

LOCTITE®

Solution Guide



Henkel



Issue 5

Making the Right Choice

With this solution guide you can easily select the best Loctite® product from the Henkel portfolio 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
- Loctite® product categories from the Henkel portfolio
- A product list including ordering information

For more information about our products or us just „hit“ our 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 Loctite® products from the Henkel portfolio, addressing segments such as Industrial OEM, Automotive, Electronics, Maintenance and Repair.





For additional information
visit our Web Site, at:


www.loctite.co.uk



4  Problem Solving Guide


10  Threadlocking
Locking of Threaded Fasteners

12  Pipe and Thread Sealing
Sealing of Threaded Components

14  Gasketing
Sealing of Flanges

16  Retaining
Securing Cylindrical Assemblies

18  Instant Bonding

20  Structural Bonding

22  Flexible Sealing and Bonding


24  Lubrication

30  Surface Treatment and Rust Prevention

32  Metal-filled Compounds

34  Wearing Compounds

36  Cleaning


38  Surface Preparation
Activators and Primers

39  Emergency Repair Products

40  Gearbox & Pump Repair

42  Maintenance Workshop

44  Equipment

45  Product Ordering Information

51  Measurement Table



What's the Problem?

Nuts, Bolts, Studs, Threaded Parts



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

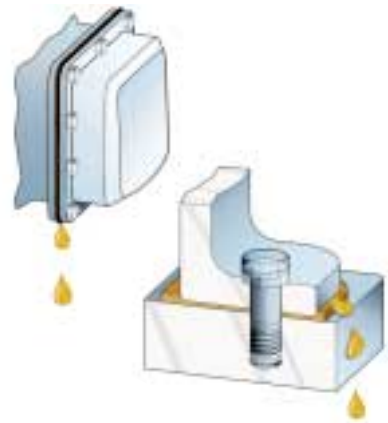
Fluid Pipe Systems



- ? Leaks from hydraulic, air, coolant, oil or other threaded fittings
- ? 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

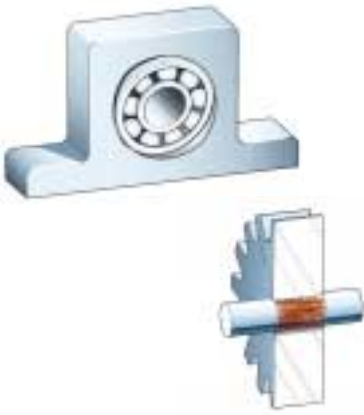
See also Emergency Repair Products on page 39

Flanges Leaking



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

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

Page 16

Retaining

Joining Small Parts

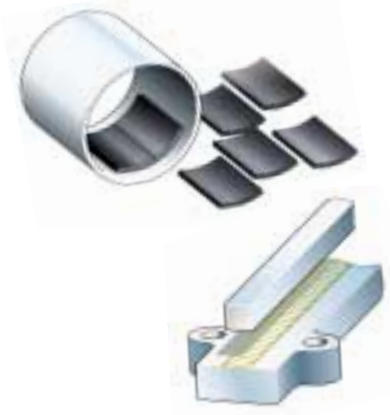


- ? Join different materials rapidly
- ? Bond parts temporarily during positioning or repair
- ? Re-use broken parts
- ? Need to speed up production

Page 18

Instant Bonding

Joining Large/ Structural Parts



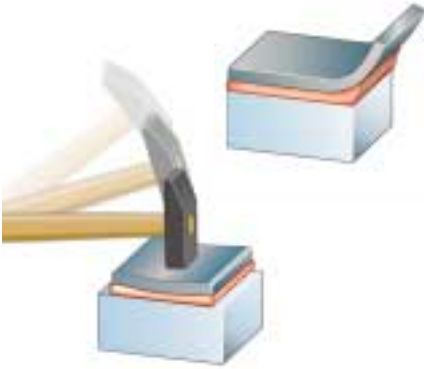
- ? Strong durable joints between different materials
- ? Replace welding/riveting – with a corrosion-free, reduced stress joint

Page 20

Structural Bonding

What's the Problem?

Flexible Joining of Parts



- ? Impact and vibration-resistant joint
- ? Permanently flexible bonding of different materials
- ? Joints have large gaps or are subject to high temperatures

Page 22

Lubrication



- ? Need to combat wear and seizing caused by friction
- ? Resist high temperatures and tough operating conditions

Page 24

Corroding Components



- ? Prevent corrosion after assembly or during storage
- ? Guard against electro-chemical effects
- ? Protect welds at high temperatures

Page 30

Worn and Damaged Parts



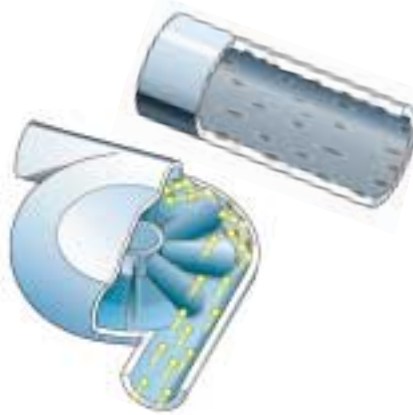
- ? Re-build, restore, repair metal parts and assemblies
- ? Make castings, moulds and fixtures

See also Emergency Repair Products on page 39

Page 32

Metal Filled Compounds

Wear



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

Page 34

Wearing Compounds

Cleaning Parts and Hands



- ? 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

Page 36

Cleaning

What's the Problem?

Slow Adhesive/ Poor Adhesion



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

Page 38

Emergency Repair



- ? 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

Page 39

Gearbox & Pump Repair



- ? Prevent costly breakdowns
- ? Increase reliability and performance
- ? Make any size or shape gasket
- ? Prevent fretting and corrosion

Page 40

Best Practice



- ? Reduce routine maintenance tasks and unnecessary repairs
- ? Reduce standard and extended repair time
- ? Improve safety by eliminating personal injury hazards
- ? Reduce disposal costs, clean up time and materials

Page 42

Dispensing and Curing Adhesives and Sealants



- ? Apply thick or thin products easily, cleanly, accurately and without waste

Page 44

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 sections:

- Threadlocking
- Pipe and Thread Sealing
- Gasketing
- Retaining and Securing Cylindrical Assemblies
- Instant Bonding
- Structural Bonding
- Lubrication – Oils & Dry Film
- Lubrication – Greases
- Lubrication – Anti-Seize

Product Pack Sizes & Order Numbers

Page 45

Maintenance
Workshop

Equipment

Product Ordering
Information



Threadlocking – Locking of Threaded Fasteners

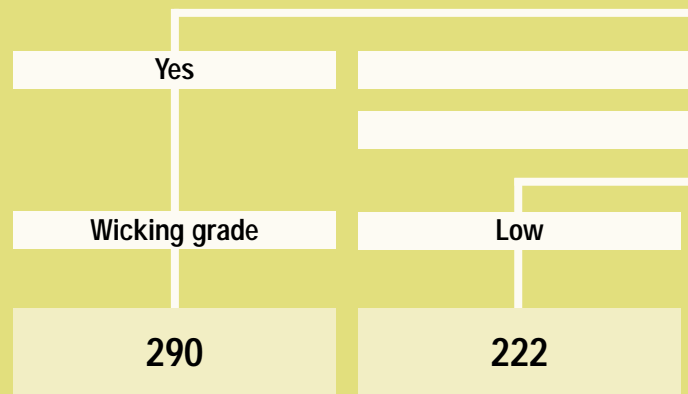
- Resists vibration
- Single part – clean and easy to apply
- Can be used on all sizes of fasteners – reduces inventory costs
- Seals threads – allows through-hole tapping

Are the parts already assembled?

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
- If one substrate is plastic look at page 18/19 Instant Bonding

Solution



Size of Thread	Up to M 6	Up to M36
Strength	Medium/High	Low
Functional Strength ¹	3 hrs	6 hrs
Breakaway Torque M10 bolts	10 Nm	6 Nm
Long-Term Temperature Resistance	+150 °C	+150 °C
Pack Sizes	10 ml, 50 ml, 250 ml	10 ml, 50 ml, 250 ml

¹ Typical 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.
P1 NSF Reg. No.: 123002





No

What strength do you require?

Medium		High	
Liquid	Semi-solid	Liquid	Semi-solid
243	248	2701 (improved 270)	268
Up to M 36	Up to M 50	Up to M 20	Up to M 50
Medium	Medium	High	High
2 hrs	6 hrs	6 hrs	24 hrs
20 Nm	19 Nm	38 Nm	25 Nm
+150 °C	+150 °C	+150 °C	+150 °C
10 ml, 50 ml, 250 ml	9 g, 19 g stick	10 ml, 50 ml, 250 ml	9 g, 19 g stick



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. Recommended for use where disassembly with hand tools is required for servicing and where parts are contaminated with oil. P1 NSF Reg. No.: 123000 Certified to ANSI/NSF Standard 61



Loctite® 248

Convenient to use, no migration. Suitable where product application access is difficult – overhead, under, or around machinery – on components that cannot be moved. Effective on all types of metal threaded fasteners. Recommended for applications where disassembly is required – Machine tools and presses, pumps and compressors, mounting bolts, gear boxes. Certified to ANSI/NSF Standard 61



Loctite® 2701 (improved Loctite® 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



Loctite® 268

Convenient to use, no migration. Suitable where product application access is difficult – overhead, under, or around machinery – on components that cannot be moved. Effective on all types of metal threaded fasteners. Recommended for use where regular removal for maintenance is not required – suspension bolts, motor transmission and pump mounts, bearing cap bolts and studs.



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?

Handy Hints:

- All parts must be clean & dry before sealing – use Loctite® 7063
- If the sealant (Loctite® 542, 577, 572 or 561) will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator)
- If the parts have been in contact with washes or cutting fluids containing nitrites wash them with hot water¹

Solution

Plastic or combined plastic/metal parts	
Do you need to make post assembly adjustments?	
Yes	No
Cord	Liquid
55	5331

Description	Cord	Curing gel
Maximum Pipe Size	Tested to 4"	3"
Temperature Resistance	+130 °C	+150 °C
Disassembly Strength	Low	Low
Substrate to be Sealed	Metal, plastic or both	Metal, plastic or both
Instant Low Pressure Seal	Yes (full pressure)	Yes
Pack Sizes	50 m, 150 m cord	100 ml

¹ Does not apply to Loctite® 5331/55

Application Examples



Loctite® 55

Can be safely applied on metal and plastics threaded fittings.
Potable water: WRC listed for use with potable water up to 85 °C, meets BS 6920.
KTW recommendation for cold and hot water.
Gas and water: Carries the 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 plastic or plastic/metal fittings carrying hot or cold water e.g. industrial and agricultural plastic water pipe systems, or drainage systems.
WRC approved for use with potable water up to 85 °C.
P1 NSF Reg. No.: 123620





Metal parts

Are the threads fine or coarse?

**Fine up to (R³/₄)
pipe thread**

Coarse up to (R3) pipe thread

Semi-solid

542
(Hydraulic and pneumatic)

577
(General purpose)

572
(Slow cure)

561

Curing liquid

Curing gel

Curing gel

Curing semi-solid

3/4"

3"

3"

3"

+150 °C

+150 °C

+150 °C

+150 °C

Medium

Medium

Medium

Low

Metal

Metal

Metal

Metal

No

Yes

Yes

Yes

10 ml, 50 ml, 250 ml

50 ml, 250 ml

50 ml, 250 ml

19 g stick



Loctite® 542

Recommended for fine threaded fittings as used in hydraulic and pneumatic installations and small fittings in general. 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.



Loctite® 577

Recommended for all coarse metal threads. Suitable for fast applications at low temperatures e.g. outdoor plant maintenance. Carries the German DVGW approval (NG-5146 AR 0621). Tested in accordance to EN 751-1. Meets BS 6956 type B for sealing gas fittings. WRC approval for use with potable water. P1 NSF Reg. No.: 123001 WRC Approval 0302507



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.



Loctite® 561

Convenient to use, no migration. Recommended for all coarse metal threads, where disassembly is required. Ideal for use in a broad range of industries including chemical processing, waste water treatment, and automotive. Certified to ANSI/NSF Standard 61.



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:

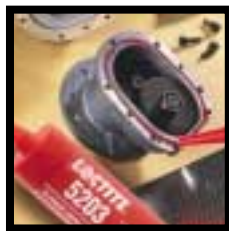
- If there are traces of old gasket left on the parts to be sealed, clean with Loctite® 7200 gasket remover
- All parts must be clean and dry before sealing – use Loctite® 7063
- Anaerobic products cure between metal surfaces in the absence of air
- Use activator Loctite® 7240 in cold conditions to speed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

Solution

		Yes			
		Coat existing gasket	Positioning cut gaskets		
		Paste	Semi-solid	Semi-solid	Gel
		5203	534	548	574

Gasket Type	Formed-in-place	Use with cut gaskets	Formed-in-place	Formed-in-place
Flange Type	Rigid	Rigid or Flexible	Rigid	Rigid
Cure Method	Anaerobic	Anaerobic	Anaerobic	Anaerobic
Tack-Free Time	N.A.	N.A.	N.A.	N.A.
Temperature Resistance	150 °C	150 °C	150 °C	150 °C
Instant Seal	Excellent	Excellent	Excellent	Excellent
Oil Resistance	Excellent	Good	Good	Excellent
Water/Glycol Resistance	Moderate	Good	Good	Excellent
Pack Sizes	50 ml, 300 ml cartridge	9 g, 19 g stick	9 g, 18 g stick	50 ml, 160 ml cartridge 250 ml tube

Application Examples



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



Loctite® 534 Gasket Positioner
Adhesive/sealant for holding pre-cut gaskets in place during assembly. Can be applied to all rubber, cork, paper and metal gaskets.



Loctite® 548
Recommended for all types of rigid iron, steel and aluminium flanges.



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



No			
What gap must the sealant fill?			
Up to 0.25 mm		Greater than 0.25 mm	
Metals		Plastic or combined plastic/metal parts	
Paste	Paste	Paste	Paste
518	510	5910	5699

Formed-in-place	Formed-in-place	Formed-in-place	Formed-in-place
Rigid	Rigid	Flexible	Flexible
Anaerobic	Anaerobic	Moisture	Moisture
N.A.	N.A.	20 min.	10 min.
150 °C	up to 200 °C	200 °C	200 °C
Excellent	Excellent	Excellent	Excellent
Excellent	Excellent	Excellent	Good
Excellent	Excellent	Moderate	Excellent
50 ml, 65 ml, 300 ml cartridge	50 ml, 160 ml, 250 ml cartridge	300 ml cartridge	300 ml cartridge



Loctite® 518
Recommended for use on rigid iron, steel and aluminium flanges.
P1 NSF Reg. No.: 123758



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



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?

Handy Hints:

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

Yes
(gaps to 0.5 mm)

Yes

Liquid

Solution

660
(with Activator 7240)

641

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

¹ at room temperature on steel joints

Application Examples



Loctite® 660
(use with Activator
Loctite® 7240)
Used for repairing worn coaxial parts without remachining; enables re-use of worn bearing seats, keys, splines, tapers, or 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 and into housings.



	No (gaps to 0.25 mm)		
	Will the parts be dismantled later for maintenance? i.e. bearings		
	No		
	Temperatures above 150 °C?		
	Yes (to 175 °C)	No	
		How big is the gap?	
Semi-solid		Up to 0.25 mm	Up to 0.1 mm
668	648	638	603 (improved 601)
Medium	High	High	High
30 min.	5 min.	8 min.	8 min.
Up to 0.15 mm	Up to 0.15 mm	Up to 0.25 mm	Up to 0.1 mm
150 °C	175 °C	150 °C	150 °C
9 g, 19 g stick	50 ml, 250 ml	50 ml, 250 ml	10 ml, 50 ml, 250 ml



Loctite® 668
Medium Strength Retaining Stick
 Convenient to use. Suitable where product application access is difficult – overhead, under or around machinery – on components that cannot be moved. Recommended for all kinds of retaining applications with medium strength.



Loctite® 648
 Recommended for high temperature retaining of parts with a clearance or interference fit i.e. retaining bushes, bearings, seals, fans, and liners.



Loctite® 638
 Gives best resistance to dynamic, axial and radial loads. Recommended for retaining shafts, gears, pulleys and similar cylindrical parts. KWT approval for cold and hot water. P1 NSF Reg. No.: 123010 WRC Approval 9909511



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, TVP

Handy Hints:

- To improve adhesion to difficult to bond materials e.g. PE, PP, PTFE, TVP or thermoplastic rubbers; in combination with Loctite® 401, 406, 431, 454, 480 or 4850 – use Primer Loctite® 7239
- For difficult to bond plastics PE and PP look also at Loctite® 3030 Polyolefin Bonder, page 20.
- To increase the cure speed of Instant Adhesives in combination with Loctite® 401, 406, 431, 454 and 4850 – use Activator Loctite® 7458.

Yes

Do any of the following apply?

If one or more apply

Yes

Solution

406
(with Primer 7239)

454

480

Operating Temperature	Up to 80 °C	Up to 80 °C	Up to 100 °C
Fixture Time ¹	10 – 20 sec.	5 – 20 sec.	60 – 120 sec.
Viscosity mPa.s	20	Gel	300
Especially for	Plastics	Porous Substrates	Metal/Plastics
Pack Sizes	20 g, 500 g	10 g, 20 g, 300 g, 300 g cartridge	20 g, 500 g

¹ on steel

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 with applications where high peel strength is required and/or shock loads are present.



No

Is the gap over 0.1 mm? Do you require a non-drip/non-run product?

No

Is the bond going to be subject to shock or peel loads?

No

Bonding flexible materials

4850

4062

401

431

Up to 70 °C

Up to 80 °C

Up to 80 °C

Up to 80 °C

5 – 20 sec.

3 – 20 sec.

5 – 20 sec.

5 – 20 sec.

400

2

110

1,000

Flexible Substrates

Metal/Plastics

Porous Substrates

Porous Substrates

20 g, 500 g

20 g, 500 g

3 g, 20 g, 50 g, 500 g

20 g, 500 g



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, gaiters, and loudspeaker assemblies.



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



Loctite® 401
 General purpose for bonding most substrates such as plastics, rubber, metals, card, wood.
P1 NSF Reg. No.: 123011



Loctite® 431
 Particularly suitable for bonding porous or absorbent materials such as: wood, paper, leather, cork and fabric.



Structural Bonding

- Bond 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 main performance are you looking for?

Handy Hints:

- All parts must be clean & dry before bonding – use Loctite® 7063
- For slow curing products, clamp during cure

Is one of the substrates a difficult to bond plastic, like HDPE, LDPE, PP or polyolefin?

General purpose

Solution

3030

3421 A&B

330/7388
MULTI-BOND®

Description	2K-Acrylic	2K-Epoxy	2-part-acrylic (no mix)
Mix Ratio by Volume	10:1	1:1	-
Mix Ratio by Weight	N.A.	100:90	-
Working Life	3 min.	180 min.	-
Fixture Time	< 10 min.	240 min.	5 min.
Colour	Off white	Clear amber	Light amber
Viscosity	15 Pa.s	40 Pa.s	67.5 Pa.s
Operating Temperature	up to 100 °C	up to 100 °C	up to 100 °C
Pack Sizes	35 ml dual cartridge	50 ml, 200 ml, 400 ml dual cartridges; 1 kg can	18 ml, 50 ml Kit, 315 ml cartridge

Application Examples



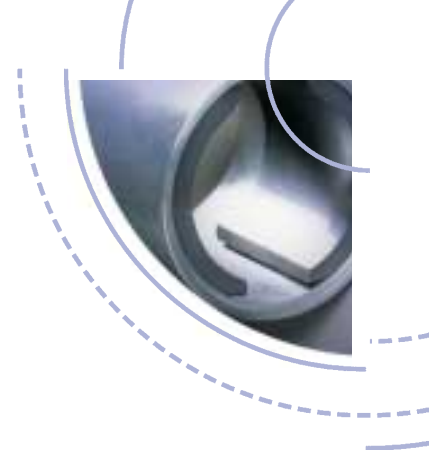
Loctite® 3030 is designed for bonding difficult to bond substrates, such as HDPE, LDPE, and PP. The product offers good resistance to many chemicals, allowing it to be used to assemble small appliances, signs and displays, speaker components, battery cases, liquid tanks, and storage bins. The product contains 0.25 mm glass beads for bondline thickness control.



Loctite® Hysol® 3421 A&B is a general purpose, 2K-Epoxy adhesive, for bonding large surfaces which require a long open time. Ideal for bonding metals, plastics and most other surfaces which will be subjected to high humidity environments.



Loctite® 330/7388 MULTI-BOND® 50 ml Kit is a two part no mix, fast curing, toughened adhesive with good impact resistance. Ideal for bonding dissimilar substrates, including plastics like PC, PVC, phenolic and acrylic.
Loctite® 330:
P1 NSF Reg. No.: 123005



Five-minute		Toughened		High temperature			
3430 A&B		3450 A&B		9466 A&B		9492 A&B	
2K-Epoxy		2K-Epoxy		2K-Epoxy		2K-Epoxy	
1:1		1:1		2:1		2:1	
100:100		100:105		100:50		100:50	
4 min.		4 min.		60 min.		15 min.	
12 min.		12 min.		180 min.		75 min.	
Ultra clear		Grey		Off-white		White	
25 Pa.s		35 Pa.s		30 Pa.s		30 Pa.s	
up to 80 °C		up to 100 °C		up to 120 °C		up to 180 °C	
24 ml twin syringe		25 ml twin syringe		50 ml, 400 ml dual cartridges; 1 kg can		50 ml, 400 ml dual cartridges	



Loctite® Hysol® 3430 A&B is a five-minute, 2K-Epoxy adhesive, suitable for applications requiring an optically clear bond line. Ideal for bonding glass, decorative panels and displays and general repair applications.



Loctite® Hysol® 3450 A&B is a five-minute, 2K-Epoxy adhesive, suitable where large gaps are present. Ideal for bonding and filling damaged components.



Loctite® Hysol® 9466 A&B is a toughened, 2K-Epoxy adhesive, suitable for multi purpose applications requiring long open time and high bonding strength. Ideal for a wide variety of substrates like metals, ceramic and most plastics.



Loctite® Hysol® 9492 A&B is a high operating temperature resistant, 2K-Epoxy adhesive, suitable for multi purpose applications. Ideal for bonding electronic components and mesh to frames.



Flexible Sealing and Bonding

- Withstand impact shock and bending
- 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?

Yes

Solution

5145

Operating Temperature	Up to 200 °C
Paintable	No
Cure Method	Moisture
Skin Over Time	70 min
Viscosity	Paste
Especially for	Electrical components
Colour Variations	Translucent
Pack Sizes	40 ml , 300 ml

Loctite® 5221/5225/5226 and Loctite® 5062/5063/5064/5065/5066/5068/5069 are now available under the Teroson brand name. Please contact us for the Teroson catalogue.

Application Examples



Loctite® 5145
Flexible non-corrosive electrical grade Adhesive/Sealant
 Low odour, neutral cure that does not corrode electrical and electronic components.





No

Do you require high temperature resistance?

Yes

Up to 250 °C

Up to 350 °C

5366

5398

5399

Up to 250 °C

350 °C

Up to 350 °C

No

No

No

Moisture

Moisture

Moisture

5 min.

8 – 10 min.

5 min.

Paste

Liquid

Paste

Glass

Sealing / Potting

Oven door seals,
heat source sealing

5366 – Clear
5367 – White
5368 – Black

Red

Red

310 ml

310 ml

310 ml



Loctite® 5366/5367/5368
Flexible Adhesive/Sealant
Cures to a flexible rubber.
Recommended for bonding, sealing and protecting components subjected to vibration. Suitable for glass, metal, ceramics, composites, and most plastics.



Loctite® 5398
Flexible Adhesive/Sealant
Recommended for sealing heat exchangers, steam circuits, water heaters, ovens and in equipment such as turbines and pumps. 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 temperature can reach 350 °C, e.g. sealing of stove flues/chimneys, industrial ovens, electro-appliances and ventilation systems.

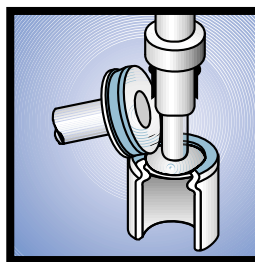


Lubrication – Oils and Dry Film

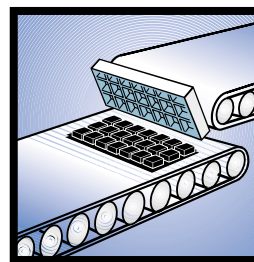
- Prevent seizing and galling during assembly and operation
- Inhibit corrosion and oxidation in chemically and thermally aggressive environments
- Penetrate and free corroded assemblies
- Prevent wear and cold welding during assembly and operation

Solution	Dry film lubricant		
	General purpose	Food grade	Low viscosity penetrating oil
	8191	8192	8001 (Food grade)
Appearance	Black	Off white paste	Colourless
Base	MoS ₂	PTFE	Mineral oil
Viscosity	-	-	11 mm ² /s
Temperature Range	-180 to +450 °C	-180 to +260 °C	-20 to +120 °C
Load Test 4 Ball N	-	-	1800
Pack Sizes	400 ml aerosol	400 ml aerosol	400 ml aerosol

Application Examples



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



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® 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 seats, collars, chains, hinges, cutting knives in food transport equipment and sewing machines.
H1 NSF Reg. No.: 122999

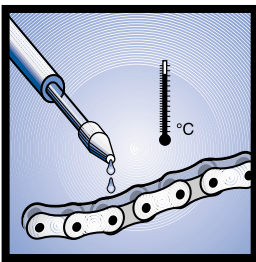




Oil

Lubricate chains	Free rusted and seized parts	Silicone oil	Cutting oil	General purpose
8011	8018	8021	8030/8031	8201

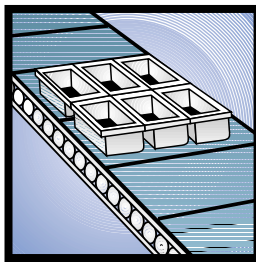
Yellow	Colourless	Colourless liquid	Light yellow liquid	Light yellow liquid
Synthetic oil	Mineral oil	Silicone oil	Mineral oil	Mineral oil
11 mm ² /s	< 100 mPa.s	350 mPa.s	8030: 175 mm ² /s 8031: 46 mm ² /s	17.5 mm ² /s
-30 to +250 °C	N.A.	-30 to +150 °C	N.A.	-20 to +120 °C
1260	N.A.	N.A.	5000	-
400 ml aerosol	400 ml aerosol	400 ml aerosol	8030: 250 ml bottle, 8031: 400 ml aerosol	400 ml aerosol



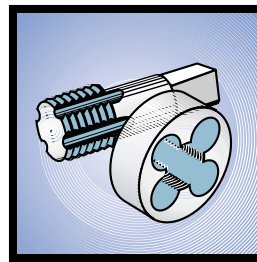
Loctite® 8011
High temperature chain oil spray
 (Not available in UK.)
 Oxidation resistance prolongs lubricant service life. This product is used for the lubrication of open mechanisms, conveyors and chains at elevated temperatures up to 250 °C.
H2 NSF Reg. No.: 122978



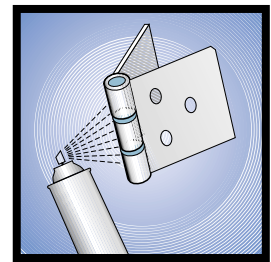
Loctite® 8018
Solvo Rust
 Releases rusted, corroded and seized components. A penetrating oil to free rusted nuts, bolts, screws, fittings, other fasteners as well as metal components in industrial equipment. Also recommended for cleaning parts before lubrication and as light lubricant and rust inhibitor.



Loctite® 8021
Silicone oil
 This product is a general purpose, low viscosity silicone oil used for lubricating metal and non metal surfaces. It may also be used as a release agent.



Loctite® 8030 bottle
Loctite® 8031 aerosol
Cutting oil
 (Not available in UK.)
 Protects cutting tools in operation. To be used when drilling, sawing or tapping steel and most non-ferrous metals. It is especially designed for use with stainless steel.



Loctite® 8201
Five way spray
 Frees, lubricates, cleans. Displaces moisture, and prevents corrosion. Ideal for light lubrication of metals and freeing assemblies.

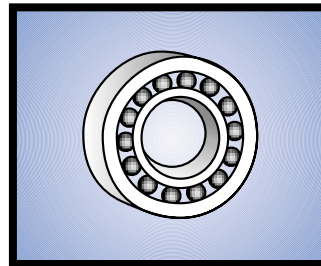


Lubrication – Greases

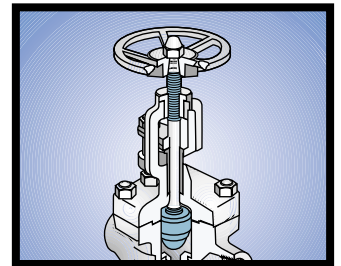
- Prevent seizing and galling during assembly and operation
- Inhibit corrosion and oxidation in chemically and thermally aggressive environments
- Withstand high temperatures and extreme pressures

Solution	General purpose	Food grade
	8106	8104
Appearance	Light Brown	Colourless smooth paste
Base Oil and Additives	Mineral	Silicone
Viscosity	Paste	Paste
Thickener	Lithium soap	Silica gel
Drop Point	185 °C	-
N.L.G.I. Class	2	2/3
Speed Characteristics DN Factor	450,000	50,000
Temperature Range	-15 to + 150 °C	-50 to +200 °C
Load Test 4 Ball N	2500 Weld load	N.A.
Pack Sizes	400 ml cartridge, 1 litre can	1 litre can

Application Examples



Loctite® 8106
Multi-purpose grease
 (Not available in UK.)
 Lubricant for moving parts. It provides corrosion protection and is used for rolling and plain bearings and slideways.

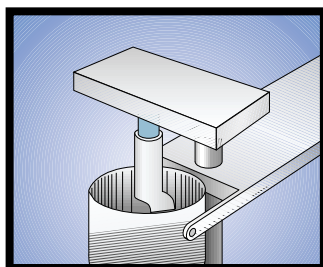


Loctite® 8104
Food grade silicone grease
 Recommended for lubrication of most elastomeric and plastic parts. Food approved. Meets CNERNA Guide 1992. H1 NSF Reg. No.: 122981

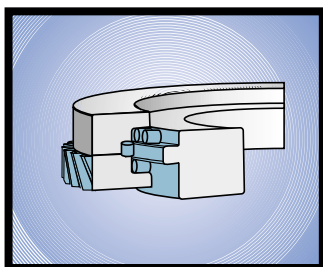


Grease

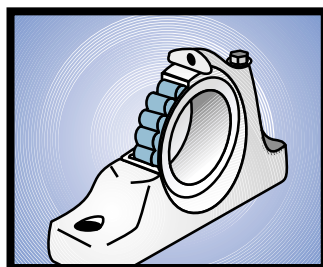
products	High performance			Chains, gears
8105	8102	8103	8101	
White	Beige high tack paste	Black smooth paste	Amber high tack paste	
Mineral	Mineral E.P.	Mineral E.P. MoS ₂	Synthetic E.P.	
Paste	Paste	Paste	Paste	
Inorganic gel	Lithium soap complex	Lithium soap	Lithium soap	
None	290 °C	>190 °C	>190 °C	
2	2	2	2	
150,000	500,000	500,000	N.A.	
-20 to +150 °C	-30 to +200 °C	-20 to +150 °C	-25 to +170 °C	
1600 Weld load	3150 Weld load	3500 Weld load	3150 Weld load	
400 ml cartridge	400 g cartridge, 1 litre can	400 g cartridge, 1 litre can	400 ml aerosol	



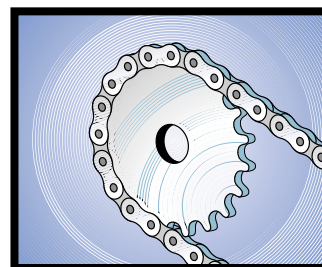
Loctite® 8105
Food grade mineral grease
 (Not available in UK.)
 Lubricant for moving parts. Recommended for use on equipment in food processing and pharmaceutical industries. It is ideally suited for bearings, cams, valves and conveyors for food and pharmaceutical products.
 H1 NSF Reg. No.: 122979



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, 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-fling properties. Use on open mechanisms such as chains and gears.



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

Do you need?

Handy Hints:

- Loctite® 8060 and Loctite® 8065 now offer the same trusted performance in a semi-solid stick formula, but clean, fast and easy to apply.

High performance applications

Use in high humidity/water concentrations

High purity ideal for nuclear applications

Use for long term protection of all metals

Eliminate friction seizure during assembly (high % MoS₂)

Marine grade Anti-Seize

N-7000 High purity Anti-Seize

Heavy duty Anti-Seize

Moly paste

Solution

8023

8013

8009

8012

Colour	Black	Dark grey	Black	Black
Solid Lubricating Agent	Graphite, calcium, boron nitride & rust inhibitors	Graphite & calcium oxide	Graphite & calcium fluoride	MoS ₂ & rust inhibitors
Torque Coefficient (K)	0.18	0.16	0.16	0.11
N.L.G.I. Class	1	1	1	1
Temperature Range	-30 to +1315 °C	-30 to +1315 °C	-30 to +1315 °C	-30 to +400 °C
Pack Sizes	454 g brush top	454 g brush top	454 g brush top, 3.6 kg can	454 g brush top, 6.8 kg can
Approvals	American Bureau of Shipping certified MIL-PRF-907E	PMUC D50YP12 General Electric TIL 1117-3R1	-	-

Application Examples



Loctite® 8023 brush top Anti-Seize with ultimate wash out resistance. Suitable for use on stainless steel.



Loctite® 8013 brush top High purity metal free Anti-Seize with excellent chemical resistance. Recommended for stainless steel. Ideal for use in the nuclear industry.



Loctite® 8009 brush top Metal free Anti-Seize providing a long term lubrication on all metals including stainless steel and titanium.



Loctite® 8012 brush top MoS₂ assembly paste ensures maximum lubricity, gives good resistance to extremely high loads and is ideal for protection of parts during running in or cold start.



Standard applications				
Need food approval?				
No			Yes	
Need metal free formulation?			Is the application for incidental food contact?	
No		Yes	No	Yes
C5-A® Copper Anti-Seize	Aluminium Anti-Seize	Metal free Anti-Seize	MoS ₂ assembly paste/spray	Food grade Anti-Seize
8007/8008 8065	8150/8151 8060	8153/8156	8154/8155	8014

Copper	Grey	White	Black	White
Copper & graphite	8150/8151 Aluminium, copper & graphite 8060 Aluminium & graphite	Extreme pressure (EP) additives	MoS ₂	White oil and extreme pressure (EP) additives
-	-	-	-	-
1	0	2	0	1
-30 to +980 °C	-30 to +900 °C	-25 to +900 °C	-20 to +450 °C	-30 to +400 °C
400 ml aerosol, 113g, 454g brush top, 3.6kg can, 20g stick	400 ml aerosol, 500g can, 1kg can, 5kg can, 20g stick	400 ml aerosol, 500g can	400 ml aerosol, 1kg can	907g can
MIL-PRF-907E	SECLF 216	SECLF 216	8154: H2 NSF Reg. No.: 122982	FDA 21 CFR 178-3570 H1 NSF Reg. No.: 123004



C5-A®
Loctite® 8007 aerosol
Loctite® 8008 brush top
Loctite® 8065 stick
 Copper based Anti-Seize, for screws, nuts, pipes, heat exchangers etc. Typical applications: exhaust bolts, brake caliper bolts.



Loctite® 8150 can
Loctite® 8151 aerosol
Loctite® 8060 stick
 Aluminium based Anti-Seize for screws, nuts, pipes, heat exchangers etc. Typical applications: wheel to hub connection.



Loctite® 8153 aerosol
Loctite® 8156 can
 (Loctite® 8153 is not available in UK.)
 Metal free Anti-Seize. Recommended where cleanliness is important. Can be used on stainless steel, copper alloys, in wet environments and all other standard applications.



Loctite® 8154 aerosol
Loctite® 8155 can
 MoS₂ assembly paste which is ideal for slow moving or static assemblies. Prevents press fits from galling or seizing and can reduce the risk of wear during start up.



Loctite® 8014 can
 Food grade metal free Anti-Seize. Recommended for stainless steel components, and can be used in wet environments.



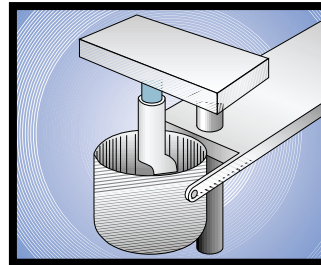
Surface Treatment and Rust Prevention

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

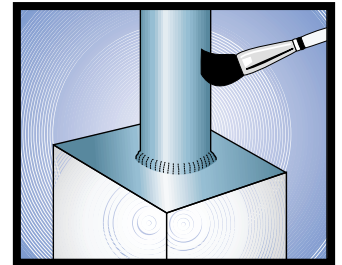
Surface Treatment and Rust Prevention

	Belt dressing	Rust treatment
Solution	8005	7500
Description	Liquid spray	Rust treatment
Colour	Colourless	Matt black
Temperature Range	-30 to +250 °C	N.A.
Pack Sizes	400 ml aerosol	1 litre can

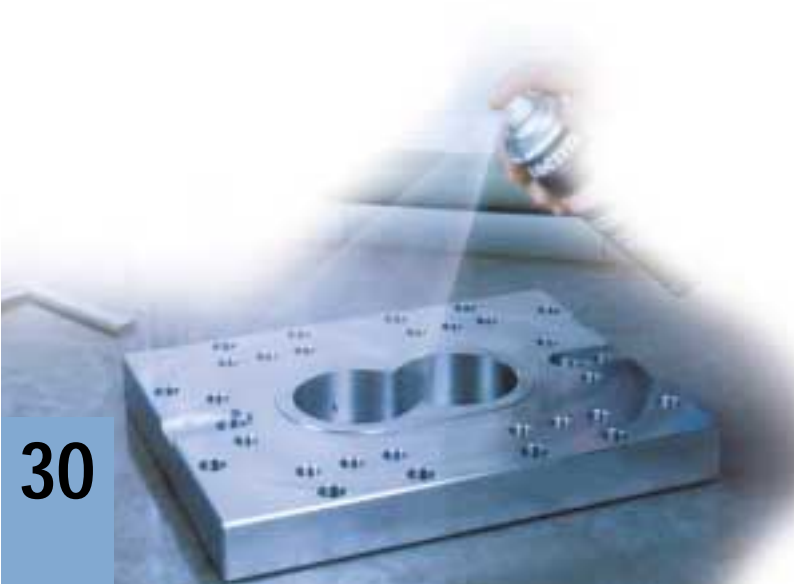
Application Examples



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



**Loctite® 7500
Rust treatment**
Converts existing rust into a stable base. 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.





Corrosion protection

General purpose

Cathodic protection

Removable

Non drying

7800/7922

7802

7803

Zinc spray

Varnish spray

Metal protection coating

Grey

Blue

Amber

-50 to +550 °C

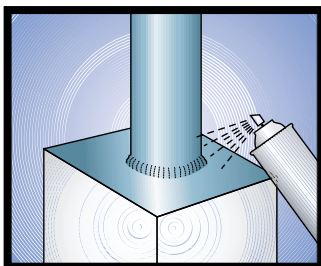
-10 to +80 °C

-10 to +40 °C

400 ml aerosol

400 ml aerosol

400 ml aerosol



Loctite® 7800
Zinc spray shiny

Loctite® 7922

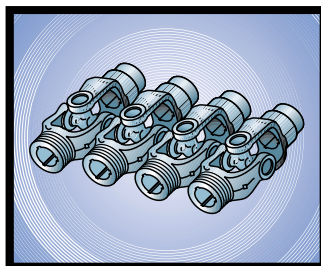
Zinc spray matt

(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.



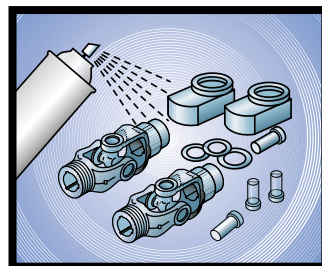
Loctite® 7802

Varnish spray

(Not available in UK.)

Easy to remove coating that provides long term protection.

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.

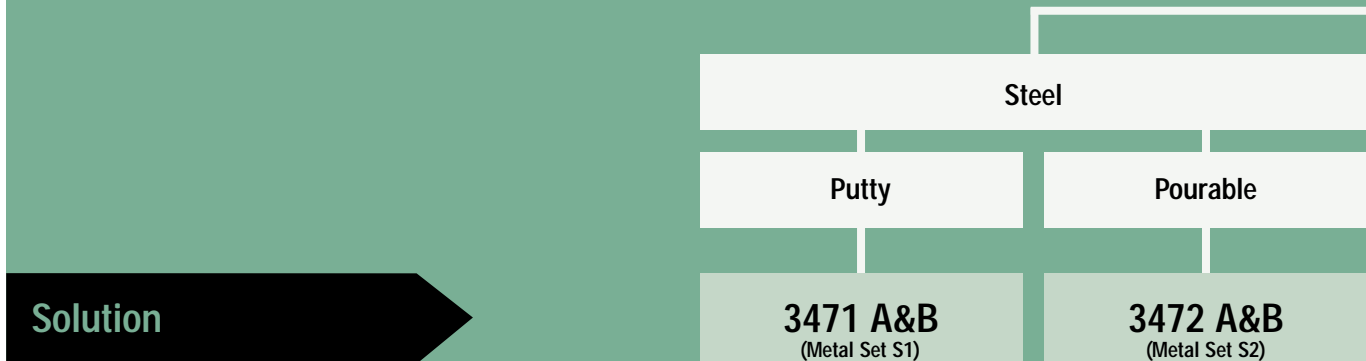
Long term protection of metal assemblies such as moulds, machines and outdoor installations.



Metal-filled Compounds

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

Repair or rebuild damaged parts?



	3471 A&B (Metal Set S1)	3472 A&B (Metal Set S2)
Description	2K-Epoxy	2K-Epoxy
Mix Ratio by Volume	1:1	1:1
Mix Ratio by Weight	1:1	1:1
Working Life	45 min.	45 min.
Fixture Time	180 min.	180 min.
Colour	Grey	Grey
Viscosity	Putty	Liquid
Shear Strength (GBMS)	20 N/mm ²	25 N/mm ²
Compressive Strength	70 N/mm ²	70 N/mm ²
Operating Temperature	Up to 120 °C	Up to 120 °C
Pack Sizes	500 g Tub Kit	500 g Tub Kit

Application Examples



Loctite® Hysol® 3471 A&B is a steel filled, 2K-Epoxy adhesive, for repairing and rebuilding worn metal parts. Ideal for repairing worn pipes and castings as well as cracks in housings and machine parts.



Loctite® Hysol® 3472 A&B is a pourable steel filled, 2K-Epoxy adhesive, for repairing and rebuilding worn metal parts. Ideal for making moulds, models, tools and fixtures.



What material are you filling?

		Aluminium		Metallic parts under friction
Fast cure	Multi purpose	High temperature resistant	Wear resistant	
3473 A&B (Metal Set S3)	3475 A&B (Metal Set A1)	3479 A&B (Metal Set HTA)	3474 A&B (Metal Set M)	
2K-Epoxy	2K-Epoxy	2K-Epoxy	2K-Epoxy	
1:1	1:1	1:1	1:1	
1:1	1:1	1:1	1:1	
6 min.	45 min.	40 min.	45 min.	
15 min.	180 min.	150 min.	180 min.	
Grey	Grey	Grey	Grey	
Putty	Putty	Putty	Putty	
20 N/mm ²	20 N/mm ²	20 N/mm ²	20 N/mm ²	
60 N/mm ²	70 N/mm ²	90 N/mm ²	70 N/mm ²	
Up to 120 °C	Up to 120 °C	Up to 190 °C	Up to 120 °C	
500 g Tub Kit	500 g Tub Kit	500 g Tub Kit	500 g Tub Kit	



Loctite® Hysol® 3473 A&B is a rapid curing, steel filled 2K-Epoxy adhesive, for emergency repairing and rebuilding worn metal parts. Ideal where downtime is an issue.



Loctite® Hysol® 3475 A&B is an aluminium filled, 2K-Epoxy adhesive, for repairing and rebuilding worn metal parts. Ideal for repairing castings and cracks in housings and machine parts.



Loctite® Hysol® 3479 A&B is an aluminium filled, 2K-Epoxy adhesive, for repairing and rebuilding worn metal parts in high operating temperature applications.



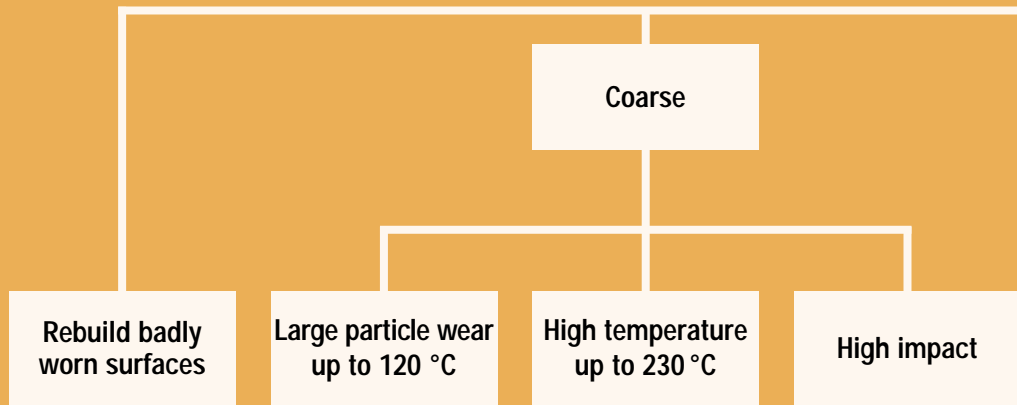
Loctite® Hysol® 3474 A&B is a mineral filled, 2K-Epoxy adhesive, which forms a self-lubricating surface to reduce sliding wear on moving parts. Ideal for repairing metallic surfaces under friction.



Wearing Compounds

- Restore 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	7222	7218	7230	7219
----------	------	------	------	------

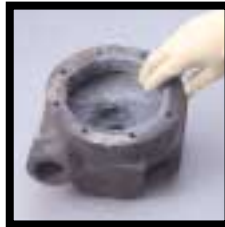
Colour	Grey	Grey	Grey	Grey
Maximum Temperature	107 °C	120 °C	230 °C	120 °C
Mix Ratio by Volume	2 to 1	2 to 1	4 to 1	2 to 1
Working Time	30 min.	30 min.	30 min.	30 min.
Cure Time	6 hrs	7 hrs	7 + 2 hrs* Post Cure	6 hrs
Recommended Layer Thickness	min. 6 mm	min. 6 mm	min. 6 mm	min. 6 mm
Pack Sizes	1.3 kg	1 kg, 10 kg	10 kg	1 kg, 10 kg

* Require post heat cure at 150 °C for maximum temperature resistance

Application Examples



Loctite® Nordbak® 7222 Wear Resistant Putty
Protects against: corrosion, cavitation & abrasion. Can also be used as a first re-profile before applying a top coat wearing compound.



Loctite® Nordbak® 7218 Wearing Compound
Ceramic filled two part epoxy to protect, rebuild and repair high wear areas. Outstanding resistance to abrasion and corrosion. Use to rebuild and protect chutes, pump housings, elbows, cyclones and material handling equipment.



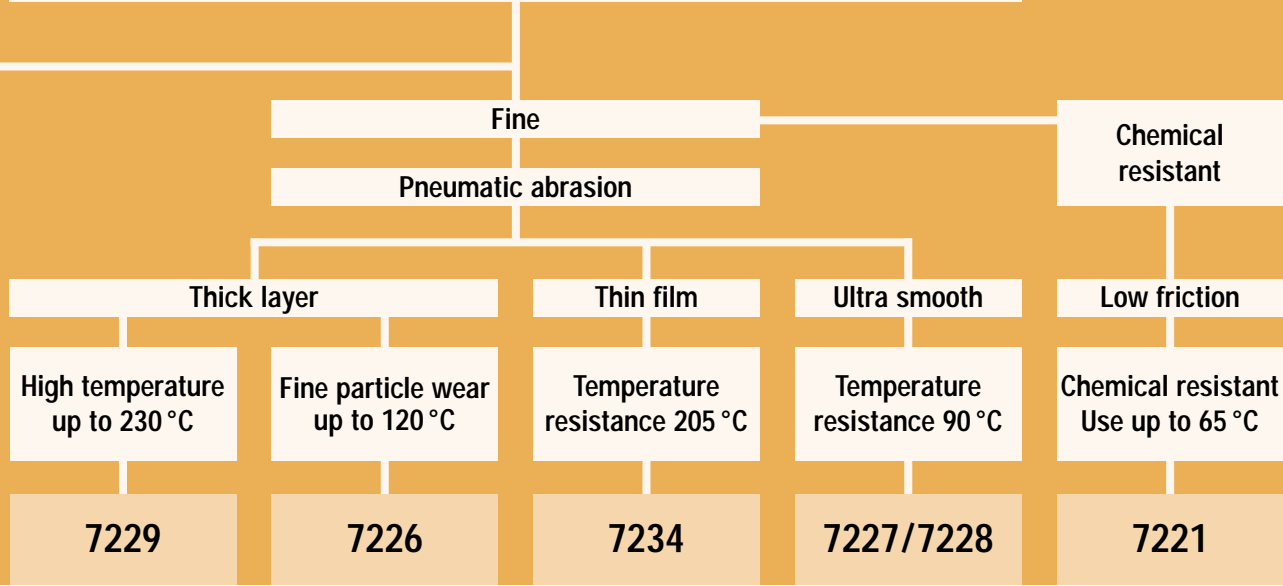
Loctite® Nordbak® 7230 High Temperature Wearing Compound
Ceramic filled two part epoxy to protect, rebuild and repair high wear areas. Use to rebuild and protect chutes, pump housings, elbows, cyclones and material handling equipment in hot environments.



Loctite® Nordbak® 7219 High Impact Wearing Compound
Rubber modified epoxy that provides a combination of wear resistance and impact resistance not usually found in epoxies. Use for lining and protecting flumes, troughs, elbows, hoppers, chutes, and other surfaces exposed to both wear and impact.



Fine, coarse or badly worn surface abrasion?



Grey	Grey	Grey	Grey/White	Grey
230 °C	120 °C	205 °C	95 °C	65 °C
4 to 1	4 to 1	2.6 to 1	2.75: 1/2.8: 1	2.3 to 1
30 min.	30 min.	30 min.	30 min./15 min.	20 min.
6 + 2 hrs* Post Cure	6 hrs	8 + 3 hrs* Post Cure	6 hrs/5 hrs	16 hrs
min. 6 mm	min. 6 mm	min. 0.5 mm	min. 0.5 mm	min. 0.5 mm
10 kg	1 kg, 10 kg	1 kg	1 kg	5.4 kg



Loctite® Nordbak® 7229 High Temperature Pneu-Wear
A two component epoxy, filled with small ceramic beads for protecting processing equipment from fine particle abrasion in hot environments. Trowelable epoxy is recommended for rebuilding, repairing and protecting pump housings, chutes, elbows, cyclones and other equipment against pneumatic abrasion.



Loctite® Nordbak® 7226 Pneu-Wear
A two component epoxy, filled with small ceramic beads for protecting processing equipment from fine particle abrasion. Trowelable epoxy is recommended for rebuilding, repairing and protecting pump housings, chutes, elbows, cyclones and other equipment against pneumatic abrasion.



Loctite® Nordbak® 7234 High Temperature Brushable Ceramic
Ultra-smooth, ceramic reinforced epoxy that provides a high gloss, low friction coating to protect against turbulence, abrasion and cavitation in hot environments. Also works as top-coat over Nordbak® Wearing Compounds for applications requiring surface rebuilding and lasting protection.



Loctite® Nordbak® 7227 Brushable Ceramic Grey Loctite® Nordbak® 7228 Brushable Ceramic White
Ultra-smooth, ceramic reinforced epoxy that provides a high gloss, low friction coating to protect against turbulence, abrasion and cavitation. Also works as top-coat over Nordbak® Wearing Compounds for applications requiring surface rebuilding and lasting protection.



Loctite® Nordbak® 7221 Chemical Resistant Coating
Protects equipment against extreme corrosion caused by chemical exposure.



Cleaning

- Clean components prior to using 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?

Hand cleaner

For ink, paint or resin on hands

General purpose

Solution

7855

7850

Description	Hand cleaner	Hand cleaner
Pack Sizes	400 ml bottle, 1.75 litre pump dispenser	400 ml bottle, 3 litre pump dispenser

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

Application Examples

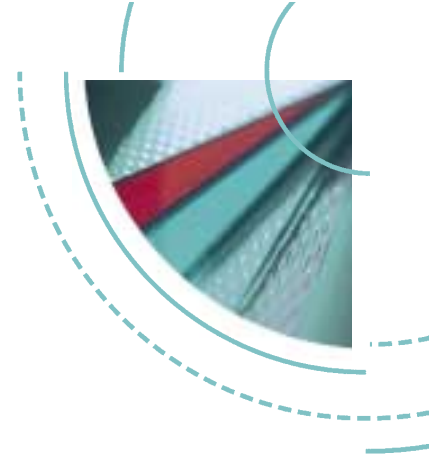


Loctite® 7855
Hand cleaner
Removes paint, resin and adhesives. Biodegradable and non toxic.



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





Parts/surface cleaner Parts i.e. machined components		Large surfaces i.e. worktops	
Are you cleaning electrical contacts?			
Yes	No		
Are you removing old gaskets?			
Yes		No	
		General parts cleaner	
7039	7200* (Gasket remover)	7063	7840*
Contact cleaner spray	Gasket remover	Cleaner and degreaser	Cleaner and degreaser
400 ml aerosol	400 ml aerosol	400 ml aerosol, pump 10 litre can,	750 ml trigger spray, 5 litre can, 20 litre drum



Loctite® 7039
Contact cleaner spray
Does not affect insulating varnishes. For cleaning electrical contacts, relays, switchgear 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 with minimal scraping.



Loctite® 7063
Cleaner & degreaser
Solvent based 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® 7840
Cleaner & degreaser
Biodegradable, solvent free, non-toxic and non flammable, diluted with water. Rated USFA-C1. Removes grease, oil, cutting fluids and workshop grime.



Surface Preparation – Activators and Primers

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



Do you need an activator or primer?

Improve adhesion to difficult to bond materials e.g. PE, PP, PTFE, TVP or thermoplastic rubbers

Increase cure speed of instant adhesives

Accelerate cure? Large gap fill or temperature < 5 °C?

In combination with 401, 406, 431, 454, 480 or 4850

In combination with 401, 406, 431, 454 and 4850

In combination with 222, 243, 248, 268, 2701, 290, 510, 518, 5203, 542, 548, 561, 572, 577, 603, 638, 641, 648, 660 or 668

Solution

7239

7458

7240

Description	Primer	Activator	Activator
Colour	Colourless	Colourless	Blue-green
Pack Sizes	4 ml	500 ml	90 ml pump

Application Examples



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

- Will seal leaks in tanks and other containment vessels in addition to repairing metal parts
- Includes a kit for replacing damaged O-ring seals and a gas leak detector

Emergency Repair

Replace O-rings
in situ

Fill holes, smooth
welds, repair
non-structural
defects?

Detect gas leak?

Stop pipe leaks?

Solution

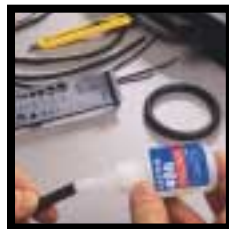
O-Ring kit

3463

7100

5070

Application
Examples



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. 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. Steel filled kneadable stick. Adheres to damp surfaces and cures under water. Chemical and corrosion resistant. Can be drilled, filed and painted. It is ideal for emergency sealing of leaking tanks and pipes. Smoothes welds, repairs small cracks in castings and fills oversized bolt holes.
ANSI/NSF Standard 61.



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® 3463 Metal Magic Steel™ Stick, and urethane-impregnated GRP tape.



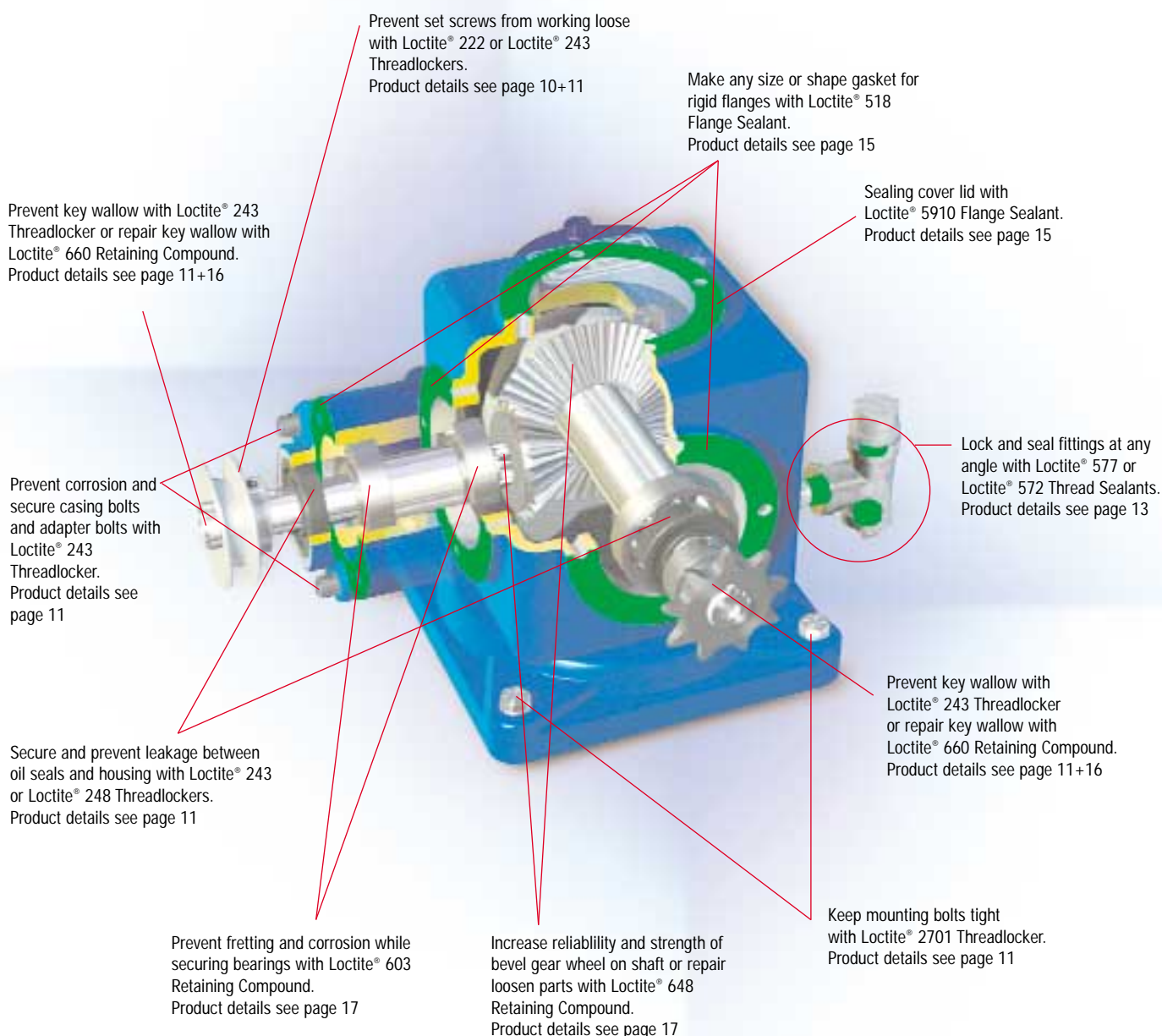
Gearbox & Pump Repair

Loctite® products will:

- Help prevent costly breakdowns
- Increase reliability and performance
- Make any size or shape gasket
- Seal threads at low temperatures
- Prevent fretting and corrosion

Gearbox Repairs

Gearboxes are designed to provide users with the flexibility, precision, performance and reliability required in a wide range of modern power transmission applications. Loctite® products help to ensure reliable operation, extend service life and make speedy repairs to minimise gearbox downtime.





Pump Repairs

Pump castings, impellers and volutes wear due to corrosion, erosion, cavitation, and mechanical damage. All these forms of damage can be effectively and economically repaired with Loctite® products.

Prevent fretting and corrosion while securing bearings with Loctite® 603 Retaining Compound. Product details see page 17

Prevent rust and seizure of power end bolts with Loctite® 8023 Marine Grade Anti-Seize. Product details see page 28

Prevent key wallow with Loctite® 243 Threadlocker or repair key wallow with Loctite® 660 Retaining Compound. Product details see page 11+16

Prevent set screws from working loose with Loctite® 222 Loctite® or 243 Threadlockers. Product details see page 10+11

Secure and prevent leakage between oil seals and housing with Loctite® 243 or Loctite® 248 Threadlockers. Product details see page 11

Lubricate and prevent damage to O-Rings with Loctite® 8104. Product details see page 26

Seal threaded fittings with Loctite® 577 or Loctite® 572 Thread Sealants. Product details see page 13

Keep mounting bolts tight with Loctite® 2701 Threadlocker. Product details see page 11

Prevent corrosion and secure casing bolts and adapter bolts with Loctite® 243 Threadlocker. Product details see page 11

Make any size gasket with Loctite® 518 Flange Sealant. Product details see page 15

Protect pump against chemical attack and erosion with Loctite® Nordbak® 7221 Chemical Resistant Coating. Product details see page 35

Rebuild and protect worn volutes with Loctite® Nordbak® 7218 Wearing Compound and/or Loctite® Nordbak® 7227 or 7228 Brushable Ceramics. Product details see page 34+35

Restore, coat, and protect impeller vanes with Loctite® Nordbak® 7227 or 7228 Brushable Ceramics. Product details see page 35

Prevent corrosion and seizure of gland assembly nuts and seizure of the impeller to the shaft with Loctite® 8023 Marine Grade Anti-Seize. Product details see page 28

Seal and protect flushing connectors with Loctite® 572 Thread Sealant. Product details see page 13



Maintenance Workshop

- Proactive hands-on training program on the use of our products for maintenance
- Will provide solutions to help your plant combat downtime
- Loctite® products and Maintenance Workshop training will help provide solutions to prevent predictable and unpredictable failures

After a Loctite® Maintenance Workshop, your workforce will have the knowledge and tools to:

- Save Time
- Reduce Energy Costs
- Improve Safety
- Reduce Fluid Consumption
- Improve Reliability

Maintenance Workshop Training Modules Hands-On Product and Reliability Training

Standard Reliability Training

Threadlocking



- How a threaded fastener works
- Advantages and disadvantages of mechanical locking devices
- Loctite® Threadlockers:
 - How they work
 - Product selection
- How substrates affect performance
- Temperature and other environmental factors
- Application techniques
- Hands-on demonstrations

Pipe & Thread Sealing



- Types of threads and fittings
- Causes of leaks
- Loctite® Thread Sealants:
 - How they work
 - Product selection
- How substrates affect performance
- Temperature and other environmental factors
- Application techniques
- Hands-on demonstrations

Gasketing



- Why gaskets fail
- Gasket materials
- Assembly problems
- Form-in-place gasketing basics
- Product selection
- Rigid flanges vs. flexible flanges
- Service factors
- Anaerobic and silicone (RTV) gasketing
- Hands-on demonstrations

Retaining



- Types of cylindrical fittings
- Potential problems and possible solutions
- Loctite® Retaining Compounds:
 - How they work
 - Product selection
- How substrates affect performance
- Temperature and other environmental factors
- Application techniques
- Hands-on demonstrations

Bonding



- Typical application areas
- Bonding dissimilar materials
- Assemble parts quickly and easily
- Loctite® adhesives:
 - How they work
 - Product selection

For more information please contact your local Henkel Technical Support Group.

The Features

- Pre-plant survey
- Hands-on training
- Covers all trades
- Conducted on site
- Training materials supplied
- Review of common failure causes and prevention
- Standard 2 hour workshop can be tailored to meet your needs through a plant tour and pre-survey
- In-plant follow up



Trained, motivated and equipped personnel drive costs down!

Maintenance Solution Training

Flexible Sealing & Bonding



- Bonding and sealing parts that withstand impact, shock and twisting forces
- Loctite® products:
 - Typical applications
 - Product selection
 - How they work

Lubrication



- Basics of Anti-Seize, oils, greases and dry lubricants
- How to select the right product

Surface Treatment & Rust Prevention



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

Metal Rebuilding



- Rebuild and repair of worn metal parts
- Use of metal-filled epoxies that are machinable and have the right compressive strengths

Additional Training

Cleaning



- Why to clean substrates before applying adhesives and sealants
- How to remove cured sealant residues
- Hand cleaners
- How to clean and degrease parts



Equipment

- Loctite® dispensing equipment is specially designed to make application and use of our 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® 98414
Peristaltic Hand Pump
 Mounts easily on any Loctite® 50 ml bottle, converting the bottle into a portable dispenser. Comes with a stand to stabilise 50 ml bottle.



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® 250 ml bottle.



Loctite® 97002
Pneumatic Cartridge Dispenser
 Dispenses all Loctite® products packaged in a 250 ml squeeze tube or in a 300 ml cartridge.



Loctite® 97006
Digital Syringe Dispensing System
 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 Loctite® products.



Loctite® 97008
Semi-Automatic Controller
Loctite® 97009
Semi-Automatic Controller
 Fully integrated semi-automatic adhesive dispensing systems.



Loctite® 97121
Pinch Valve Applicator
 A Pinch-valve with a pneumatic actuator for use with Loctite® 97008 and 97009.



Loctite® 96001
50 ml Dual Cartridge Dispenser
Loctite® 96003
200 ml Dual Cartridge Dispenser
 Automatically mix Loctite® structural adhesives in their correct proportions. Application is done without waste, in quantities determined by production needs.



Loctite® 97033
UV Wand System DC
 High intensity spot curing system designed to emit UVA and visible light (blue light) for extremely fast curing. Ideal for high-volume production and short cycle times.



Loctite® 97035
UVALOC Flood 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

■ Look for Loctite® Product number on these pages!

NSF * Products with NSF approval

Pr. No.	Product Name	Pack Size	Order No.	IDH No.	Page	Pr. No.	Product Name	Pack Size	Order No.	IDH No.	Page
222	Threadlocker, Low Strength*	12 x 10 ml	267358	267358	10	4850	Flexible Instant Adhesive	20g	373358	373358	19
222	Threadlocker, Low Strength*	50 ml	231501	231501	10	4850	Flexible Instant Adhesive	500g	373354	373354	19
222	Threadlocker, Low Strength*	250 ml	267359	267359	10	5070	Pipe Repair Kit	2" x 6' Kit	255861	255861	39
243	Threadlocker, Medium Strength*, Liquid	12 x 10 ml	135279	135279	11	510	Flange Sealant, Rigid Parts*	50 ml	135475	135475	15
243	Threadlocker, Medium Strength*, Liquid	50 ml	135278	135278	11	510	Flange Sealant, Rigid Parts*	160 ml	135476	135476	15
243	Threadlocker, Medium Strength*, Liquid	250 ml	135357	135357	11	510	Flange Sealant, Rigid Parts*	250 ml	135477	135477	15
248	Threadlocker, Medium Strength*, Semi-Solid	9g stick	TBC	TBC	11	5145	Flexible Adhesive Sealant, Non corrosive	40 ml	88318	88318	22
248	Threadlocker, Medium Strength*, Semi-Solid	19g stick	TBC	TBC	11	5145	Flexible Adhesive Sealant, Non corrosive	300 ml	335811	335811	22
268	Threadlocker, High Strength, Semi-Solid	9g stick	TBC	TBC	11	518	Flange Sealant, Rigid Parts*	65 ml	135480	135480	15
268	Threadlocker, High Strength, Semi-Solid	19g stick	TBC	TBC	11	518	Flange Sealant, Rigid Parts*	300 ml	435566	435566	15
270	Threadlocker, High Strength*, Liquid	12 x 10 ml	267380	267380	11	5203	Flange Sealant, Low Strength	50 ml	388178	388178	14
270	Threadlocker, High Strength*, Liquid	50 ml	232515	232515	11	5203	Flange Sealant, Low Strength	300 ml	170682	170682	14
270	Threadlocker, High Strength*, Liquid	250 ml	267381	267381	11	5331	Thread Sealant, Plastic*	100 ml	142492	142492	12
2701	Threadlocker, High Strength, Liquid	10 ml	TBC	TBC	11	534	Flange Sealant, Rigid or Flexible Parts	9g stick			14
2701	Threadlocker, High Strength, Liquid	50 ml	234853	234853	11	534	Flange Sealant, Rigid or Flexible Parts	19g stick			14
2701	Threadlocker, High Strength, Liquid	250 ml	234855	234855	11	5366	Flexible Adhesive Sealant, Clear	310 ml	142494	142494	23
290	Threadlocker, Wicking	12 x 10 ml	267397	267397	10	5367	Flexible Adhesive Sealant, White	310 ml	142493	142493	23
290	Threadlocker, Wicking	50 ml	233733	233733	10	5368	Flexible Adhesive Sealant, Black	310 ml	142495	142495	23
290	Threadlocker, Wicking	250 ml	267398	267398	10	5398	Flex. Adhesive Sealant, High temperature, Red	310 ml	195794	195794	23
3030	Structural Adhesive	35 ml			20	5399	Flex. Adhesive Sealant, High temperature, Red	310 ml	231230	231230	23
330	MULTI-BOND® Kit*	50/18 ml	230054	230054	20	542	Thread Sealant, Hydraulic and pneumatic	12 x 10 ml	135483	135483	13
330	Structural Adhesive, Toughened, non-mix*	315 ml	135407	135407	20	542	Thread Sealant, Hydraulic and pneumatic	50 ml	267431	267431	13
3421 A&B	Structural Adhesive, General Purpose	50 ml	248211	248211	20	542	Thread Sealant, Hydraulic and pneumatic	250 ml	267432	267432	13
3421 A&B	Structural Adhesive, General Purpose	200 ml	254055	254055	20	548	Flange Sealant, Rigid Parts	9g stick			14
3421 A&B	Structural Adhesive, General Purpose	400 ml	530376	530376	20	548	Flange Sealant, Rigid Parts	19g stick			14
3421 A	Structural Adhesive, General Purpose	1 kg	431949	431949	20	55	Pipe Sealing Cord*	50 m	483283	483283	12
3421 A	Structural Adhesive, General Purpose	20 kg	431948	431948	20	55	Pipe Sealing Cord*	150 m	270153	270153	12
3421 B	Structural Adhesive, General Purpose	1 kg	TBC	TBC	20	5699	Flange Sealant, Big gaps/Glycol resistant*	300 ml	135270	135270	15
3421 B	Structural Adhesive, General Purpose	20 kg	TBC	TBC	20	561	Thread Sealant*	19g stick	TBC	TBC	13
3430 A&B	Structural Adhesive, Fast cure	2 x 24 ml	142517	142517	21	572	Pipe Sealant, Slow curing	50 ml	229360	229360	13
3430 A&B	Structural Adhesive, Fast cure	50 ml	TBC	TBC	21	572	Pipe Sealant, Slow curing	250 ml	135495	135495	13
3430 A&B	Structural Adhesive, Fast cure	200 ml	TBC	TBC	21	574	Flange Sealant	50 ml	267437	267437	14
3430 A	Structural Adhesive, Fast cure	1 kg	TBC	TBC	21	574	Flange Sealant	250 ml	135500	135500	14
3430 B	Structural Adhesive, Fast cure	1 kg	TBC	TBC	21	577	Pipe Sealant, General Purpose *	50 ml	229342	229342	13
3450 A&B	Structural Adhesive, Fast cure	2 x 25 ml	229177	229177	21	577	Pipe Sealant, General Purpose *	250 ml	234573	234573	13
3463	Metal Magic Steel™ Stick	114 g	265628	265628	39	5910	Flange Sealant, Big gaps/Flexible	300 ml	142491	142491	15
3471 A&B	Metal Set S1, Putty	500g	229176	229176	32	603	Retainer, High Strength, oil tolerant*	12 x 10 ml	229873	229873	17
3472 A&B	Metal Set S2, Pourable	500g	229175	229175	32	603	Retainer, High Strength, oil tolerant*	50 ml	135280	135280	17
3473 A&B	Metal Set S3, Fast Cure	500g	229174	229174	33	603	Retainer, High Strength, oil tolerant*	250 ml	88573	88573	17
3474 A&B	Metal Set M, Wear Resistant	500g	195891	195891	33	638	Retainer, High Strength*	50 ml	234795	234795	17
3475 A&B	Metal Set A1, Multi Purpose	500g	229173	229173	33	638	Retainer, High Strength*	250 ml	234811	234811	17
3479 A&B	Metal Set HTA, High Temperature Resistant	500g	195826	195826	33	641	Retainer, Medium Strength	12 x 10 ml	267442	267442	16
401	Instant Adhesive, General Purpose*	10 x 3 g	87993	87993	19	641	Retainer, Medium Strength	50 ml	135522	135522	16
401	Instant Adhesive, General Purpose*	20g	135428	135428	19	641	Retainer, Medium Strength	250 ml	135523	135523	16
401	Instant Adhesive, General Purpose*	50g	233658	233658	19	648	Retainer, High Temperature	50 ml	234880	234880	17
401	Instant Adhesive, General Purpose*	500g	135431	135431	19	648	Retainer, High Temperature	250 ml	267443	267443	17
406	Instant Adhesive, Elastomers	20g	233695	233695	18	660	Retainer, Large gap repair*	12 x 50 ml	229232	229232	16
406	Instant Adhesive, Elastomers	500g	135438	135438	18	668	Retainer, Medium Strength	9g stick			17
4062	Instant Adhesive, Wicking	20g	152922	152922	19	668	Retainer, Medium Strength	19g stick			17
4062	Instant Adhesive, Wicking	500g	234075	234075	19	7039	Contact Cleaner Spray, Aerosol	12 x 400 ml	142538	142538	37
431	Inst. Adhesive, General Purpose, High viscosity	20g	261800	261800	19	7063	Small Parts Cleaner Aerosol	400 ml	458648	458648	37
431	Inst. Adhesive, General Purpose, High viscosity	500g	234053	234053	19	7063	Small Parts Cleaner Pump	400 ml	195814	195814	37
454	Instant Adhesive, General Purpose Gel*	10 x 10 ml	231100	231100	18	7063	Small Parts Cleaner	10l	149293	149293	37
454	Instant Adhesive, General Purpose Gel*	20g	195678	195678	18	7063	Small Parts Cleaner	200l	250179	250179	37
454	Instant Adhesive, General Purpose Gel*	300g	88526	88526	18	7100	Leak Detector Spray	400 ml	399181	399181	39
454	Instant Adhesive, General Purpose Gel* (Collapsible Cartridge)	300g	234443	234443	18	7200	Gasket Remover, Aerosol	400 ml	458654	458654	37
480	Instant Adhesive, Peel Resistant	20g	135250	135250	18	7218	Nordbak Wearing Compound	1 kg			34
480	Instant Adhesive, Peel Resistant	500g	135253	135253	18	7218	Nordbak Wearing Compound	10 kg			34
						7219	Nordbak High Impact Wearing Compound	1 kg	255891	255891	34

** Not available in UK



Product Ordering Information

■ Look for Loctite® Product number on these pages!



* Products with NSF approval

Pr. No.	Product Name	Pack Size	Order No.	IDH No.	Page	Pr. No.	Product Name	Pack Size	Order No.	IDH No.	Page
7219	Nordbak High Impact Wearing Compound	10 kg			34	8151	Aluminium Anti-Seize, Aerosol	400 ml	303136	303136	29
7221	Nordbak Chemical Resistant Coating	5.4 kg	**	**	35	8153	Metal free Anti-Seize, Aerosol	400 ml	142531	142531	29
7222	Nordbak Wear Resistant Putty	1.3 kg	**	**	34	8154	MoS ₂ Assembly Spray, Aerosol*	400 ml	303135	303135	29
7226	Nordbak Pneu-Wear	1 kg			35	8155	MoS ₂ Assembly Paste	1 kg	142725	142725	29
7226	Nordbak Pneu-Wear	10 kg			35	8156	Metal free Anti-Seize	500 g	303146	303146	29
7227	Nordbak Brushable Ceramic Grey	1 kg			35	8191	MoS ₂ Anti-friction, Aerosol	400 ml	**	**	24
7228	Nordbak Brushable Ceramic White	1 kg			35	8192	Food Grade PTFE Coating, Aerosol*	400 ml	**	**	24
7229	Nordbak High Temperature Pneu-Wear	10 kg			35	8201	Five Way Spray, Aerosol	12 x 400 ml	142730	142730	25
7230	Nordbak High Temperature Wearing Compound	10 kg	255896	255896	34	9466 A&B	Structural Adhesive, Toughened	50 ml	451198	451198	21
7234	Nordbak High Temperature Brushable Ceramic	1 kg	254469	254469	35	9466 A&B	Structural Adhesive, Toughened	200 ml	TBC	TBC	21
7239	Plastics Primer, CA (all plastics)	4 ml	333359	333359	38	9466 A&B	Structural Adhesive, Toughened	400 ml	451200	451200	21
7240	Activator, Anaerobics	90 ml	333369	333369	38	9466 A	Structural Adhesive, Toughened	1 kg	446309	446309	21
7458	Activator	500 ml	373363	373363	38	9466 B	Structural Adhesive, Toughened	1 kg	446320	446320	21
7500	Rust Treatment Coating	1 l	303403	303403	30	9466 A	Structural Adhesive, Toughened	20 kg	537824	537824	21
7800	Zinc Spray, Shiny	12 x 400 ml	150740	150740	31	9466 B	Structural Adhesive, Toughened	17 kg	537825	537825	21
7802	Varnish Spray Coating, Aerosol	12 x 400 ml	142535	142535	31	9492 A&B	Structural Adhesive, High Temperature	50 ml	468286	468286	21
7803	Metal Protection Spray Coating	12 x 400 ml	**	**	31	9492 A&B	Structural Adhesive, High Temperature	400 ml	468314	468314	21
7840	Large Parts Cleaner (water based)	200	235343	235343	37	96001	Epoxy Dual Cartridge Dispenser	50 ml	267452	267452	44
7840	Large Parts Cleaner (water based)	12 x 750 ml	235330	235330	37	96003	Epoxy Dual Cartridge Dispenser	200 ml	267453	267453	44
7840	Large Parts Cleaner (water based)	20	235341	235341	37	97001	Peristaltic Hand Pump	eq	88631	88631	44
7840	Large Parts Cleaner (water based)	4 x 5 lt.	235338	235338	37	97002	300 ml Pneumatic Cartridge Dispenser	eq	88632	88632	44
7850	Hand Cleaner	4 x 3 lt.	234258	234258	36	97006	Digital Syringe Dispensing System	eq	88633	88633	44
7850	Hand Cleaner	12 x 400 ml	234228	234228	36	97008	Integrated Semi-Automatic Dispensing System	1 l	215844	215844	44
7850	Hand Cleaner	2 x 10	88239	88239	36	97009	Integrated Semi-Automatic Dispensing System	2 l	215845	215845	44
7855	Hand Cleaner, Paint, Resin	12 x 400 ml	235321	235321	36		with Low Level Sensor				
7855	Hand Cleaner, Paint, Resin	1.75 lt	235320	235320	36	97033	UV Wand System DC	eq	236377	236377	44
7922	Zinc Spray, Matt, Aerosol	12 x 400 ml	**	**	31	97035	UVALOC 1000 Cure Chamber	eq	307079	307079	44
8001	Mineral Oil Spray*	400 ml	**	**	24	97121	Pinch Valve Applicator	eq	88650	88650	44
8005	Belt Dressing, Aerosol	400 ml	458643	458643	30	97263	Needle Variety Kit	Kit	218288	218288	44
8007	C5-A* Copper Anti-Seize, Aerosol	400 ml	255851	255851	29	98414	Peristaltic Hand Pump	eq			44
8008	C5-A* Copper Anti-Seize, Brush Top	113 g	503392	503392	29		O-Ring Kit	Kit	480166	480166	39
8008	C5-A* Copper Anti-Seize, Brush Top	454 g	503147	503147	29						
8008	C5-A* Copper Anti-Seize	3.6 kg	503148	503148	29						
8009	Heavy Duty Anti-Seize, Brush Top	454 g	504219	504219	28						
8009	Heavy Duty Anti-Seize	3.6 kg	504233	504233	28						
8011	High Temperature chain oil spray*	400 ml	**	**	25						
8013	Moly Paste, Brush Top	454 g	504336	504336	28						
8013	Moly Paste	6.8 kg	505464	505464	28						
8013	N-7000 High Purity Anti-Seize, Brush Top	454 g	504588	504588	28						
8014	Food Grade Anti-Seize*	907 g	505467	505467	29						
8018	Solvo Rust, Aerosol	12 x 400 ml	458647	458647	25						
8021	Silicone oil, Aerosol	12 x 400 ml	458646	458646	25						
8023	Marine Grade, Anti-Seize, Brush Top	454 g	504618	504618	28						
8030	Cutting oil, Bottle	250 ml	**	**	25						
8031	Cutting oil, Aerosol	12 x 400 ml	**	**	25						
8060	Aluminium Anti-Seize	20 g stick	525113	525113	29						
8065	C5-A* Copper Anti-Seize	20 g stick	525380	525380	29						
8101	Chain Lubricant, Aerosol	400 ml	**	**	27						
8102	High Performance Grease	400 g	**	**	27						
8102	High Performance Grease	6 x 1 l	**	**	27						
8103	MoS ₂ Grease	400 g	**	**	27						
8103	MoS ₂ Grease	6 x 1 l	**	**	27						
8104	Food Grade Silicone Grease*	6 x 1 l	142550	142550	26						
8105	Food Grade Mineral Grease*	400 ml	**	**	27						
8106	General purpose Grease	400 ml	**	**	26						
8106	General purpose Grease	1 l	**	**	26						
8150	Aluminium Anti-Seize	500 g	303147	303147	29						
8150	Aluminium Anti-Seize	1 kg	TBC	TBC	29						
8150	Aluminium Anti-Seize	5 kg	TBC	TBC	29						

** Not available in UK

Look for Loctite® Product name on these pages!



Product Name	Pr. No.	Pack Size	Order No.	IDH No.	Page	Product Name	Pr. No.	Pack Size	Order No.	IDH No.	Page
300ml Pneumatic Cartridge Dispenser	97002	eq	88632	88632	44	Heavy Duty Anti-Seize, Brush Top	8009	454g	504219	504219	28
Activator	7458	500ml	373363	373363	38	High Performance Grease	8102	400g	**	**	27
Activator, Anaerobics	7240	90ml	333369	333369	38	High Performance Grease	8102	6x1l	**	**	27
Aluminium Anti-Seize	8060	20g stick	525113	525113	29	High Temperature chain oil spray*	8011	400ml	**	**	25
Aluminium Anti-Seize	8150	500g	303147	303147	29	Inst. Adhesive, General Purpose, High viscosity	431	20g	261800	261800	19
Aluminium Anti-Seize	8150	1kg	TBC	TBC	29	Inst. Adhesive, General Purpose, High viscosity	431	500g	234053	234053	19
Aluminium Anti-Seize	8150	5kg	TBC	TBC	29	Instant Adhesive, Elastomers	406	20g	233695	233695	18
Aluminium Anti-Seize, Aerosol	8151	400ml	303136	303136	29	Instant Adhesive, Elastomers	406	500g	135438	135438	18
Belt Dressing, Aerosol	8005	400ml	458643	458643	30	Instant Adhesive, General Purpose Gel*	454	300g	88526	88526	18
C5-A® Copper Anti-Seize	8008	3.6kg	503148	503148	29	Instant Adhesive, General Purpose Gel*	454	300g	234443	234443	18
C5-A® Copper Anti-Seize	8065	20g stick	525380	525380	29	(Collapsible Cartridge)					
C5-A® Copper Anti-Seize, Aerosol	8007	400ml	255851	255851	29	Instant Adhesive, General Purpose Gel*	454	10x10ml	231100	231100	18
C5-A® Copper Anti-Seize, Brush Top	8008	113g	503392	503392	29	Instant Adhesive, General Purpose Gel*	454	20g	195678	195678	18
C5-A® Copper Anti-Seize, Brush Top	8008	454g	503147	503147	29	Instant Adhesive, General Purpose*	401	10x3g	87993	87993	19
Chain Lubricant, Aerosol	8101	400ml	**	**	27	Instant Adhesive, General Purpose*	401	20g	135428	135428	19
Contact Cleaner Spray, Aerosol	7039	12x400ml	142538	142538	37	Instant Adhesive, General Purpose*	401	50g	233658	233658	19
Cutting oil, Bottle	8030	250ml	**	**	25	Instant Adhesive, General Purpose*	401	500g	135431	135431	19
Cutting oil, Aerosol	8031	12x400ml	**	**	25	Instant Adhesive, Peel Resistant	480	20g	135250	135250	18
Digital Syringe Dispensing System	97006	eq	88633	88633	44	Instant Adhesive, Peel Resistant	480	500g	135253	135253	18
Epoxy Dual Cartridge Dispenser	96001	50ml	267452	267452	44	Instant Adhesive, Wicking	4062	20g	152922	152922	19
Epoxy Dual Cartridge Dispenser	96003	200ml	267453	267453	44	Instant Adhesive, Wicking	4062	500g	234075	234075	19
Five Way Spray, Aerosol	8201	12x400ml	142730	142730	25	Integrated Semi-Automatic Dispensing System	97008	1l	215844	215844	44
Flange Sealant, Rigid or Flexible Parts	534	9g stick			14	Integrated Semi-Automatic Dispensing System with Low Level Sensor	97009	2l	215845	215845	44
Flange Sealant, Rigid or Flexible Parts	534	19g stick			14	Large Parts Cleaner (water based)	7840	200	235343	235343	37
Flange Sealant, Rigid Parts	548	9g stick			14	Large Parts Cleaner (water based)	7840	12x750ml	235330	235330	37
Flange Sealant, Rigid Parts	548	19g stick			14	Large Parts Cleaner (water based)	7840	20	235341	235341	37
Flange Sealant	574	50ml	267437	267437	14	Large Parts Cleaner (water based)	7840	4x5lt.	235338	235338	37
Flange Sealant	574	250ml	135500	135500	14	Large Parts Cleaner (water based)	7840	200	235343	235343	37
Flange Sealant, Big gaps/Flexible	5910	300ml	142491	142491	15	Large Parts Cleaner (water based)	7840	4x5lt.	235338	235338	37
Flange Sealant, Big gaps/Glycol resistant*	5699	300ml	135270	135270	15	Leak Detector Spray	7100	400ml	399181	399181	39
Flange Sealant, Low Strength	5203	50ml	388178	388178	14	Marine Grade, Anti-Seize, Brush Top	8023	454g	504618	504618	28
Flange Sealant, Low Strength	5203	300ml	170682	170682	14	Metal free Anti-Seize	8156	500g	303146	303146	29
Flange Sealant, Rigid Parts*	510	50ml	135475	135475	15	Metal free Anti-Seize, Aerosol	8153	400ml	142531	142531	29
Flange Sealant, Rigid Parts*	510	160ml	135476	135476	15	Metal Magic Steel™ Stick	3463	114g	265628	265628	39
Flange Sealant, Rigid Parts*	510	250ml	135477	135477	15	Metal Protection Spray Coating	7803	12x400ml	**	**	31
Flange Sealant, Rigid Parts*	518	65ml	135480	135480	15	Metal Set A1, Multi Purpose	3475 A&B	500g	229173	229173	33
Flange Sealant, Rigid Parts*	518	300ml	435566	435566	15	Metal Set HTA, High Temperature Resistant	3479 A&B	500g	195826	195826	33
Flex. Adhesive Sealant, High temperature, Red	5398	310ml	195794	195794	23	Metal Set M, Wear Resistant	3474 A&B	500g	195891	195891	33
Flex. Adhesive Sealant, High temperature, Red	5399	310ml	231230	231230	23	Metal Set S1, Putty	3471 A&B	500g	229176	229176	32
Flexible Adhesive Sealant, Black	5368	310ml	142495	142495	23	Metal Set S2, Pourable	3472 A&B	500g	229175	229175	32
Flexible Adhesive Sealant, Clear	5366	310ml	142494	142494	23	Metal Set S3, Fast Cure	3473 A&B	500g	229174	229174	33
Flexible Adhesive Sealant, Non corrosive	5145	40ml	88318	88318	22	Mineral Oil Spray*	8001	400ml	**	**	24
Flexible Adhesive Sealant, Non corrosive	5145	300ml	335811	335811	22	Moly Paste	8013	6.8kg	505464	505464	28
Flexible Adhesive Sealant, White	5367	310ml	142493	142493	23	Moly Paste, Brush Top	8013	454g	504336	504336	28
Flexible Instant Adhesive	4850	20g	373358	373358	19	MoS, Anti-friction, Aerosol	8191	400ml	**	**	24
Flexible Instant Adhesive	4850	500g	373354	373354	19	MoS, Assembly Paste	8155	1kg	142725	142725	29
Food Grade Anti-Seize*	8014	907g	505467	505467	29	MoS, Assembly Spray, Aerosol*	8154	400ml	303135	303135	29
Food Grade Mineral Grease*	8105	400ml	**	**	27	MoS, Grease	8103	400g	**	**	27
Food Grade PTFE Coating, Aerosol*	8192	400ml	**	**	24	MoS, Grease	8103	6x1l	**	**	27
Food Grade Silicone Grease*	8104	6x1l	142550	142550	26	MULTI-BOND® Kit*	330	50/18ml	230054	230054	20
Gasket Remover, Aerosol	7200	400ml	458654	458654	37	N-7000 High Purity Anti-Seize, Brush Top	8013	454g	504588	504588	28
General purpose Grease	8106	400ml	**	**	26	Needle Variety Kit	97263	Kit	218288	218288	44
General purpose Grease	8106	1l	**	**	26	Nordbak Brushable Ceramic Grey	7227	1kg			35
Hand Cleaner	7850	4x3lt.	234258	234258	36	Nordbak Brushable Ceramic White	7228	1kg			35
Hand Cleaner	7850	12x400ml	234228	234228	36	Nordbak Chemical Resistant Coating	7221	5.4kg	**	**	35
Hand Cleaner	7850	2x10	88239	88239	36	Nordbak High Impact Wearing Compound	7219	1kg	255891	255891	34
Hand Cleaner, Paint, Resin	7855	12x400ml	235321	235321	36	Nordbak High Impact Wearing Compound	7219	10kg			34
Hand Cleaner, Paint, Resin	7855	1.75lt	235320	235320	36	Nordbak High Temperature Brushable Ceramic	7234	1kg	254469	254469	35
Heavy Duty Anti-Seize	8009	3.6kg	504233	504233	28	Nordbak High Temperature Pneu-Wear	7229	10kg			35
						Nordbak High Temperature Wearing Compound	7230	10kg	255896	255896	34

** Not available in UK

■ Look for Loctite® Product name on these pages!



Product Name	Pr. No.	Pack Size	Order No.	IDH No.	Page	Product Name	Pr. No.	Pack Size	Order No.	IDH No.	Page
Nordbak Pneu-Wear	7226	1 kg			35	Structural Adhesive, Toughened	9466 B	17 kg	537825	537825	21
Nordbak Pneu-Wear	7226	10 kg			35	Structural Adhesive, Toughened, non-mix*	330	315 ml	135407	135407	20
Nordbak Wear Resistant Putty	7222	1.3 kg	**	**	34	Thread Sealant*	561	19 g stick	TBC	TBC	13
Nordbak Wearing Compound	7218	1 kg			34	Thread Sealant, Hydraulic and pneumatic	542	12 x 10 ml	135483	135483	13
Nordbak Wearing Compound	7218	10 kg			34	Thread Sealant, Hydraulic and pneumatic	542	50 ml	267431	267431	13
O-Ring Kit		Kit	480166	480166	39	Thread Sealant, Hydraulic and pneumatic	542	250 ml	267432	267432	13
Peristaltic Hand Pump	97001	eq	88631	88631	44	Thread Sealant, Plastic*	5331	100 ml	142492	142492	12
Peristaltic Hand Pump	98414	eq			44	Threadlocker, High Strength*, Liquid	270	12 x 10 ml	267380	267380	11
Pinch Valve Applicator	97121	eq	88650	88650	44	Threadlocker, High Strength*, Liquid	270	50 ml	232515	232515	11
Pipe Repair Kit	5070	2" x 6' Kit	255861	255861	39	Threadlocker, High Strength*, Liquid	270	250 ml	267381	267381	11
Pipe Sealant, General Purpose*	577	50 ml	229342	229342	13	Threadlocker, High Strength, Liquid	2701	10 ml	TBC	TBC	11
Pipe Sealant, General Purpose*	577	250 ml	234573	234573	13	Threadlocker, High Strength, Liquid	2701	50 ml	234853	234853	11
Pipe Sealant, Slow curing	572	50 ml	229360	229360	13	Threadlocker, High Strength, Liquid	2701	250 ml	234855	234855	11
Pipe Sealant, Slow curing	572	250 ml	135495	135495	13	Threadlocker, High Strength, Semi-Solid	268	9 g stick	TBC	TBC	11
Pipe Sealing Cord*	55	50 m	483283	483283	12	Threadlocker, High Strength, Semi-Solid	268	19 g stick	TBC	TBC	11
Pipe Sealing Cord*	55	150 m	270153	270153	12	Threadlocker, Low Strength*	222	12 x 10 ml	267358	267358	10
Plastics Primer, CA (all plastics)	7239	4 ml	333359	333359	38	Threadlocker, Low Strength*	222	50 ml	231501	231501	10
Retainer, Medium Strength	668	9 g stick			17	Threadlocker, Low Strength*	222	250 ml	267359	267359	10
Retainer, Medium Strength	668	19 g stick			17	Threadlocker, Medium Strength*, Liquid	243	12 x 10 ml	135279	135279	11
Retainer, High Strength*	638	50 ml	234795	234795	17	Threadlocker, Medium Strength*, Liquid	243	50 ml	135278	135278	11
Retainer, High Strength*	638	250 ml	234811	234811	17	Threadlocker, Medium Strength*, Liquid	243	250 ml	135357	135357	11
Retainer, High Strength, oil tolerant*	603	12 x 10 ml	229873	229873	17	Threadlocker, Medium Strength*, Semi-Solid	248	9 g stick	TBC	TBC	11
Retainer, High Strength, oil tolerant*	603	50 ml	135280	135280	17	Threadlocker, Medium Strength*, Semi-Solid	248	19 g stick	TBC	TBC	11
Retainer, High Strength, oil tolerant*	603	250 ml	88573	88573	17	Threadlocker, Wicking	290	12 x 10 ml	267397	267397	10
Retainer, High Temperature	648	50 ml	234880	234880	17	Threadlocker, Wicking	290	50 ml	233733	233733	10
Retainer, High Temperature	648	250 ml	267443	267443	17	Threadlocker, Wicking	290	250 ml	267398	267398	10
Retainer, Large gap repair*	660	12 x 50 ml	229232	229232	16	UV Wand System DC	97033	eq	236377	236377	44
Retainer, Medium Strength	641	12 x 10 ml	267442	267442	16	UVALOC 1000 Cure Chamber	97035	eq	307079	307079	44
Retainer, Medium Strength	641	50 ml	135522	135522	16	Varnish Spray Coating, Aerosol	7802	12 x 400 ml	142535	142535	31
Retainer, Medium Strength	641	250 ml	135523	135523	16	Zinc Spray, Matt, Aerosol	7922	12 x 400 ml	**	**	31
Rust Treatment Coating	7500	1 l	303403	303403	30	Zinc Spray, Shiny	7800	12 x 400 ml	150740	150740	31
Silicone oil, Aerosol	8021	12 x 400 ml	458646	458646	25						
Small Parts Cleaner	7063	10 l	149293	149293	37						
Small Parts Cleaner	7063	200 l	250179	250179	37						
Small Parts Cleaner Aerosol	7063	400 ml	458648	458648	37						
Small Parts Cleaner Pump	7063	400 ml	195814	195814	37						
Solvo Rust, Aerosol	8018	12 x 400 ml	458647	458647	25						
Structural Adhesive	3030	35 ml			20						
Structural Adhesive, Fast cure	3430 A&B	2 x 24 ml	142517	142517	21						
Structural Adhesive, Fast cure	3430 A&B	50 ml	TBC	TBC	21						
Structural Adhesive, Fast cure	3430 A&B	200 ml	TBC	TBC	21						
Structural Adhesive, Fast cure	3430 A	1 kg	TBC	TBC	21						
Structural Adhesive, Fast cure	3430 B	1 kg	TBC	TBC	21						
Structural Adhesive, Fast cure	3450 A&B	2 x 25 ml	229177	229177	21						
Structural Adhesive, General Purpose	3421 A&B	50 ml	248211	248211	20						
Structural Adhesive, General Purpose	3421 A&B	200 ml	254055	254055	20						
Structural Adhesive, General Purpose	3421 A&B	400 ml	530376	530376	20						
Structural Adhesive, General Purpose	3421 A	1 kg	431949	431949	20						
Structural Adhesive, General Purpose	3421 A	20 kg	431948	431948	20						
Structural Adhesive, General Purpose	3421 B	1 kg	TBC	TBC	20						
Structural Adhesive, General Purpose	3421 B	20 kg	TBC	TBC	20						
Structural Adhesive, High Temperature	9492 A&B	50 ml	468286	468286	21						
Structural Adhesive, High Temperature	9492 A&B	400 ml	468314	468314	21						
Structural Adhesive, Toughened	9466 A&B	50 ml	451198	451198	21						
Structural Adhesive, Toughened	9466 A&B	200 ml	TBC	TBC	21						
Structural Adhesive, Toughened	9466 A&B	400 ml	451200	451200	21						
Structural Adhesive, Toughened	9466 A	1 kg	446309	446309	21						
Structural Adhesive, Toughened	9466 B	1 kg	446320	446320	21						
Structural Adhesive, Toughened	9466 A	20 kg	537824	537824	21						

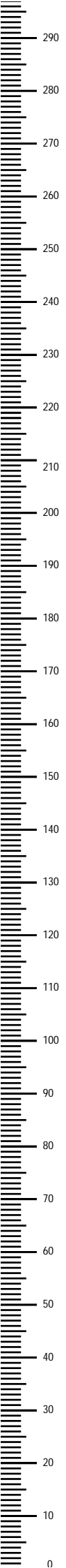
** Not available in UK

Notes

A large rectangular area with a light gray background and horizontal black lines, intended for writing notes. The lines are evenly spaced and extend across the width of the page.

12
11
10
9
8
7
6
5
4
3
2
1

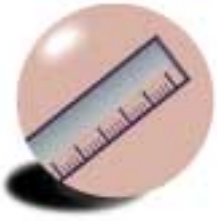
in inch



Notes

A large rectangular area with a light gray background, containing 20 horizontal black lines spaced evenly down the page, intended for writing notes.

in cm



International Units and Imperial Units



MEASURE	SI SYSTEM SUB-MULTIPLES	MULTIPLES OR Values in SI
Length	metre = m	centimetre = cm = 10^{-2} m millimetre = mm = 10^{-3} m micron = μm = 10^{-6} m
Surface area	metre square = m ²	centimetre square = cm ² = 10^{-4} m ² millimetre square = mm ² = 10^{-6} m ²
Volume	metre cube = m ³	centimetre cube = cm ³ = 10^{-6} m ³ decimetre cube = dm ³ = 10^{-3} m ³
Mass	kilogramme = kg	gramme = g = 10^{-3} kg tonne = t = 10^3 kg
Linear mass	kg/m	g/cm = 10^{-1} kg/m
Volume mass	kg/m ³	g/cm ³ = 10^3 kg/m ³ = kg/dm ³
Linear speed	m/s	cm/s = 10^{-2} m/s
Speed (rotation)	rad/s	–
Force	Newton = N	dyne = dyn = 10^{-5} N decaNewton = daN = 10 N
Torque (moment)	Nm	daNm = 10 Nm
Pressure	pascal = Pa	m. bar = 10^2 Pa bar = 10^5 Pa megapascal = MPa = 10^6 Pa = N/mm ²

UNITS OTHER THAN SI Values in SI	IMPERIAL Values in SI or other systems
	inch = in = 1" = 2,54 cm foot = ft = 1' = 30,48 cm yard = yd = 0,914 m
	square inch = in ² , sq in = 6,452 cm ² square foot = ft ² , sq ft = 929,03 cm ² square yard = yd ² , sq yd = 0,836 m ²
1 litre = 1×10^{-3} m ³	cubic inch = in ³ , cu in = 16,387 cm ³ cubic foot = ft ³ , cu ft = 0,028 m ³ cubic yard = yd ³ , cu yd = 0,765 m ³ 1 litre = 1,76 pints = 0,22 gallons
	ounce = oz = 28,350 g pound = lb = 0,454 kg ton = 2240 lb = 1016,05 kg US ton (short ton) = 2000 lb = 907,185 kg
	pound per foot = lb/ft = 1,488 kg/m pound per yard = lb/yd = 0,496 kg/m
	pound per cubic foot = lb/ft ³ = 16,019 kg/m ³
m/min = 1/60 m/s	foot per second = ft/s = 60 ft/min = 0,305 m/s
rev per second = r/s = 2π rad/s	revolution per minute (rpm) = 2π rad/min
kgf (or kgp) = 9,81 N = 0,981 daN	pound-force = 4,448 N = 0,454 kgf
kgfm = 0,908 daNm = 9,81 Nm	pound x foot = lbf.ft = 1,355 Nm = 0,138 kgfm
kgf/cm ² = $9,81 \times 10^4$ Pa	Lbf/in ² (or psi) = 6895,00 Pa = 0,0698 bar
kgf/mm ² = 9,81 N/mm ² = 0,981 daN/mm ² = 9,81 MPa	= 5,17/mm of mercury ton-force per square inch = tonf/in ² = 15,4448 Mpa

Henkel – The Solution Provider

A World of Engineering Solutions and Customer Support

The Henkel Group is a world-wide, market-driven specialty chemical company. Strong brands with proven and trusted names, such as Loctite® and Teroson, have long been the key to Henkel's success in the automotive and many other industries. The portfolio includes adhesives and sealants, products for direct glazing, corrosion protection, underbody and anti-chip coating, sound deadening solutions, body care and many other specialty chemicals.

Henkel & Motor Sports

Henkel has a long tradition of sponsorship in motor sport through the Loctite® and Teroson brands. With effect from 2004, Henkel has been an Official Supplier to the Team McLaren Mercedes Formula One racing team, thus building on the partnership which began in 1995. Today, every major assembly of the Team McLaren Mercedes race car contains solutions which depend on products from the Henkel portfolio.

The Dakar Rally 2005 is the latest in a long line of top-level competitive motor sport events in which Henkel has been involved. It's a tough 16-day tour across 6 countries, and the mechanical components in the cars, bikes and trucks that competed were put under enormous stresses. Henkel has assisted the drivers as an Official Supplier, offering a wide range of Loctite® and Teroson branded adhesives, sealants, maintenance products, cleaners, bonding tapes and repair kits that helped to get many competitors to the finish and proved they were more than a match for the world's most demanding conditions.

Products from the Henkel range – Designed for everyday use – Tested on the world's toughest events.

For more information on the complete range of Loctite® products from the Henkel portfolio, please visit www.loctite.co.uk where you can download catalogues, data sheets, technical papers and application examples.

The data contained herein are intended as reference only. Please contact your local Henkel Technical Support Group for assistance and recommendation on specifications for these products.



**Henkel Loctite
Adhesives Limited**

Wood Lane End
Hemel Hempstead
Hertfordshire HP2 4RQ
Tel. 01442 418305
Fax 01442 418228

www.loctite.co.uk

© designates a trademark of Henkel KGaA or its affiliates, registered in Germany and elsewhere. © Henkel KGaA, 2005