure UV Bonding products quickly and completely



Dispensing and Curing Adhesives and Sealants

Products with NSF Approval



NSF is one of the most widely respected and recognised global third-party certification providers focusing on food, water, indoor air and the environment. For more information go to www.nsf.com

- ? Need NSF approval check section:
- Threadlocking
- Pipe and Thread Sealing
- Gasketing
- Retaining and Securing Cylindrical Assemblies
- Instant Bonding
- Structural Bonding
- Lubrication - Oils
- Lubrication - Greases
- Lubrication - Anti-seize
- Lubrication - Dry Film



Threadlocking – Locking of Threaded Fasteners

- Resists vibration
- Single part – clean and easy to apply
- Can be used on all sizes of fasteners – reduces inventory costs
- Seals threads allows through-hole tapping



Are the parts already assembled?



Solution

- Handy Hints:**
- Clean parts with Loctite® 7063 before applying the adhesive
 - If the threadlocker will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator)
 - If the parts were in contact with aqueous washing solutions or cutting fluids which leave a protective layer on the surface, wash with hot water before use
 - Use Loctite® 406 if either substrate is plastic

Size of Thread	Strength	Functional Strength ¹	Breakaway Torque M10 bolts	Long-Term Temperature Resistance	Pack Sizes
Up to M 12	Medium/High	3 hrs	10 Nm	+150 °C	10 ml, 50 ml, 250 ml
Up to M 36	Low	6 hrs	6 Nm	+150 °C	10 ml, 50 ml, 250 ml
Up to M 36	Medium	2 hrs	20 Nm	+150 °C	10 ml, 50 ml, 250 ml
Up to M 20	High	6 hrs	38 Nm	+150 °C	50 ml, 250 ml

¹Typical value @ 22 °C

Application Examples



Loctite® 290
Recommended for locking preassembled fasteners, e.g. instrumentation screws, electrical connectors and set screws.



Loctite® 222
Recommended for low-strength threadlocking of adjusting screws, countersunk head screws and set screws.
Also use on low strength metals such as aluminium or brass which could break during disassembly.



Loctite® 243
Effective on all types of metal threaded fasteners.
Prevents loosening on vibrating parts such as pumps, motor mounting bolts, gear boxes or presses.



Loctite® 2701 (improved 270)
For use on all metal fasteners (including stainless steels and those with protective coatings such as zinc) where regular removal for maintenance is not required.
Recommended for permanently locking studs on engine blocks and pump housings.
P1 NSF Reg. No.: 123006 – only Loctite® 270

Standard 61

Certified to ANS/NSF

P1 NSF Reg. No.: 123000

parts are contaminated with oil.

required for servicing and where disassembly with hand tools is

Recommended for use where parts such as aluminium or brass which

could break during disassembly.

Recommended for low-strength

threadlocking of adjusting screws, countersunk head screws and set screws.

Also use on low strength metals such as aluminium or brass which

could break during disassembly.

Recommended for use where parts are contaminated with oil.

required for servicing and where disassembly with hand tools is

Recommended for use where parts are contaminated with oil.



Pipe and Thread Sealing – Sealing of Threaded Components

- Provide an instant, low pressure seal for all types of pipe connections
- Will not creep, shrink or block systems (including filters) by shredding
- Disassembly can be achieved easily with normal tools
- Replace all tapes and hemp/pastes combinations



Are the parts metal or plastic?

Metal parts		Plastic or combined plastic/ metal parts		Do you need to make post assembly adjustments?		Plastic or combined plastic/ metal parts		Metal parts		Are the threads fine or coarse?	
<p>Handy Hints:</p> <ul style="list-style-type: none"> ■ If the sealant (Loctite® 542, 577 or 572) will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator) ■ All parts must be clean & dry before sealing – use Loctite® 7063 containing nitriles wash them with hot water* ■ If the parts have been in contact with washes or cutting fluids ■ Clean U-PVC pipe surfaces with Loctite® 7044 prior to joining with Loctite® 5004 											
<p>Solution</p>											
572		542		5331		55		5004		577	
Coarse up to (R3) pipe thread		Hydraulic and pneumatic pipe thread		Liquid		Cord		Joining non threaded plastic pipe fittings		(General purpose)	
572		542		5331		55		5004		577	
Slow cure											

Description	Maximum Thread Size	Temperature Resistance	Disassembly Strength	Substrate to be Sealed	Instant Low Pressure Seal	Pack Sizes:
Solvent	N.A.	As plastic	High	U-PVC	No	125 g, 250 g, 500 g
Cord	Tested to 4"	+130 °C	Low	Metal, plastic or both	Yes (full pressure)	80 g = 150 m cord
Curing gel	3"	+150 °C	Low	Metal, plastic or both	Yes	100 ml
Curing liquid	3/4"	+150 °C	Medium	Metal	No	10 ml, 50 ml, 250 ml
Curing gel	3"	+150 °C	Medium	Metal	Yes	50 ml, 250 ml
Curing gel	3"	+150 °C	Medium	Metal	No	50 ml, 250 ml

* Does not apply to Loctite® 5331/55

Application Examples



Loctite® 5004

(Not available in UK)
Special solvent-based adhesive for bonding U-PVC pipes.
Complies with the following: DIN 16970 and KRIV guidelines R1.17. BS 4346, part 3 and ASTM D2564. The cured adhesive meets the requirements of admission for drinking water supply through U-PVC pipes in compliance with the Recommendation no. VIII of the Plastics Commission of the Bundesgesundheitsamt (Germany Health Authorities).



Loctite® 55

Can be safely applied on metal and plastics threaded fittings.
Portable water: WRc listed for use with potable water up to 85 °C.
16970 and KRIV recommendation meets BS 6920, KTW recommendation for cold and hot water.
German DVGW approval (No. DV-5142 AU0166), together with DIN 30660. Tested in accordance with EN 751-2 Class Arp. Certified to ANSI/NSF Standard 61.



Loctite® 5331

Recommended for use on threaded fittings as used in hydraulic and pneumatic installations and small carrying hot or cold water e.g. industrial and agricultural plastic water pipe systems, or drainage systems.
Carries the German DVGW approval (NG-5146 AR 0855). Tested in accordance to EN 751-1. Meets BS 6956 type A for sealing gas fittings.
WRc approval for use with potable water up to 85 °C.
P1 NSF Reg. No.: 123620



Loctite® 542

Recommended for all coarse metal threads where slow cure is required for adjusting the alignment of valves and fittings.
Meets BS 6956 type B for sealing gas fittings.
WRc approval for use with potable water.
P1 NSF Reg. No.: 123001



Loctite® 577

Recommended for all coarse metal threads where slow cure is required for adjusting the alignment of valves and fittings.
Meets BS 6956 type B for sealing gas fittings.
WRc approval for use with potable water.
P1 NSF Reg. No.: 123001



Loctite® 572

Recommended for all coarse metal threads where slow cure is required for adjusting the alignment of valves and fittings.
Meets BS 6956 type B for sealing gas fittings.
WRc approval for use with potable water.
P1 NSF Reg. No.: 123001



Gasketing - Sealing of Flanges

- No shimming effect - controlled tolerances, no need for re-torquing
- Fill all voids - reduce the need for a fine surface finish of flanges
- Parts can be disassembled easily even after extended service
- Resists high pressure when fully cured



Does the existing gasket need to be used as a shim?

Handy Hints:

- If there are traces of old gasket left on the parts to be sealed, clean with Loctite® 7200 gasket remover
- All parts must be clean and dry before sealing - use Loctite® 7063 Anaerobic products cure between metal surfaces in the absence of air
- Use activator Loctite® 7240 in cold conditions to speed up the cure

Solution

Does the existing gasket need to be used as a shim?	5203	3020	5205	5208	518	510	5910	5699
Yes	Coat existing gasket	Positioning cut gaskets	Aluminium		Metals		Plastic or combined	
No				Up to 0.5 mm			Greater than 0.5 mm	
						What gap must the sealant fill?		

Gasket Type	5203	3020	5205	5208	518	510	5910	5699
Gasket Type	Formed-in-place	Use with cut-gasket	Formed-in-place	Formed-in-place	Formed-in-place	Formed-in-place	Formed-in-place	Formed-in-place
Flange Type	Rigid	Rigid or Flexible	Rigid	Rigid	Rigid	Rigid	Flexible	Flexible
Cure Method	Anaerobic	Solvent evaporation	Anaerobic	Anaerobic	Anaerobic	Anaerobic	Moisture	Moisture
Tack-Free Time	150 °C	N.A.	150 °C	150 °C	N.A.	N.A.	20 min.	200 °C
Temperature Resistance	150 °C	N.A.	150 °C	150 °C	150 °C	up to 200 °C	200 °C	200 °C
Instant Seal	Excellent	Excellent	Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
Oil Resistance	Excellent	N.A.	Excellent	Excellent	Excellent	Excellent	Excellent	Good
Water/Glycol Resistance	Moderate	N.A.	Good	Moderate	Excellent	Excellent	Moderate	Excellent
Pack Sizes	50 ml, 300 ml cartridge	400 ml aerosol	50 ml, 300 ml cartridge	50 ml, 250 ml tube	65 ml, 300 ml cartridge	50ml,160ml,250ml cartridge	300 ml cartridge	300 ml cartridge

Application Examples



Loctite® 5203
Recommended for coating and re-using gaskets to improve sealing. Low strength metal/metal sealing.

Loctite® 3020
Adhesive/sealant for holding pre-cut gaskets in place during assembly. Can be applied to all rubber, cork, paper and metal gaskets.

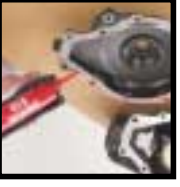
Loctite® 5205
Recommended for aluminium parts where flexibility is required e.g. aluminium gearbox and engine castings, etc.



Loctite® 5208
(Alternative 574)
Recommended for use on iron metal parts e.g. cast iron components and pump housings, etc.



Loctite® 518
Recommended for use on rigid iron, steel and aluminium flanges. Certified to ANSI/NSF Standard 61.



Loctite® 510
Sealing rigid flanges
Recommended for applications where high temperature and chemical resistance is needed. P1 NSF Reg. No.: 123007



Loctite® 5910
Replacement for cork and paper cut gaskets on flanges and stamped sheet metal covers. Recommended for use where high vibration or flexing occurs. Can also be used with plastic and painted parts.



Loctite® 5699
Recommended for sealing all types of flanges including stamped sheet metal where water glycol resistance is required. P1 NSF Reg. No.: 122998



Application Examples



Retaining - Securing Cylindrical Assemblies



- High and moderate strength products – can carry high loads and eliminate fretting
- Fill all voids – prevent corrosion
- Reduce the need for close tolerances
- 100 % contact – load and stress is distributed evenly over the joint



Is the assembly very loose or badly worn?

Solution

- Handy Hints:**
- If the retainer will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator)
 - All parts must be clean & dry before sealing – use Loctite® 7063 containing nitriles, wash with hot water
 - If the parts have been in contact with washing or cutting fluids Can also be used to increase the strength of existing designs

Strength Required	Handling Strength ¹	Diametrical Clearance	Temperature Resistance	Pack Sizes
High	20 min.	Up to 0.5 mm	150 °C	50 ml
Moderate	30 min.	Up to 0.1 mm	150 °C	10 ml, 50 ml, 250 ml
High	5 min.	Up to 0.15 mm	175 °C	50 ml, 250 ml
High	5 min.	Up to 0.25 mm	150 °C	50 ml, 250 ml
High	10 min.	Up to 0.1 mm	150 °C	10 ml, 50 ml, 250 ml

¹ at room temperature on steel joints



Loctite® 660 (Use with Activator Loctite® 7240)
 Used for repairing worn coaxial parts without remachining; enables re-use of worn bearing seals, keys, splines, tapers, or shafts for retaining shims.
 P1 NSF Reg. No.: 123704



Loctite® 641
 Recommended for parts that will need subsequent dismantling i.e. retention of bearings onto shafts or interference fit i.e. retaining bushes, bearings, seals, fans, and liners.
 Recommended for high temperature retainering of parts with a clearance axial and radial loads.
 Gives best resistance to dynamic, P1 NSF Reg. No.: 123010



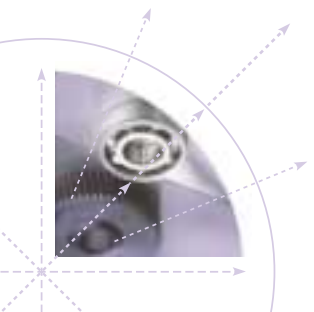
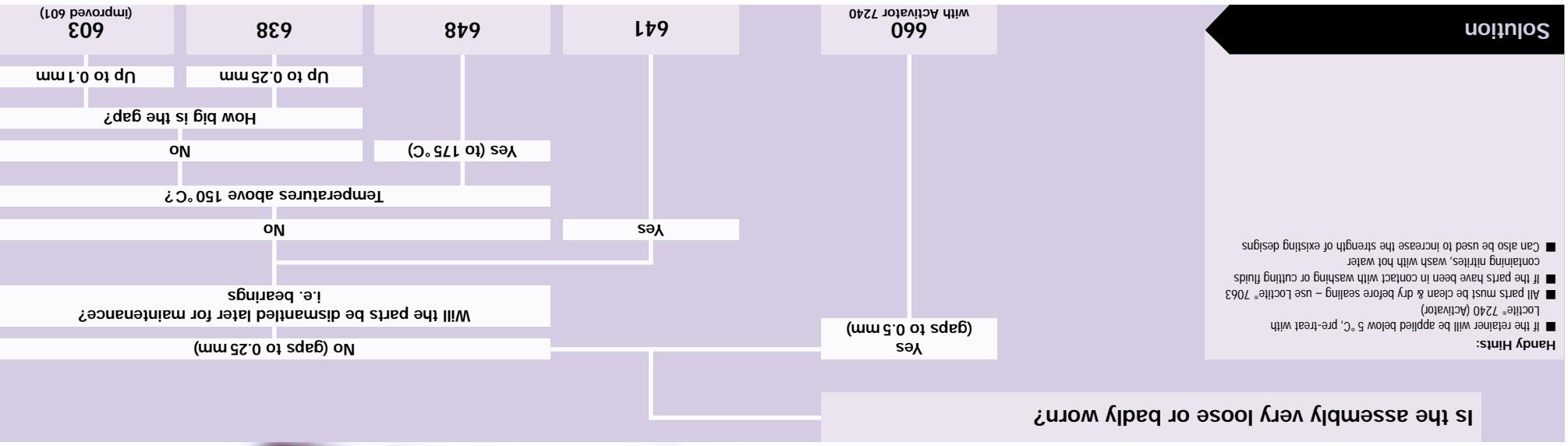
Loctite® 648
 Recommended for retaining axial and radial loads. Recommended for retaining shafts, gears, pulleys and similar cylindrical parts where thorough degreasing is not possible.
 Tested and approved for use on bearings.
 P1 NSF Reg. No.: 123003



Loctite® 638
 Recommended for retaining axial and radial loads. Gives best resistance to dynamic, P1 NSF Reg. No.: 123010



Loctite® 603 (Improved Loctite® 601)
 For retaining close fitting cylindrical parts (up to 0.1 mm gap). For use on cylindrical fitting parts where thorough degreasing is not possible.
 Tested and approved for use on bearings.
 P1 NSF Reg. No.: 123003





Instant Bonding

- Fixtures in seconds
- Clear bond line – good cosmetic appearance
- Versatile – dissimilar materials can be bonded
- High strength – often giving a bond stronger than the materials being bonded
- Small parts bonding

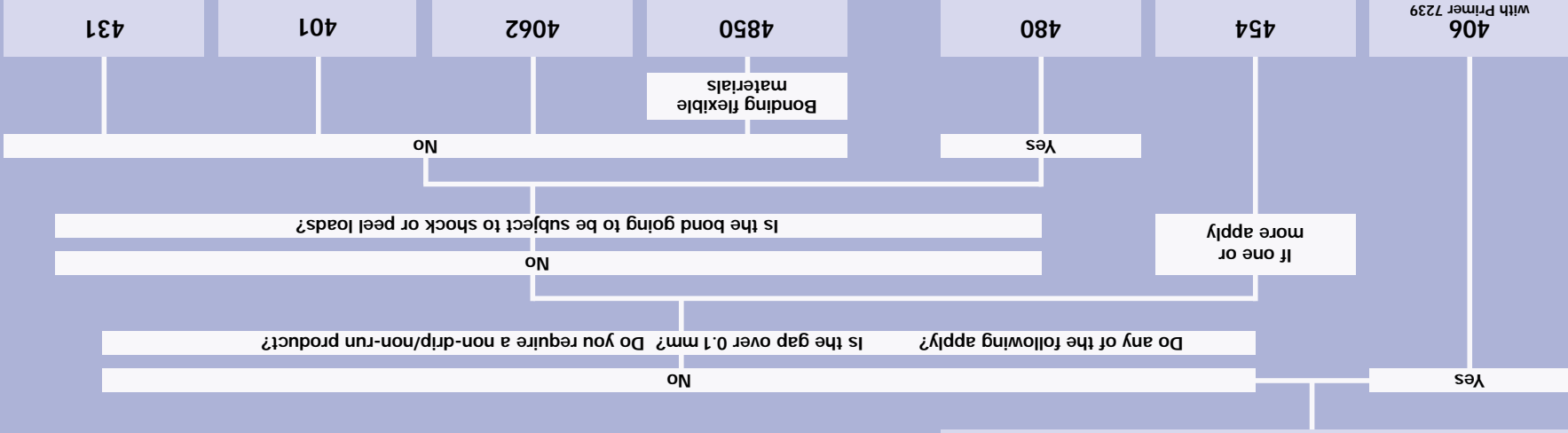


Are you bonding "difficult to bond" rubber or plastic?
 e.g. polyethylene, polypropylene, PTFE, thermoplastic rubbers such as Santoprene®

Handy Hints:

- To improve adhesion to difficult-to-bond materials e.g. PE, PP, PTFE, Santoprene® or thermoplastic rubbers: in combination with Loctite® 401, 406, 431, 454 or 480 – use Primer Loctite® 7239

Solution



Operating Temperature	Fixture Time*	Viscosity mPa.s	Especially for	Pack Sizes
Up to 80 °C	10-20 sec.	20	Plastics	20 g, 500 g
Up to 80 °C	5-20 sec.	Gel	Porous Substrates	10 g, 20 g, 300 g, 300 g cartridge
Up to 100 °C	60-120 sec.	300	Metal/Plastics	20 g, 500 g
70 °C	5-20 sec.	400	Flexible Substrates	20 g, 500 g
Up to 80 °C	3-20 sec.	2	Metal/Plastics	20 g, 500 g
Up to 80 °C	5-20 sec.	110	Porous Substrates	3 g, 20 g, 50 g, 500 g
Up to 80 °C	5-20 sec.	1000	Porous Substrates	20 g, 500 g

Application Examples



Loctite® 406
 Rapid bonding of rubbers (including EPDM), plastics and elastomers, when used with Loctite® 7239 Polyolefin Primer bonds "difficult to bond" plastics.



Loctite® 454
 General purpose gel for bonding metals, composite materials, wood, cork, foam, leather, card, paper, and unglazed ceramics. Recommended for use on vertical or overhead surfaces. P1 NSF Reg. No.: 123009



Loctite® 480
 Black, rubber toughened grade for bonding metal to metal and metal to rubber, especially suitable where strength is required and/or shock loads are present.



Loctite® 4850 Flexible Instant Adhesive
 Medium viscosity, fast curing, transparent adhesive. Especially designed for the assembly and repair of flexible materials and components. Typical application areas: Bonding materials used in the manufacture and repair of flexible gaskets and seals, galleys, and loudspeaker assemblies.



Loctite® 4062
 Ideal for very fast bonding of plastic, rubber and metal substrates.



Loctite® 401
 General purpose for bonding most porous or absorbent materials such as wood, paper, leather, cork and fabric. P1 NSF Reg. No.: 123011



Loctite® 431
 Particularly suitable for bonding porous or absorbent materials such as wood, paper, leather, cork and fabric. P1 NSF Reg. No.: 123011



UV Bonding

- Fast and on-command curing
- Rapid fixture after alignment or repositioning of parts
- Clear bond line
- High strength and excellent humidity resistance

What is your transparent substrate?

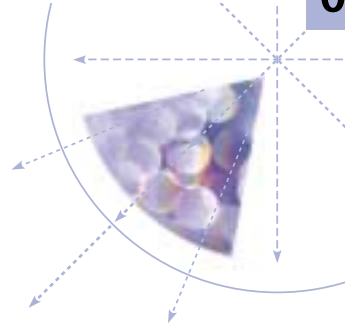
Handy Hints:

- One of the parts being bonded must be UV-transparent
- Henkel Loctite provides a full range of UV curing equipment

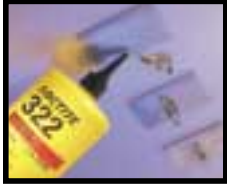
Solution

Operating Temperature	Fixturing time	Viscosity mPas	Pack sizes
+100 °C	1-10 sec.	100	250 ml
+100 °C	1-10 sec.	5,800	250 ml
+120 °C	5-20 sec.	5,500	250 ml
Up to 120 °C	5-20 sec.	19,500	250 ml

Application Examples



Loctite® 302
 Low viscosity fast curing clear UV curing adhesive. Especially designed for post-application. Recommended for plastics to themselves, metal and glass.



Loctite® 322
 Medium viscosity fast curing clear UV curing adhesive. Recommended for plastics to themselves, metal and glass.



Loctite® 350
 Medium viscosity UV curing adhesive. Highly transparent. Recommended for glass and metal in combination with glass and metal.



Loctite® 352
 Thixotropic clear UV curing adhesive. Especially designed for vertical application. Recommended for glass in combination with glass, metal, ceramic and Glass Reinforced Plastic (GRP).



Structural Bonding

- Bonds a wide variety of materials such as wood, metals, hard plastics and glass
- Provide a tough and resilient joint
- Have high shear and peel strength



What is the bond gap?

Handy Hints:

- All parts must be clean & dry before bonding – use Loctite® 7063
- For slow curing products, clamp during cure
- For maximum peel and impact resistance use Loctite® 330 MULTI-BOND®

Solution

Operating Temperature	Up to 100 °C	Up to 100 °C	Up to 100 °C	Up to 100 °C	Up to 100 °C
Paintable	No	Yes	Yes	Yes	Yes
Maximum Gap	Up to 0.5 mm	Up to 1 mm	Up to 1 mm	Up to 3 mm	Up to 3 mm
Cure Method	Activator 7388	Two component	Two component	Two component	Two Component
Fixture Time	< 5 min.	280 min.	12 min.	12 min.	150 min.
Consistency	Gel	Thick liquid	Thick liquid	Gel	Gel
Especially for	Metal, plastics, glass	Metal, wood	Metal, glass	Metal, wood	Metal, rigid plastics
Pack Sizes	50 ml/18 ml kit, 315 ml cartridge	2x0.9 litre tins	24 ml twin syringe (manual mixing)	2x0.9 litre tins	2x0.9 litre Tins
Dual Cartridge (with static mixer)	-	50 ml, 200 ml	24 ml	25 ml	50 ml, 200 ml



Loctite® 330/7388 MULTI-BOND® 50 ml Kit
 Two part no mix fast curing toughened adhesive with good solvent, moisture, impact resistance, and good peel strength.
 P1 NSF Reg. No.: 123005



Loctite® 3421 Multi-purpose Clear
 Slow-curing adhesive. Excellent humidity and water resistance. Very high shear strength. long working life. Ideal for bonding large surfaces and parts which need careful alignment.



Loctite® 3430
 Two part mix adhesive for bonding rigid transparent parts. Recommended for repairing parts where clarity is important.

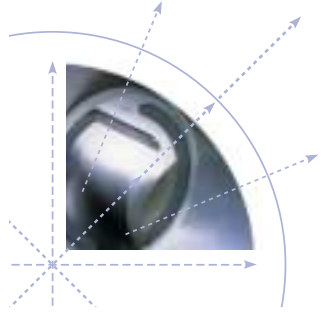


Loctite® 3450 Metal coloured
 General purpose adhesive for large (3 mm) bond gaps. High viscosity. Good chemical resistance and heat ageing properties. Ideal for bonding metal surfaces.



Loctite® 3425 Toughened
 High viscosity, toughened adhesive for bond gaps up to 3 mm. High shear strength. Good chemical and humidity resistance. Suitable for rigid plastics such as GRP (Glass Re-enforced Plastic) and SMC (Sheet Moulding Compound).

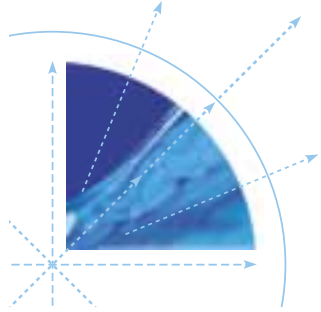
Application Examples





Flexible Sealing and Bonding

- Withstand impact shock and bonding
- Resist thermal expansion and contraction as well as vibration
- Have very good gap fill
- Wide temperature range
- Good weathering resistance



Are you sealing electrical items?

Handy Hints:

- To improve adhesion of Loctite® 5221/5225/5226 use the following primers: Loctite® 7251 - Glass Loctite® 7252 - Plastic Loctite® 7253 - Metal and paint

Solution

Operating Temperature	Up to 200 °C	Up to 250 °C	350 °C	Up to 350 °C	Up to 80 °C	Up to 100 °C
Paintable	No	No	No	No	Yes	Yes
Cure Method	Moisture	Moisture	Moisture	Moisture	Moisture	Moisture
Skin Over Time	70 min.	5 min.	8 - 10 min.	5 min.	70 min.	15 min.
Viscosity	Paste	Paste	Liquid	Paste	Flexible, medium strength bonds	Paste
Especially for	Electrical components	Glass	Sealing/Potting	Oven door seals	Flexible, medium strength bonds	Flexible bonds, joint sealing
Colour Variations	Translucent	5366 - Clear 5367 - White 5368 - Black	Red	Red	5226 - Black 5221 - Grey 5225 - White	Low Strength: 5062 - Black, 5063 - Grey, 5064 - White Medium: 5065 - Black, 5066 - Dark-Grey, 5068 - White High Strength: 5069 - Black
Pack Sizes	40 ml kit, 300 ml	310 ml	310 ml	310 ml	300 ml	310 ml

Do you require high temperature resistance?

Yes → 5145

No → 5398 (Food grade)

Do you require high temperature resistance?

Yes → 5399

No → 5226

Do you require high temperature resistance?

Yes → 5366

No → 5069

Do you require high temperature resistance?

Yes → 5398 (Food grade)

No → 5069

Application Examples



Loctite® 5145
Flexible non-corrosive electrical grade Adhesive/Sealant

Low odour, neutral cure that does not corrode electrical and electronic components.

Suitable for glass, metal, ceramics, composites, and most plastics.



Loctite® 5366/5367/5368
Flexible Adhesive

Cures to a flexible rubber. Recommended for bonding, sealing and protecting components subjected to vibration heaters, ovens and in equipment such as turbines, pumps and other areas within the food processing environment. The product may also be used for protection and insulation of electrical boxes.



Loctite® 5398
Flexible Adhesive/Sealant

Recommended for sealing heat exchangers steam circuits, water heaters, ovens and in equipment such as turbines, pumps and other areas within the food processing environment. The product may also be used for protection and insulation of electrical boxes.



Loctite® 5399
Flexible high temperature Adhesive/Sealant

Suitable for bonding and sealing glass, metal, and ceramics, where temperatures can reach 350 °C, e.g. sealing of stove flues/chimneys, industrial ovens, electro-appliances and ventilation systems.



Loctite® 5221/5225/5226
Flexible Adhesive/Sealant

Paintable, with good chemical resistance. Recommended for bonding materials with different coefficients of thermal expansion. See handy hints.



Loctite® 5062/5063/5064
MS Polymer Adhesive/Sealant

Permanently join and seal bare and painted metals, plastics, wood and many other materials, without the need for primers.

Good UV resistance.

Lubrication – Oils

- Prevent seizing and galling during assembly and operation
- Inhibit corrosion and oxidation in chemically and thermally aggressive environments
- Penetrate and free corroded assemblies

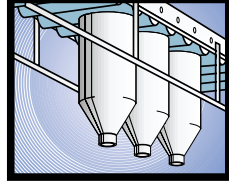


Solution

Oil	
Low viscosity penetrating oil	8001 Food grade
Lubricate chains	8011
Free rusted, and seized parts,	8018
Silicone oil	8021
Cutting oil	8031
General purpose	8201

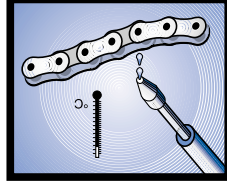
Appearance	Base Oil and Additives	Viscosity	Temperature Range	Load Test 4 Ball N	Pack Sizes
Colourless	Mineral oil	11 mm ² /s	-20 to +120 °C	1800	400 ml
Yellow	Synthetic	11 mm ² /s	-30 to +250 °C	1260	400 ml
Colourless	Colourless	< 100 mPa.s	N.A.	N.A.	300 ml
Colourless liquid	Silicone	350 mPa.s	-30 to +50 °C	N.A.	400 ml aerosol
Colourless liquid	Mineral	46 mm ² /s	N.A.	5000	400 ml aerosol
Light yellow liquid	Mineral	17.5 mm ² /s	-20 to +120 °C	-	400 ml aerosol

Application Examples



Loctite® 8001
Food approved mineral oil spray
(Not available in UK.)
Multi-purpose penetrating oil. Product is suitable for the food, pharmaceutical and textile industries.

It is ideal for lubricating valve conveyors and chains at elevated temperatures up to 250 °C. cutting knives in food transport equipment and sewing machines.
H1 NSF Reg. No.: 122999



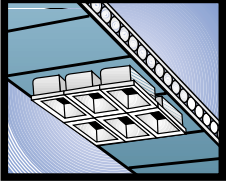
Loctite® 8011
High temperature chain oil spray
(Not available in UK.)
Oxidation resistance prolongs lubricant service life.

This product is used for the lubrication of open mechanisms, seats, collars, chains, hinges, conveyors and chains at elevated temperatures up to 250 °C.
H2 NSF Reg. No.: 122978

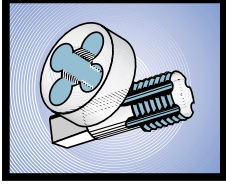


Loctite® 8018
Solvo Rust
Releases rusted, corroded and seized components.
Ideal for lubricating plastics and elastomers.

A penetrating oil to free rusted nuts, bolts, screws, fittings, other fasteners as well as metal components in industrial equipment.
Also recommended for cleaning parts before lubrication and as light lubricant and rust inhibitor.



Loctite® 8021
Silicone oil
Protects cutting tools in operation. Displaces moisture, and prevents Frees, lubricates, cleans.



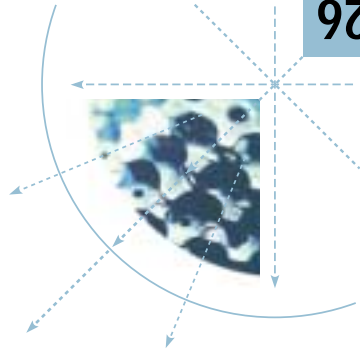
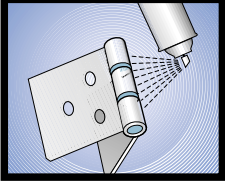
Loctite® 8031
Cutting oil
(Not available in UK.)
To be used when drilling, sawing or tapping steel and most non-ferrous metals.

It is especially designed for use with stainless steel.

Displaces moisture, and prevents Frees, lubricates, cleans.

Protects cutting tools in operation. Displaces moisture, and prevents Frees, lubricates, cleans.

Loctite® 8201
Five way spray



Lubrication - Greases



- Prevent seizing and galling during assembly and operation
- Inhibit corrosion and oxidation in chemically and thermally aggressive environments
- Withstand high temperatures and extreme pressures

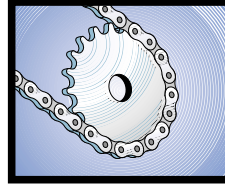
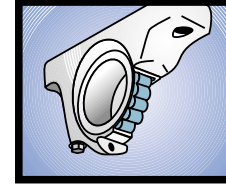
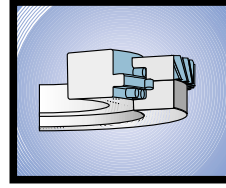
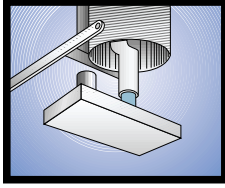
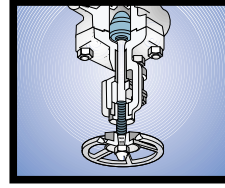
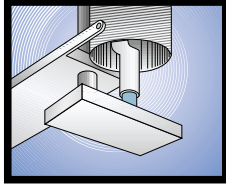


Grease

Solution		8015	8104	8105	8102	8103	8101
Food grade products							
High performance							
Chains, gears							

Appearance	Base Oil and Additives	Viscosity	Thickener	Drop Point	N.L.G.I. Class	Speed Characteristics DN Factor	Temperature Range	Load Test 4 Ball N	Pack Sizes
White paste	Mineral	Paste	-	-	2	-	-30 to +130 °C	N.A.	400g
Colourless smooth paste	Silicone	Paste	Silica Gel	-	2/3	50,000	-50 to +200 °C	N.A.	1 litre can
White	Mineral	Paste	Inorganic Gel	None	2	150,000	-50 to +150 °C	1600 Weld load	400 ml cartridge
Beige high tack paste	Mineral E.P.	Paste	Lithium soap complex	290 °C	2	500,000	-30 to +200 °C	3150	400g cartridge 1 litre can
Black smooth paste	Mineral E.P. MoS ₂	Paste	Lithium soap	>190 °C	2	500,000	-20 to +150 °C	3500	400g cartridge 1 litre can
Amber high tack paste	Synthetic E.P.	Paste	Lithium soap	>190 °C	2	N.A.	-25 to +170 °C	3150	400 ml aerosol

Application Examples



Loctite® 8015
Food grade grease
 Multi-purpose.
 White mineral grease for bearings, slides, bushes and linkages.

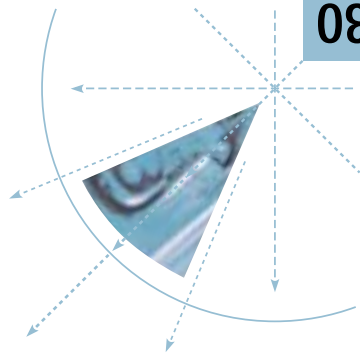
Loctite® 8104
Food grade silicone grease
 Meets CNERNA Guide 1992.
 H1 NSF Reg. No.: 122981
 Food approved.
 Recommended for lubrication of most elastomeric and plastic parts.

Loctite® 8105
Food grade mineral grease
 (Not available in UK.)
 Lubricant for moving parts.
 Recommended for use on equipment in food processing and pharmaceutical industries.
 It is ideally suited for bearings, cams, valves and conveyors for food and pharmaceutical products.
 H1 NSF Reg. No.: 122979

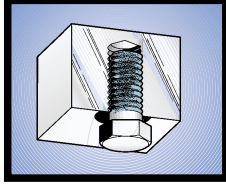
Loctite® 8102
High performance grease
 (Not available in UK.)
 Can be used in humid conditions and withstands heavy loads at medium and high speeds.
 Use for lubrication of bearings, roller and plain bearings.
 open gears and slide ways.

Loctite® 8103
MoS₂ grease
 (Not available in UK.)
 Withstands heavy loads and vibration at all speeds.
 Typically used on cylindrical taper roller and plain bearings.

Loctite® 8101
Chain lubricant
 (Not available in UK.)
 Water resistant.
 Chain lubricant with anti-filing properties.
 Use on open mechanisms such as chains and gears.



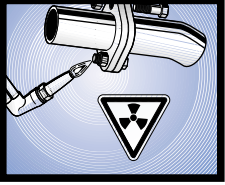
Loctite® 8014
Food grade
Anti-seize-brush top
 White, metal free Anti-seize paste.
 For use on stainless steel components in food processing and packaging.
H1 NSF Reg. No.: 123004



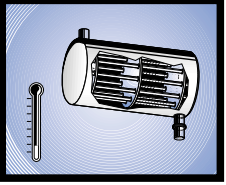
Loctite® 8007
C5-A® - Aerosol
C5-A® - Brush Top
Loctite® 8008
Loctite® 8007
 A general purpose Anti-seize lubricant which protects metal parts from corrosion, galling and seizing and ensures easy dismantling.
 Do not use on stainless steel.



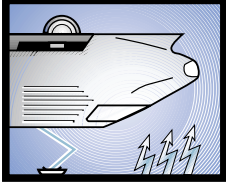
Loctite® 8013
N 7000
Anti-seize brush top
 A high purity metal free Anti-seize with excellent chemical resistance. Recommended for use in all power stations including nuclear plants.



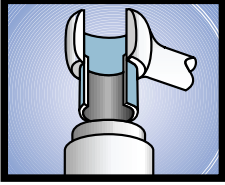
Loctite® 8009
Heavy duty
Anti-seize-brush top
Anti-seize
 Metal free Anti-seize. Provides long term lubrication on all metals. Widely used in petrochemical plants and where copper based Anti-seize is not permitted.



Loctite® 8152
Copper paste
Anti-seize
 (Not available in UK.)
 Ideal for static and slow moving assemblies.
 Resists arcing making it ideal for electrical contacts, switches and isolators.
 Do not use on stainless steel.



Loctite® 8154
Spray assembly paste
with MoS₂
 (Not available in UK.)
 Assists the assembly of cylindrical parts, bearings, wheels, gears, spined shafts, etc.
 Prevents fretting and galling. This spray protects components during the running-in periods. MoS₂ can provide emergency lubrication.
H2 NSF Reg. No.: 122982



Application Examples

Appearance	Solid Lubricating Agent	Torque Coefficient ¹	N.L.G.I. Class	Temperature Range	Pack Sizes
White paste	Mineral	-	1	-30 to +400 °C	250 g
Copper paste	Copper	0.16	-	up to 980 °C	Aerosol 400 ml, Brush top 500 g
Dark grey paste	Mineral	0.16	1	-30 to +1300 °C	Brush top 500 g
Black paste	Mineral/Graphite	0.16	1	-50 to +1300 °C	Brush top 500 g
Copper paste	Copper	-	2	-35 to +1100 °C	1 litre can
Black	MoS ₂	N.A.	N.A.	-35 to +450 °C	400 ml

¹ on steel, nuts and bolts

Solution

Food grade	8014
Copper base up to 980 °C	8007/8008
General purpose up to 1300 °C	8013
Electrical contacts	8152
Assembly Paste	8154

Anti-seize paste

Lubrication - Anti-seize



- Prevent seizing and galling during assembly and operation
- Inhibit corrosion and oxidation in chemically and thermally aggressive environments
- Prevent wear and cold welding during assembly and operation





Lubrication - Dry Film

- Prevent seizing and galling during assembly and operation
- Inhibit corrosion and oxidation in chemically and thermally aggressive environments
- Prevent wear and cold welding during assembly and operation

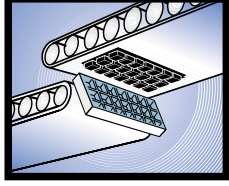


Solution	
Dry film lubricant	
General purpose	
Lubricant up to 400 °C and Anti-seize up to 1300 °C	
Food grade	
8192	8016
8017	8191

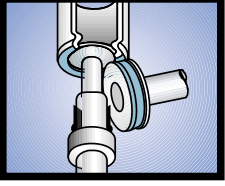
Appearance	Solid Lubricating Agent	Torque Coefficient ¹	Temperature Range	Pack Sizes:
Off white paste	PTFE	-	-180 to +260 °C	400 ml aerosol
Black	MoS ₂	0.06 - 0.12	-30 to +400/1300 °C	340 g aerosol
Black	MoS ₂	0.06 - 0.12	-30 to +400/1300 °C	500 g
Black	MoS ₂	-	-180 to +450 °C	400 ml aerosol

¹ on steel, nuts and bolts

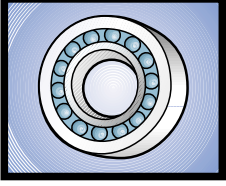
Application Examples



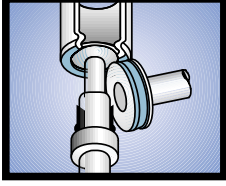
Loctite® 8192
PTFE coating
(Not available in UK.)
Food approved coating.
Meets CNERNA Guide 1992.
Ideal for use on conveyor belts, slideways and cams.
H2 NSF Reg. No.: 122980



Loctite® 8016
Moly dry film - aerosol
Contains MoS₂.
Copper-free.
Fast air-dries to protect sliding surfaces and slow moving parts.
Recommended for use in dusty environments.



Loctite® 8017
Moly dry film-Tin
Contains MoS₂.
Copper-free.
Fast air-dries to protect sliding surfaces and slow moving parts.
Recommended for use in dusty environments.



Loctite® 8191
coating - aerosol
MoS₂ Anti-friction
(Not available in UK.)
Rapidly air-dries to protect surfaces from fretting and corrosion.
Enhances the performance of oils and greases.



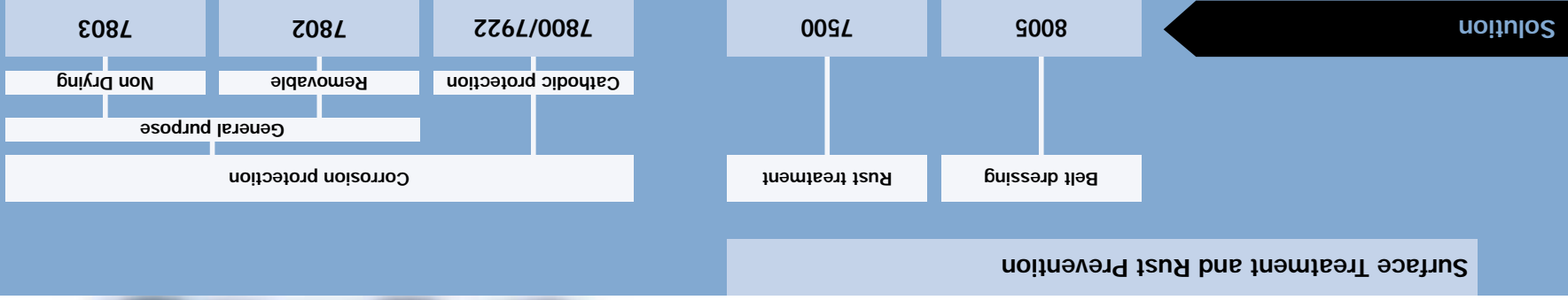


Surface Treatment and Rust Prevention

- Stabilize existing rust
- Guard against corrosion
- Prevent electro-chemical corrosion
- Increase belt friction



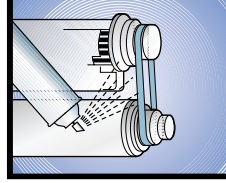
Surface Treatment and Rust Prevention



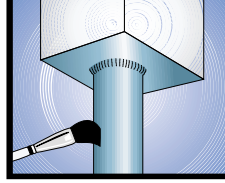
Solution

Description	Colour	Temperature Range	Pack Sizes
Liquid spray	Colourless	-30 to +250 °C	400 ml aerosol
Rust treatment	Matt black	N.A.	1 litre can
Zinc spray	Grey	-50 to +550 °C	400 ml aerosol
Varnish spray	Blue	-10 to +80 °C	400 ml aerosol
Metal protection coating	Amber	-10 to +40 °C	400 ml aerosol

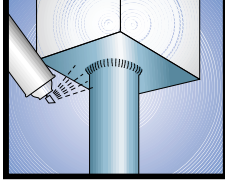
Application Examples



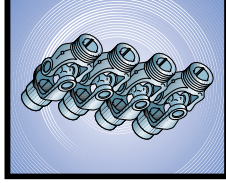
Loctite® 8005
Belt dressing
Recommended to prevent slippage and increase friction for all types of belts.
It extends belt life.



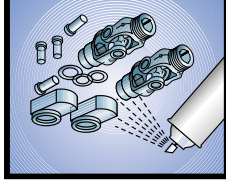
Loctite® 7500
Rust treatment
Cured product acts as a primer ready for painting.
Protect surfaces from corrosion.
Use on metal pipes, valves, fittings, storage tanks, fences, guard rails, conveyors, construction and agricultural equipment.



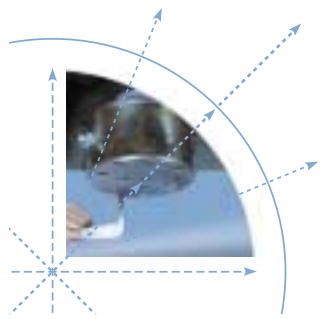
Loctite® 7800
Zinc spray shiny
Loctite® 7922
Zinc spray matt
(Loctite® 7922 is not available in UK.)
Provides excellent cathodic protection on ferrous metals.
Can be used as a primer prior to painting.
Especially suitable for protecting welds from corrosion on galvanised parts.



Loctite® 7802
Varnish spray
(Not available in UK.)
Easy to remove coating that protects equipment such as cutting and stamping tools in perfect condition during indoor and outdoor storage.



Loctite® 7803
Metal protection coating spray
(Not available in UK.)
Non drying, tack free coating which provides long term corrosion protection.
Is compatible with most plastics and elastomeric materials.
Long term protection of metal assemblies such as moulds, machines and outdoor installations.





Fibre-reinforced Plastic Repair

- Repair fibre- or glass-reinforced plastics, wood or metal parts
- Fill and seal cracks, holes and other gaps
- Products are waterproof and paintable
- Repairs can be sanded, shaped and machined
- Join and repair structural panels and stiffeners



Repair, rebuild or join Fibre Reinforced Plastic parts

Handy Hints:

- Use Loctite® 3029 Hardener
- Loctite® 3029 Hardener initiates and speeds the cure of Loctite® Polyester resin based products
- Add the hardener to the resin in the recommended proportions and mix thoroughly

Solution

Bridge and seal large gaps and holes

3022

Repair osmosis blisters and small holes

3024

Fill and seal large gaps and cracks

3025

Strong structural repair

3026

Fit and repair panels and stiffeners

3028

*GRP – Glass Fibre Reinforced Plastic

Description	Colour	GRP*, Steel, Aluminium	Enamel	Wood	Stainless Steel	Mix Ratio by wt.	Working time	Setting time at 20 °C	Sandable after at 20 °C	Pack Sizes
Glassfibre Paste	Blue/Green	Yes	No	Yes	No	97 to 3	8 min.	10 min.	20 min.	165 g, 750 g
Gelcoat Filler	White	Yes	Yes	No	No	96 to 4	8 min.	10 min.	60 min.	165 g
Marine Filler	White	Yes	No	Yes	No	97 to 3	6 min.	10 min.	20 min.	150 g, 665 g
Marine Epoxy	White/Grey	Yes	No	Yes	No	1 to 1	15 min.	60 min.	Cure time 240 min.	150 g
Glass Fibre Resin Kit	Semitransparent Gold	Yes	No	Yes	No	96 to 4	5 min.	10 min.	20 min.	Kit

Application Examples



Loctite® 3022
Two part, glass fibre reinforced
Polyester paste.



Loctite® 3024
Two part Polyester resin.
Can be over-painted to match
topside colour scheme.



Loctite® 3025
Two part Polyester paste.
Water-resistant must be over-
painted if used below the waterline.



Loctite® 3026
Two part epoxy.
Makes a strong and durable repair.
Waterproof, fuel-resistant, paint-
compatible.



Loctite® 3028
Glass Fibre Resin Kit
Two part Polyester resin with
reinforcing glass fibre mat.
The kit contains resin, hardener,
glass fibre mat, mixing cup, spatula
and brush.

Extremely water-resistant.
Sets in 10 min.; can be sanded
after another 10 min.
Recommended for repairing holes
and gaps up to 50 mm in GRP*,
aluminium, steel and wood.

Two part Polyester resin.
Can be combined with Loctite® 3025
for larger repairs.
Fully cured in 60 min. to a water-
proof, hard, white finish.
Specially formulated for minor
damage (osmosis blisters,
scratches and small holes)
in glass fibre and enamelled
surface finishes.

Paint-compatible.
Sets in 10 min.; can be machined,
drilled, tapped and sanded in
further 10 min.
Recommended for filling and sea-
ling large holes and cracks in hull
materials such as glass fibre, steel,
aluminium and wood.

Do not apply a polyester directly to
Loctite® 3026 Marine Epoxy. Seal
the epoxy surface first, using a
primer paint. Ideal for between-tides
repairs to ferrocement and fibre-
reinforced hulls, will also repair
wood, steel, stainless steel, cast iron
and aluminium components.
Stiffeners and panels are joined
of a tough, gap-filling fillet where
and plastics. Enables the formation
materials such as wooden
Recommended for joining different
bulkheads to GRP* hulls or metals

Metal-filled Compounds

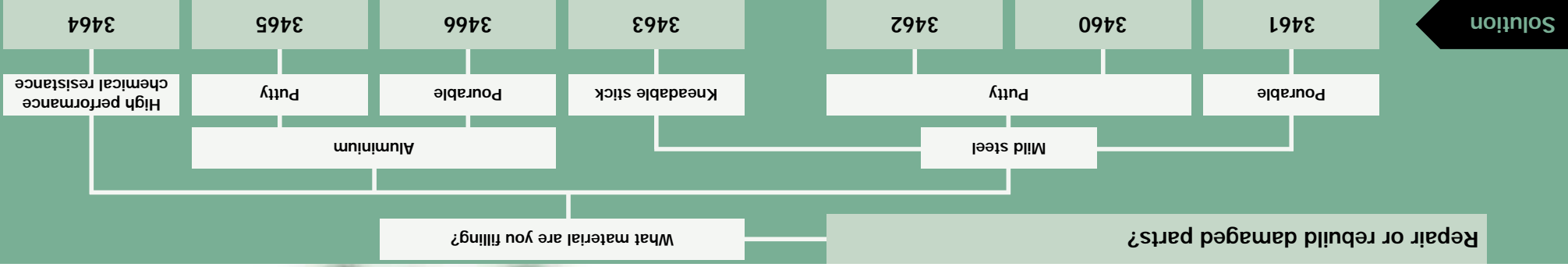


- High compressive strength
- Choice of mild steel, aluminium or non metallic fillers
- Can be machined, drilled or tapped after cure
- Excellent resistance to aggressive chemicals



Repair or rebuild damaged parts?

What material are you filling?



Solution

Description	Colour	Maximum Temperature	Mix Ratio by Vol	Working Time	Cure Time	Pack Sizes
Steel liquid	Grey	105 °C	4 to 1	25 min.	6 hrs	1 kg Kit
Steel putty	Grey	105 °C	2.5 to 1	30 min.	6 hrs	1 kg Kit
Fast set steel putty	Grey	90 °C	1 to 1	3 min.	10 min.	1 kg Kit
Metal Magic Steel™ stick	Dark grey	120 °C	N.A.	3 min.	10 min.	14 g stick
Aluminium liquid	Light grey	90 °C	5 to 1	20 min.	6 hrs	1 kg Kit
Aluminium putty	Light grey	90 °C	4 to 1	20 min.	6 hrs	1 kg Kit
Superior metal putty	Grey	120 °C	4 to 1	20 min.	6 hrs	1 kg Kit

Application Examples



Loctite® 3461
Steel liquid
High steel content.
Pourable filler used for making fixtures and mouldings.



Loctite® 3460
Steel putty
High steel content putty.
Recommended for repairing and rebuilding worn steel components, such as bearing and fan housings.



Loctite® 3462
Fast set steel putty
A fast curing version of steel putty.
Recommended for repairing pipes and other emergency repairs.



Loctite® 3463
Metal Magic Steel™ stick
Kneadable two part paste.
Working time 3 minutes - sets in 10 minutes.
Adheres to damp surfaces.
Recommended for casting replacement parts and for making moulds.
It is ideal for emergency sealing of leaking tanks and pipes.
Smooths welds, repairs small cracks in castings and fills oversized bolt holes.



Loctite® 3466
Aluminium liquid
Fluid, self-leveling aluminium filler.
Can be poured into moulds and cavities.
Recommended for casting replacement parts and for making moulds.



Loctite® 3465
Aluminium putty
General purpose, aluminium putty for repair of all aluminium alloy components.



Loctite® 3464
Superior metal putty
Metal free filler with high compressive strength and chemical resistance.
Recommended for use on all metals.



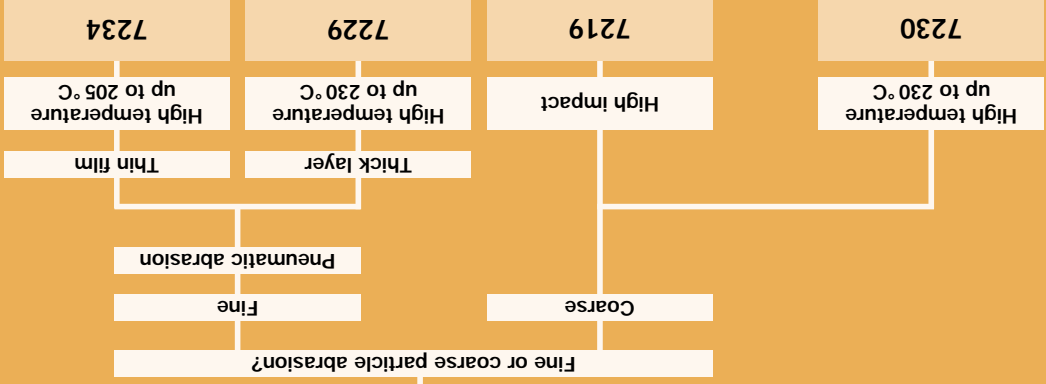
Wearing Compounds



- Restores worn surfaces
- Wear resistant coating
- Use on new parts to extend life
- Available in both trowelable and brushable forms

Repair or rebuild worn surfaces

Solution



Application Examples



Loctite® 7230
High temperature
wearing compound
Trowelable compound that protects against sliding abrasion. Use to rebuild and protect chutes, pump housings, elbows, cyclones and material handling equipment.



Loctite® 7219
High impact
wearing compound
Toughend adhesive absorbs pneumatic wear. Recommended where both sliding abrasion and impacts are present.



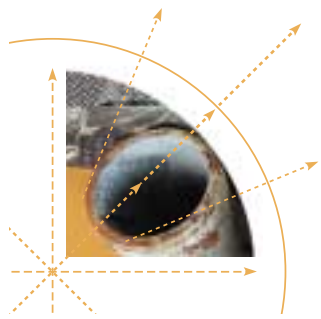
Loctite® 7229
High temperature
pneu wear
Resists fine particle abrasion caused in pipe elbows of pneumatic conveyor systems.



Loctite® 7234
High temperature
brushable ceramic
Smooth, wear resistant, low friction coating to combat turbulence and cavitation on components such as pump housings and impellers.

Description	Colour	Maximum Temperature	Mix Ratio by Volume	Working Time	Cure Time	Pack Sizes
High temperature wearing compound	Grey	230 °C	4 to 1	30 min. 7 to 9 hrs*		10 kg Kit
High impact wearing compound	Grey	120 °C	2 to 1	30 min. 6 hrs		1 kg Kit
High temperature pneu wear	Grey	230 °C	4 to 1	30 min. 6 to 8 hrs*		10 kg Kit
High temperature brushable ceramic	Grey	205 °C	2.75 to 1	30 min. 8 to 14 hrs*		1 kg Kit

* Require heat cure for maximum temperature resistance



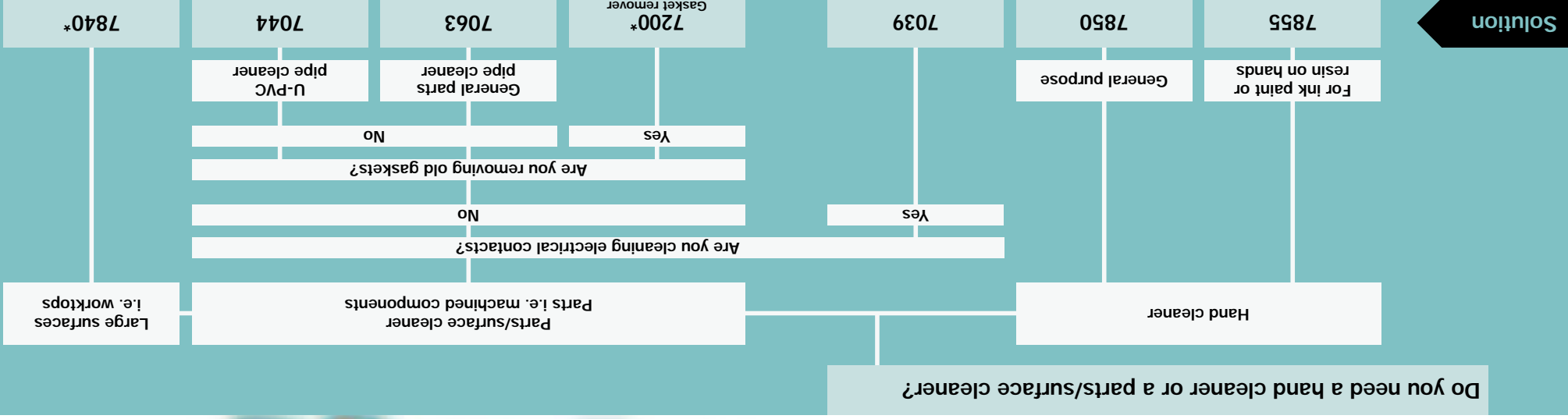


Cleaning

- Clean components prior to using Henkel Loctite Adhesives/Sealants
- Clean and degrease worktops and parts
- Remove cured Sealant residue
- The hand cleaner sub-section includes two very effective, gentle and biodegradable hand cleaners



Do you need a hand cleaner or a parts/surface cleaner?



Solution

Description	Pack Sizes
Hand cleaner 400 ml bottle, 1.75 litre pump dispenser	400 ml bottle, 3 litre pump dispenser
Hand cleaner 400 ml aerosol	400 ml aerosol
Gasket remover	400 ml aerosol
Cleaner and degreaser	400 ml aerosol, 10 litre can, 200 litre drum
Cleaner	1 litre can
Cleaner and degreaser	750 ml trigger spray, 5 litre can, 20/200 litre drum

* For best product performance clean parts with Loctite® 7063 prior to adhesive application

Application Examples



Loctite® 7855
Hand cleaner
Removes paint, resin and adhesives.
Biodegradable and non toxic.



Loctite® 7850
Hand cleaner
Hand cleaner made from natural extracts and free from mineral oils.
Biodegradable. Contains premium relays, switching gear etc. without skin conditioners. Works with or without water. Removes ground-in dirt, grease, grime, and oil.



Loctite® 7039
Contact cleaner spray
Does not affect insulating varnishes. For cleaning electrical contacts, relays, switching gear etc. without affecting insulating varnishes. Displaces moisture and forms a water repellent film.



Loctite® 7200
Gasket remover
Removes cured gasket sealants and traditional gaskets from most types of surfaces in 10 to 15 minutes without scraping.



Loctite® 7063
Cleaner & degreaser
General parts cleaner which leaves no residue - ideal for use prior to adhesive bonding and sealing applications. Compatible with metal, glass, rubber, most plastics and painted surfaces.



Loctite® 7044
U-PVC pipe cleaner
(Not available in UK.)
Product 7044 is a non-aqueous, non-CFC solvent designed for cleaning and degreasing of PVC pipe surfaces before bonding with Loctite® 5004.



Loctite® 7840
Cleaner & degreaser
Biodegradable, solvent free, non-toxic and non flammable, diluted with water.
Rated USA-C1.
Removes grease, oil, cutting fluids and workshop grime.

Surface Preparation - Activators and Primers



- Accelerate cure of Henkel Loctite products even at low temperatures
- Improve adhesion to non-wetting surfaces



Do you need an activator or primer?

Solution	
7251	Primer
7252	Primer
7253	Primer
Improve adhesion to specific surfaces In combination with 5221, 5225, 5226	

Description	Colour	Pack Sizes
Primer	Black	25 ml, 200 ml
Primer	Black	25 ml, 200 ml
Primer	Colourless	25 ml, 200 ml
Primer	Colourless	4 ml
Activator	Colourless	18 g pump
Activator	Blue-green	90 ml pump

Application Examples



Primer Loctite® 7251
Bonding/sealing plastics,
painted materials and wood.



Primer Loctite® 7252
Bonding/sealing glass & glazed
materials.



Primer Loctite® 7253
Bonding/sealing bare metallic
surfaces.



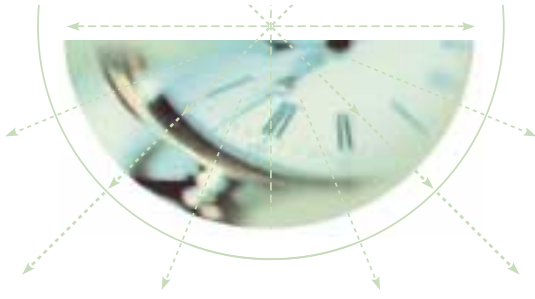
Loctite® 7239
Is a general purpose Primer,
suitable for use on all industrial
plastics, which will improve the
adhesion of instant adhesives.



Loctite® 7458
Cures excess adhesive,
Minimizes post cure blooming
and optimizes bond strength.
Low-odour.
Recommended for any areas where
the speed of cure and aesthetics
requirements are critical to ensure
a neat and consistent bond-line.



Loctite® 7240
Is a solvent-free activator that
increases cure speed on passive
surfaces such as, stainless
steel, aluminium and plated or
passivated metals.





Emergency Repair Products

- Enables rapid repair of damaged or burst pipes, conveyor or drive belts and similar rubber-based components
- Will seal leaks in tanks and other containment vessels in addition to repairing metal parts
- Includes a kit for repairing or replacing damaged O-ring seals and a gas leak detector

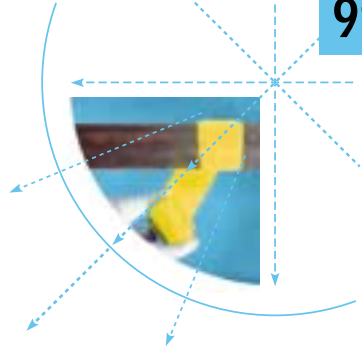


Emergency Repair

Handy Hints:
 ■ Use Rapid Rubber Repair Gun with product Loctite® 3902

Solution	
Gap/void filling or pipe insulation	5007
Replace or repair O-ring seals	O-Ring Kit!
Fill holes, smooth welds, repair non-structural defects?	3463
Detect gas leak?	7100
Stop pipe leaks?	5070
Fix damaged rubber parts?, belts, conveyors,	3902

Application Examples



Loctite® 5007 PU-Foam
 Is a moisture-curing polyurethane foam, which expands to fill and seal gaps and voids. Recommended for sealing pipe entries in walls, insulating pipe-work and tanks, filling gaps around doors and windows, draught-proofing around pipework and cable runs. Cured material can be machined, sanded and painted.



Loctite® O-Ring kit
 Saves the need for complete disassembly. Eliminates the need for an inventory of different sized O-rings. Joints resist water/oil and are as strong as the rubber itself. Recommended for sealing pipe-work and tanks, filling gaps around doors and windows, draught-proofing around pipework and cable runs. Kit contains: 7 standard diameter sizes of nitrile cord, splicing jig, safety knife and Loctite® 406 instant adhesive.



Loctite® 3463 Metal Magic Steel™ stick
 Working time 3 minutes - sets in 10 minutes. Adheres to damp surfaces and cures underwater. It is ideal for emergency sealing of leaking tanks and pipes (i.e. lead, plastic, copper.). Smooths welds, repairs small cracks in castings and fills oversized bolt holes.



Loctite® 7100 Leak Detector
 Facilitates the detection of both micro-leaks and larger leaks in gas handling systems. It will not cause subsequent corrosion and is recommended for use with all gases and gas mixtures except pure oxygen.



Loctite® 5070 Pipe Repair Kit
 Repairs pipe leaks in 1 hour. No tools required. Maximum temperature 120°C. Easy-to-use repair kit. Use for temporary/medium term repair of leaking pipes and reinforcement of weak areas. Kit contains protective gloves, Loctite® Metal Magic Steel™ Stick, and urethane-impregnated GRP tape.



Loctite® 3902 Rapid Rubber Repair Kit
 Fast, long-term repairs of rubber materials. Remains flexible. Easy application. This kit is a fast-curing, two-part flexible adhesive/sealant system in an easy-to-use pack. Operating temperature up to 80°C. Applications include repair of worn and torn conveyor belts and other rubber equipment.





Equipment

- Henkel Loctite dispensing equipment is specially designed to make application and use of Henkel Loctite products fast, precise, clean and economical
- The following is a selection, from an extensive equipment range, of items most relevant to the products in this guide



Loctite® 97001
Peristaltic Hand Pump
 This hand-held applicator is a low-cost, precision bottle top applicator that mounts easily on the top of any Loctite® 50 ml or 250 ml bottle. squeeze tube or in a 300 ml

Loctite® 97002
Hand-Held Cartridge
 Dispenses all Henkel Loctite products packaged in a 250 ml cartridge.

Loctite® 97006
Digital Syringe
 This is a fully-integrated system that will dispense products from water-thin to paste-thick from 10 ml plastic syringes.

Loctite® 97262
Needle Selection Pack
 Selection of dispensing needles which are used for the application of Henkel Loctite products.



Loctite® 97008
Semi-automatic Controller



Loctite® 97121
Pinch Valve Applicator



Loctite® 96003
Rapid Rubber Repair Gun



Loctite® 96001 Mixpac 50
Dispenser



Loctite® 97033
UV Wand System



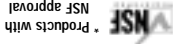
Loctite® 97035
UVALOC Flood System

High intensity spot curing system is a high intensity bench top modular light cure system. It is designed to emit UVA and visible light (blue light) for extremely fast curing. Ideal for high-volume production and short cycle times.

High intensity spot curing system is a high intensity bench top modular light cure system. It is equipped with a 1000 W metal halide lamp. Designed to emit UVA, UVC and visible light.



Product Ordering Information



Products with NSF approval

■ Look for Henkel Loctite Product number on these pages!

PR-No. Product Name Pack-Size Order-No. Page

480	Instant Adhesive, Peel Resistant	500 g	0301381	18
480	Instant Adhesive, Peel Resistant (Collapsible Cartridge)	20 g	0301380	18
454	Instant Adhesive, General Purpose Gel*	300 g	0301339	18
454	Instant Adhesive, General Purpose Gel*	300 g	0301346	18
454	Instant Adhesive, General Purpose Gel*	20 g	0301342	18
454	Instant Adhesive, General Purpose Gel*	10 x 10 mm	0301343	18
431	Instant Adhesive, General Purpose, High Viscosity	500 g	0301335	19
431	Instant Adhesive, General Purpose, High Viscosity	20 g	0301336	19
4062	Instant Adhesive, Wickling	500 g	0301337	19
4062	Instant Adhesive, Wickling	20 g	0301338	19
406	Instant Adhesive, Elastomers	500 g	0301355	18
406	Instant Adhesive, Elastomers	20 g	0301352	18
401	Instant Adhesive, General Purpose*	500 g	0301305	19
401	Instant Adhesive, General Purpose*	300 g	0301303	19
401	Instant Adhesive, General Purpose*	20 g	0301302	19
401	Instant Adhesive, General Purpose*	10 x 3 g	0301021	19
3902	Rapid Rubber Repair Kit	Kit	1096715	47
352	UV Adhesive	250 ml	0701104	21
350	UV Adhesive	0701024	0701024	21
350	UV Adhesive	50 ml	0701023	21
3466	Aluminum Liquid	1 kg	1095307	39
3465	Aluminum Putty	1 kg	1095306	39
3464	Superior Metal Epoxy Twin Syringe	1 kg	1095305	39
3463	Metal Magic Steel™ Slick	114 g	1095304	39/47
3462	Fast Set Steel Putty	1 kg	1095303	38
3461	Steel Liquid	1 kg	1095302	38
3460	Steel Putty	1 kg	1095301	38
3450	Metal Set	25 ml	1101009	23
3430	Structural Adhesive, Fast cure	2 x 24 mm	1101038	23
3425	Structural Adhesive, Toughened	2 x 900 mm	1101083	23
3425	Structural Adhesive, Toughened	10 x 200 mm	1101082	23
3425	Structural Adhesive, Toughened	1101081	1101081	23
3421	Structural Adhesive, High gap fill	2 x 900 mm	1101074	23
3421	Structural Adhesive, High gap fill	200 ml	1101073	23
3421	Structural Adhesive, High gap fill	50 ml	1101072	23
330	Structural Adhesive, Toughened, non-mix*	315 ml	0120011	22
330	MULTI-BOND™ Kit*	50/40 ml	1701172	22
322	UV Adhesive	250 ml	0703604	21
3028	please contact Henkel Loctite			37
3026	please contact Henkel Loctite			37
3025	please contact Henkel Loctite			37
3024	please contact Henkel Loctite			37
3022	please contact Henkel Loctite			36
3022	please contact Henkel Loctite			36
3022	please contact Henkel Loctite			36
3020	Caskets Adhesive	400 ml	0501061	14
302	UV Adhesive	250 ml	0702147	20
290	Threadlocker, Wickling	250 ml	0103364	10
290	Threadlocker, Wickling	50 ml	0103363	10
290	Threadlocker, Wickling	12 x 10 mm	0103360	10
2701	Threadlocker, High Strength	250 ml	0103311	11
2701	Threadlocker, High Strength	50 ml	0103310	11
270	Threadlocker, High Strength	250 ml	0113033	11
270	Threadlocker, High Strength	50 ml	0113032	11
270	Threadlocker, High Strength	12 x 10 mm	0103303	11
243	Threadlocker, Medium Strength*	250 ml	0102244	11
243	Threadlocker, Medium Strength*	50 ml	0102248	11
243	Threadlocker, Medium Strength*	12 x 10 mm	0103242	11
222	Threadlocker, Low Strength*	250 ml	0103013	11
222	Threadlocker, Low Strength*	50 ml	0103012	11
222	Threadlocker, Low Strength*	12 x 10 mm	0103114	11
480	Instant Adhesive, Peel Resistant	500 g	0301381	18
480	Instant Adhesive, Peel Resistant (Collapsible Cartridge)	20 g	0301380	18
454	Instant Adhesive, General Purpose Gel*	300 g	0301339	18
454	Instant Adhesive, General Purpose Gel*	300 g	0301346	18
454	Instant Adhesive, General Purpose Gel*	20 g	0301342	18
454	Instant Adhesive, General Purpose Gel*	10 x 10 mm	0301343	18
431	Instant Adhesive, General Purpose, High Viscosity	500 g	0301335	19
431	Instant Adhesive, General Purpose, High Viscosity	20 g	0301336	19
4062	Instant Adhesive, Wickling	500 g	0301337	19
4062	Instant Adhesive, Wickling	20 g	0301338	19
406	Instant Adhesive, Elastomers	500 g	0301355	18
406	Instant Adhesive, Elastomers	20 g	0301352	18
401	Instant Adhesive, General Purpose*	500 g	0301305	19
401	Instant Adhesive, General Purpose*	300 g	0301303	19
401	Instant Adhesive, General Purpose*	20 g	0301302	19
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3462	Fast Set Steel Putty	1 kg	1095303	38
3461	Steel Liquid	1 kg	1095302	38
3460	Steel Putty	1 kg	1095301	38
3450	Metal Set	25 ml	1101009	23
3430	Structural Adhesive, Fast cure	2 x 24 mm	1101038	23
3425	Structural Adhesive, Toughened	2 x 900 mm	1101083	23
3425	Structural Adhesive, Toughened	10 x 200 mm	1101082	23
3425	Structural Adhesive, Toughened	1101081	1101081	23
3421	Structural Adhesive, High gap fill	2 x 900 mm	1101074	23
3421	Structural Adhesive, High gap fill	200 ml	1101073	23
3421	Structural Adhesive, High gap fill	50 ml	1101072	23
330	Structural Adhesive, Toughened, non-mix*	315 ml	0120011	22
330	MULTI-BOND™ Kit*	50/40 ml	1701172	22
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2701	Threadlocker, High Strength	250 ml	0103311	11
2701	Threadlocker, High Strength	50 ml	0103310	11
270	Threadlocker, High Strength	250 ml	0113033	11
270	Threadlocker, High Strength	50 ml	0113032	11
270	Threadlocker, High Strength	12 x 10 mm	0103303	11
243	Threadlocker, Medium Strength*	250 ml	0102244	11
243	Threadlocker, Medium Strength*	50 ml	0102248	11
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3464	Superior Metal Epoxy Twin Syringe</			

X-ON Electronics

Largest Supplier of Electrical and Electronic Components

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[8106, 1L](#) [5800, 50ML](#) [MM01057](#) [1188112](#) [LOC-5615/400ML](#) [97262](#) [983438](#) [3463, 114G](#) [2700, 50ML](#) [648, 50ML](#) [40945](#) [MM01056](#)
[386862](#) [984569](#) [5400, 50ML](#) [5990, 40ML](#) [SUPERLUBE OIL, 375ML](#) [MM01939](#) [290](#) [98472](#) [GC 10 TYPE 3 \(JAR\)](#) [660, 50ML](#) [SUPER](#)
[GLUE GLASS, 3G](#) [LOC-MIKSER](#) [6300, 50ML](#) [2023641](#) [LT 5075](#) [GC 10 TYPE 4 \(JAR\)](#) [495, 50G](#) [243, 250ML](#) [LOC-638-10](#) [641, 10ML](#)
[496, 50G](#) [2472659](#) [98473](#) [5660, 40ML](#) [4080, 50G](#)