

# LOCTITE®

## the adhesive sourcebook 2008

*Loctite® products for design, assembly,  
manufacturing, and maintenance*



Henkel



volume 8

# The Adhesive Sourcebook

The complete source of Loctite® adhesives, sealants, lubricants, coatings, dispensing and curing equipment available only from Henkel Corporation.

The Adhesive Sourcebook contains over 1,400 products in total! Put them to work to make things better, faster, and more cost-efficient. Loctite® products will help you tackle the most difficult challenges the world can throw your way.

## **Reorganized to make Loctite® product selection easy and fast:**

- **Industrial Application Solutions** – Twelve application areas feature easy-to-use product selector guides, Top Choice designations, and dispensing options designed to help you quickly narrow your search for the right Loctite® product solution to all your design, assembly, maintenance or repair challenges.
- **Medical Application Solutions** – Distinctive line for medical device assemblies.
- **Agency Approvals** – Quick reference listing of certified Loctite® products by agency: ABS, CFIA, CSA, FDA, ISO, Mil-Spec, NSF®, UL®, ULC®, NEHC, NAVSEA and Lloyd's of London.
- **Engineering Services** – Engineers and scientists are available to provide engineering assistance, contract lab services, prototype testing, joint product development programs and more.
- **Training** – A variety of training programs are offered to educate today's product designers and production and maintenance staffs on the benefits and cost-savings associated with Loctite® product solutions.
- **Indexes** – Easy-to-use indexes help you quickly find obsolete items, Loctite® products by product number and item number, and by Loctite® product name.

Call us at **1-800-LOCTITE** (562-8483) in the U.S. and 1-800-263-5043 in Canada:

- For technical product assistance
- For local application assistance from the Loctite® Adhesives and Sealants Specialist in your area
- For the name of your nearest distributor authorized to sell Loctite® products
- For access to the Henkel Auto-Fax system to obtain Loctite® product data sheets or material safety data sheets

In addition to support from your local representative, **The Adhesive Sourcebook** is also supported by [www.loctite.com](http://www.loctite.com) – a virtual adhesive library designed to give you the best technical electronic support in the industry.

**Available at your convenience, from your desktop, log on to our web site to obtain the following:**



**www.loctite.com**

Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.

## **E-CATALOG**

Gain quick and easy access to product descriptions, approvals/specifications, application suggestions, package specifications, and technical and material safety data.

## **APPLICATION ASSISTANCE**

Application assistance will aid in narrowing the range of products suitable for your design and maintenance needs. Or send a message to your local Adhesives and Sealants Specialist to arrange "in person" assistance.

## **DISTRIBUTOR LOCATOR**

Find a local distributor in the U.S. or Canada that has the product you need. All it takes is a zip or postal code.

## **DATA SHEETS & LITERATURE**

Instant access to technical and material safety data sheets. View electronic versions of our design guides, bonding guides, quick reference tools, and other special literature.

## **WHAT'S NEW?**

Find out about new Loctite® product introductions, feature articles, trade show schedules, and application success stories. Register online for adhesives seminars or CEU-accredited Manufacturing Reliability Training classes in your area.

# Table of Contents

At Henkel Corporation, we invent more than just quality Loctite® products, we provide solutions to industry's biggest challenges. Whether we are reducing assembly cost, providing design and application assistance, or increasing the reliability of your process, Henkel is dedicated to earning and keeping the trust of our customers. Through this philosophy, Henkel has assumed a position of worldwide leadership.

Trust Henkel Corporation to be your sole source for design assistance, application assistance, and after-the-sale support.

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## PROBLEM SOLVER



The Top Choice designation lets you know that this Loctite® product has demonstrated proven performance in handling a variety of customer applications and is most often included in initial product testing and evaluation.



# Bonding

For successful bonding, knowledge of adhesive methodology is essential. The most frequent causes for adhesive failure do not involve adhesive strength. Rather, they are attributed to inadequate preparation of the substrates and improper adhesive selection.

The most important factor in proper adhesive selection is assessing the environment the adhesive must withstand. Once the environmental factors have been recognized, adhesive selection becomes more easily defined as other factors, such as joint design, substrates, load, stress cycles, etc., can often be varied or altered with minor design changes.

## ***What is the best adhesive for my application?***

The following chart has been designed to help you select a bonding adhesive. This chart is intended to serve as a general guideline to help you determine which adhesive categories are best suited for your application. The data presented represents typical properties for each adhesive category; however, individual product properties may differ. It is suggested that, based on the information provided, you consider at least the two best adhesive categories that meet your application criteria. Individual product information can then be found on the pages that follow to help narrow your search.

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any adhesive.*

Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **[www.loctite.com](http://www.loctite.com)** and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

## **FREE BONDING GUIDES**

Loctite® Design Guides help you select the proper Loctite® adhesive for bonding Metals, Plastics, Rubbers and Thermoplastic Elastomers. Visit **[www.loctite.com](http://www.loctite.com)** and click on **Product & Service Solutions**, then select **Literature** to view the guides or request copies.





# Bonding Selector Guide

PERFORMANCE CONSIDERATIONS	ADHESIVE CATEGORY								
	Cyanoacrylates	Epoxies	Hot Melts	Light Cure	Silicones	Elastomers	Urethanes	2-Part Acrylics	2-Step Acrylics
<b>BENEFITS</b>	Wide range of bonding applications	Wide range of formulations	Versatile, fast, large gap filling	Rapid cure / adhesion to plastics	Excellent temperature resistance	Flexible, paintable, bonder/sealant	Excellent toughness / flexibility	Good impact resistance / flexibility	Good impact resistance, no-mix
<b>LIMITATIONS</b>	Low solvent resistance	Mixing required	Limited heat resistance	Light cure system required	Low adhesion strength	High temperature resistance	Sensitive to moisture	Mixing required	Primer required
<b>TEMPERATURE RESISTANCE</b>									
Typical for the category	-65°F to +180°F	-65°F to +180°F	-65°F to +250°F	-65°F to +300°F	-65°F to +400°F	-40°F to +200°F	-65°F to +250°F	-65°F to +250°F	-65°F to +300°F
Highest Rated Product	+250°F	+400°F	+330°F	+350°F	+725°F	+200°F	+300°F	+250°F	+400°F
<b>ENVIRONMENTAL RESISTANCE</b>									
Polar Solvents (ex. H <sub>2</sub> O, Ethylene Glycol IPA, Acetone)	Poor <sup>1</sup>	Very Good	Good	Good	Good	Good	Good	Good	Good
Non-Polar Solvents (ex. Motor Oil, Toluene, Gasoline, ATF)	Good	Excellent	Good	Very Good	Poor to Fair	Poor	Good	Very Good	Very Good
<b>ADHESION TO SUBSTRATES</b>									
Metals	Very Good	Excellent	Good	Good	Good	Very Good	Good	Excellent	Excellent
Plastics <sup>2</sup>	Excellent	Fair	Very Good	Excellent	Fair	Good	Very Good	Excellent	Fair
Glass	Poor	Excellent	Good	Excellent	Very Good	Good	Good	Good	Excellent
Rubber	Very Good	Fair	Fair	Fair	Good	Poor	Good	Poor	Poor
Wood	Good	Very Good	Excellent	Poor	Fair	Very Good	Fair	Good	Good
<b>OVERLAPPING SHEAR STRENGTH</b>	High	High	Low	High	Low	Medium	Medium	High	High
<b>PEEL STRENGTH</b>	Low <sup>5</sup>	Medium	Medium	Medium	Medium	Medium	Medium	High	Medium
<b>TENSILE STRENGTH</b>	High	High	Low	High	Medium	Medium	Medium	High	High
<b>ELONGATION / FLEXIBILITY</b>	Low	Low	High	Medium	High	High	High	Medium	Medium
<b>HARDNESS</b>	Rigid	Rigid	Semi-Soft	Semi-Rigid	Soft	Soft	Soft	Semi-Rigid	Semi-Rigid
PROCESS CONSIDERATIONS	ADHESIVE CATEGORY								
	Cyanoacrylates	Epoxies	Hot Melts	Light Cure	Silicones	Elastomers	Urethanes	2-Part Acrylics	2-Step Acrylics
<b>NUMBER OF COMPONENTS</b>	1	2	1	1	1	1	2	2	2
<b>CURE TEMPERATURE</b>	Room Temperature	Room Temperature	Room Temperature <sup>3</sup>	UV/Visible	Room Temperature	Room Temperature	Room Temperature	Room Temperature	Room Temperature
<b>FIXTURE TIME</b>									
Average	60 seconds	20 minutes	70 seconds	30 seconds	25 minutes	25 minutes	25 minutes	20 minutes	5 minutes
Fastest	5 seconds	3 to 5 minutes	20 seconds	5 seconds	2 minutes	10 minutes	5 minutes	3 to 5 minutes	30 seconds
<b>FULL CURE TIME</b>	24 hours	12 to 24 hours	1 hour (or when cooled) <sup>4</sup>	30 to 60 seconds	1 to 7 days	1 to 7 days	24 hours	24 hours	24 hours
<b>GAP FILL</b>									
Ideal (in inches)	0.001 to 0.006	0.004 to 0.006	0.002 to 0.005	0.002 to 0.010	0.001 to 0.006	0.001 to 0.006	0.004 to 0.006	0.010 to 0.040	0.002 to 0.004
Maximum (in inches)	0.010	0.125	0.240	0.25	0.25	0.24	0.125	0.5	0.040
<b>DISPENSING / MIXING EQUIPMENT REQUIRED</b>	No	Yes	Yes	No	No	No	Yes	Yes	No
<b>LIGHT CURE VERSIONS AVAILABLE?</b>	Yes	Yes	No	Yes	Yes	No	No	No	Yes
<i>For more information on each adhesive category refer to pages...</i>	4-7	24-29	8-11	12-15	56-59	16-17	24-29	21, 23	20, 22

<sup>1</sup> Cyanoacrylates have very good moisture resistance on plastics.

<sup>2</sup> Uncured liquid adhesives may cause stress cracking of certain thermoplastics, e.g., polycarbonate, acrylic, and polysulfone. Special products and process techniques are available. Consult the Loctite® Design Guide to Bonding Plastics (LT-2197) or contact 1-800-LOCTITE (562-8483) for more information.

<sup>3</sup> Elevated temperatures are required to dispense liquid Hot Melt Adhesives.

<sup>4</sup> Urethane Hot Melts require 24 hours for full cure.

<sup>5</sup> Exception: Toughened cyanoacrylates have *HIGH* peel strength.

# Cyanoacrylates

Technology from Henkel Corporation has made the productivity promises of cyanoacrylate adhesives (instant adhesives) a reality with the industry's widest selection of high-performance, application-specific, instant adhesives. Loctite® instant adhesives are available in a variety of viscosities, cure speeds, gap-filling capabilities, and substrate compatibilities. The ultra high-performance Loctite® Prism® family offers additional products that surpass the most stringent demands, including toughened formulations, low odor and low blooming products, and thermally resistant formulations.

## GENERAL PURPOSE / SURFACE INSENSITIVE

### LOCTITE® 401™ PRISM® INSTANT ADHESIVE

#### Medium Viscosity

Designed for the assembly of difficult-to-bond materials that require uniform stress distribution. Particularly suited for bonding a wide range of materials, including metals, plastics, and elastomers. Also formulated for faster cure speeds on dry or acidic surfaces and substrates.



### LOCTITE® 406™ PRISM® INSTANT ADHESIVE

#### Wicking Grade

Designed for the bonding of plastics and electrometric materials where very fast fixturing is required.

### LOCTITE® 431™ PRISM® INSTANT ADHESIVE

#### High Viscosity

For bonds that require greater gap fill. Bonds to a wide variety of substrates, including dry or acidic surfaces. Fixtures fast and stays fast throughout the life of the product.



### LOCTITE® 454™ PRISM® INSTANT ADHESIVE

#### Gel

Designed for the assembly of difficult-to-bond materials that require uniform stress distribution. Particularly suited for bonding porous or absorbent materials. Also formulated for faster cure speeds on dry or acidic surfaces and substrates.



## LOW ODOR / LOW BLOOM

### LOCTITE® 403™ PRISM® INSTANT ADHESIVE

#### High Viscosity

Part of a family of low odor, low blooming, surface insensitive products designed to improve both the work environment and the cosmetic appearance. Products now have faster fixture speeds on plastics and metals.

### LOCTITE® 455™ PRISM® INSTANT ADHESIVE

#### Gel

Particularly suited for bonding porous or absorbent substrates where low odor and/or non-blooming properties are required.

## TOUGHENED

### LOCTITE® 380™ BLACK MAX® INSTANT ADHESIVE

The original elastomer-modified instant adhesive. Bonds metal, rubber, and plastic. Excellent peel, impact and shear strength.

### LOCTITE® 411™ PRISM® INSTANT ADHESIVE

#### Clear

An adhesive formulated for excellent impact and peel strength in gap-filling applications.

### LOCTITE® 426™ PRISM® INSTANT ADHESIVE

#### Gel

Designed for porous surfaces and vertical or overhead applications with the added benefits provided by an elastomer-modified instant adhesive.





INTRODUCING:

## the **NEW** Loctite® Bottle

New nozzle for *optimal* dispensing accuracy and control.

Positive seal cap –  
*seals with a click.*

*Highly flexible* package provides flow control and *ease-of-use*.

### TOUGHENED (continued)

#### LOCTITE® 435™ PRISM® INSTANT ADHESIVE

*Surface Insensitive*

The first true *clear, surface insensitive*, elastomer-modified instant adhesive. Faster fixture times over traditional toughened adhesives with exceptional bond and peel strength on metals, plastics, and rubbers.

#### LOCTITE® 480™ PRISM® INSTANT ADHESIVE

Low viscosity elastomer-modified instant adhesive. Bonds metals and rubbers. Excellent peel, impact and shear strength. NSF/ANSI 61 certified for potable water.



### THERMALLY RESISTANT

#### LOCTITE® 4204™ PRISM® INSTANT ADHESIVE

Clear, toughened, thermally resistant instant adhesive. Excellent hot strength and heat aging properties up to 250°F.

### LIGHT CURE ADHESIVE

#### LOCTITE® 4306™/4307™ FLASHCURE® LIGHT CURE ADHESIVES

Low or high viscosity fluorescent adhesives that achieve tack-free cures in less than 5 seconds. Surface versatile with shadow cure capability.



### FLEXIBLE

#### LOCTITE® 4851™/4861™ PRISM® INSTANT ADHESIVES

Medium and high viscosity instant adhesives for the assembly of flexible components.

### GENERAL PURPOSE

#### LOCTITE® 382™ TAK PAK® INSTANT ADHESIVE

An adhesive designed for high performance wire tacking when used with Loctite® 712™ or 7452™ Tak Pak® Accelerator and for gap filling up to 0.008".

#### LOCTITE® 404™ QUICK SET™ INSTANT ADHESIVE

For general maintenance and repair. Excellent for rubber bonding.



#### LOCTITE® 444™ TAK PAK® INSTANT ADHESIVE

An adhesive designed for printed circuit board assembly and repair. Cures instantly with Loctite® 712™ or 7452™ Tak Pak® Accelerator.

#### LOCTITE® 495™ SUPER BONDER® INSTANT ADHESIVE

Designed to bond rubber, metal, and plastic parts with gaps to 0.004".

#### LOCTITE® 498™ SUPER BONDER® INSTANT ADHESIVE

*Thermal Cycling Resistant*

A medium viscosity, high temperature product for all metals, and most plastics and rubbers. Resists temperatures to 180°F continuous or up to 250°F intermittent.

#### Loctite® Showcase Needle Variety Kit

This kit contains five (5) each of an assortment of high precision stainless steel tips in various lengths and gauges. Tapered and flexible dispense tips are also included. All dispense tips have helical thread Luer-Lok® hubs for reliable locking.

Item Number: 98439



### DISPENSING OPTIONS

#### Loctite® Integrated Semiautomatic Dispenser

systems combine a controller and reservoir into a single unit for valve dispensing of all Loctite® gel and instant adhesives. When used with CA dispense valve #98013 or stationary valve #97114 (for gel products), the integrated semiautomatic dispenser provides the best automatic dispensing solution. Can be equipped with low-level sensing.



	With Low-Level	Without Low-Level
0 – 15 psi	97020	97010
1 – 100 psi	97017	97007

#### Loctite® Benchtop Peristaltic Dispenser

is a reliable and effective volumetric dispenser for single-component, low viscosity instant adhesives, up to 5,000 cPA, directly from the product bottle. Great for dispensing applications where a precise bead or specific flow rate is necessary. The dispenser is electro-mechanically operated and does not require the use of an air source.

Item Number: 98548

For available spare parts and accessories, please visit

[www.equipment.loctite.com](http://www.equipment.loctite.com).



See our **Loctite® Equipment Sourcebook, LT-3669** or visit us at [www.equipment.loctite.com](http://www.equipment.loctite.com) for more details.



# Loctite® Instant Adhesives Properties Chart

PRODUCT			Item Number	Package Type & Size	TYPICAL USE	COLOR	GAP FILL	CATEGORY	VISCOSITY (cPA)	SHEAR STRENGTH* (psi)	TEMPERATURE RANGE	CURE SPEED**	SPECIFIC GRAVITY	AGENCY APPROVALS
GENERAL PURPOSE	SURFACE INSENSITIVE	401™ Prism®	40104 40140 40161	3 g tube 20 g bottle 1 lb. bottle	General purpose	Clear	0.005"	Ethyl	110	3,200	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.05	CFIA
		406™ Prism®	40604 40640 40661	3 g tube 20 g bottle 1 lb. bottle	Wicking grade	Clear	0.004"	Ethyl	20	3,200	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
		431™ Prism®	41254 41255 41256	3 g tube 20 g bottle 1 lb. bottle	Gap filling	Clear	0.008"	Ethyl	1,000	2,300	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.1	N/A
		454™ Prism®	45404 21925 45440 45474 45478	3 g tube 10 g syringe 20 g tube 200 g tube 300 g cartridge	Porous surfaces	Clear	0.010"	Ethyl	Gel	3,200	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.05	CFIA, ABS
LOW ODOR / LOW BLOOM	SURFACE INSENSITIVE	455™ Prism®	22309 17421	10 g syringe 200 g tube	Porous surfaces	Clear	0.010"	Alkoxy	Gel	2,600	-65°F to 160°F	Fixture – 90 sec. Full – 24 hrs.	1.10	N/A
		403™ Prism®	40304 40340 40361	3 g tube 20 g bottle 1 lb. bottle	Gap filling	Clear	0.008"	Alkoxy	1,000	2,600	-65°F to 160°F	Fixture – 50 sec. Full – 24 hrs.	1.10	N/A
		408™ Prism®	40840 40861	20 g bottle 1 lb. bottle	Wicking grade	Clear	0.002"	Alkoxy	5	2,600	-65°F to 160°F	Fixture – 50 sec. Full – 24 hrs.	1.05	N/A
		460™ Prism®	46004 46040 46061	3 g tube 20 g bottle 1 lb. bottle	Close fitting parts	Clear	0.004"	Alkoxy	45	2,600	-65°F to 160°F	Fixture – 50 sec. Full – 24 hrs.	1.10	N/A
TOUGHENED		380™ Black Max®	38004 38050 38061	3 g tube 1 oz. bottle 1 lb. bottle	Close fitting parts	Black	0.006"	Ethyl	300	3,750	-65°F to 225°F	Fixture – 90 sec. Full – 24 hrs.	1.10	CFIA
		410™ Prism®	41004 41045 41061	3 g tube 20 g bottle 1 lb. bottle	Gap filling	Black	0.008"	Ethyl	3,500	3,200	-65°F to 225°F	Fixture – 90 sec. Full – 24 hrs.	1.07	CFIA
		426™ Prism®	21921 18398 17451 17529	10 g syringe 20 g tube 200 g tube 300 g cartridge	Porous surfaces	Black	0.010"	Ethyl	Gel	3,000	-65°F to 210°F	Fixture – 20 sec. Full – 24 hrs.	1.10	N/A
		480™ Prism®	48040 48061	20 g bottle 1 lb. bottle	General filling	Black	0.006"	Ethyl	200	3,800	-65°F to 180°F	Fixture – 90 sec. Full – 24 hrs.	1.10	NSF/ANSI 61
		411™ Prism®	41104 41145 41161	3 g tube 20 g bottle 1 lb. bottle	Clear gap filling	Clear	0.008"	Ethyl	5,000	3,200	-65°F to 210°F	Fixture – 30 sec. Full – 24 hrs.	1.07	N/A
	SURFACE INSENSITIVE	435™ Prism®	41005 40994 40995	3 g tube 20 g bottle 1 lb. bottle	General purpose	Clear	0.006"	Ethyl	200	2,700	-65°F to 240°F	Fixture – 30 sec. Full – 24 hrs.	1.1	N/A
		438™ Prism®	41006 40997 40996	3 g tube 20 g bottle 1 lb. bottle	General purpose	Black	0.006"	Ethyl	200	2,800	-65°F to 240°F	Fixture – 30 sec. Full – 24 hrs.	1.1	N/A
THERMALLY RESISTANT		4203™ Prism®	28026 28027	20 g tube 1 lb. bottle	Close fitting parts	Clear	0.005"	Ethyl	375	2,200	-65°F to 250°F	Fixture – 30 sec. Full – 24 hrs.	1.10	N/A
		4205™ Prism®	28028 28029 28030	20 g tube 200 g tube 300 g cartridge	Porous surfaces	Clear	0.010"	Ethyl	Gel	2,300	-65°F to 250°F	Fixture – 30 sec. Full – 24 hrs.	1.10	N/A
		4204™ Prism®	26324 26325	20 g tube 1 lb. bottle	Gap filling	Clear	0.008"	Ethyl	4,000	2,400	-65°F to 250°F	Fixture – 30 sec. Full – 24 hrs.	1.10	N/A
LIGHT CURE		4306™ Flashcure®	37439 37442*	1 oz. bottle 1 lb. bottle	Close fitting	Clear/ Pale Green/ Fluorescent	0.004"	Ethyl	20	2,000‡	-65°F to 240°F	Fixture < 5 sec‡	1.1	ISO 10993
		4307™ Flashcure®	37441 37443*	1 oz. bottle 1 lb. bottle	Gap filling	Clear/ Pale Green/ Fluorescent	0.008"	Ethyl	900	2,000‡	-65°F to 240°F	Fixture < 5 sec‡	1.1	N/A
FLEXIBLE		4851™ Prism®	37732 37733	20 g bottle 1 lb. bottle	Flexible	Clear	0.006"	Alkyl	400	2,175	-65°F to 125°F	Fixture – 20 sec. Full – 24 hrs.	1.10	N/A
		4861™ Prism®	37708 37711	20 g bottle 1 lb. bottle	Flexible	Clear	0.008"	Alkyl	4,000	2,465	-65°F to 125°F	Fixture – 20 sec. Full – 24 hrs.	1.10	N/A

\* Grit blasted steel.

\*\* Varies with substrates.

‡ Data generated using polycarbonate.

‡ Full Cure = 24 hours without UV exposure (With UV exposure, see Technical data Sheets)

A complete line of surface primers, accelerators and cleaners are available to further enhance the performance of Loctite® instant adhesives. Refer to the Surface Preparation section.



Indicates worldwide availability.



Indicates TOP CHOICE products.

# Loctite® Instant Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	TYPICAL USE	COLOR	GAP FILL	CATEGORY	VISCOSITY (cPa)	SHEAR STRENGTH* (psi)	TEMPERATURE RANGE	CURE SPEED**	SPECIFIC GRAVITY	AGENCY APPROVALS
GENERAL PURPOSE	382™ Tak Pak®	38203 3 g tube 20 g kit† 38240 20 g bottle 38261 1 lb. bottle	Gap filling and ultra-performance wire tracking	Clear	0.008"	Ethyl	5,000	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.05	N/A
	404™ Quick Set™	46551 1/8 oz. bottle 46548 4 oz. bottle 46561 1 lb. bottle	Rubber o-ring bonder	Clear	0.005"	Ethyl	80	3,500	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	ABS, CFIA, Commercial item std. A-A-3097
	409™ Super Bonder®	40904 3 g tube 21922 10 g syringe 40945 20 g tube 40974 200 g tube 18030 300 g cartridge	General purpose gel	Clear	0.010"	Ethyl	Gel	3,200	-65°F to 180°F	Fixture – 75 sec. Full – 24 hrs.	1.10	N/A
	414™ Super Bonder®	41404 3 g tube 41450 1 oz. bottle 41461 1 lb. bottle	Plastic bonder	Clear	0.006"	Ethyl	110	3,200	-65°F to 180°F	Fixture – 20 sec. Full – 24 hrs.	1.05	CFIA, Commercial item std. A-A-3097
	415™ Super Bonder®	41550 1 oz. bottle 41561 1 lb. bottle	Gap filling metal bonder	Clear	0.008"	Methyl	1,500	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	416™ Super Bonder®	41650 1 oz. bottle 41661 1 lb. bottle	Gap filling plastic bonder	Clear	0.008"	Ethyl	1,500	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.05	CFIA, Commercial item std. A-A-3097
	420™ Super Bonder®	42050 1 oz. bottle 42061 1 lb. bottle	Wicking type plastic bonder	Clear	0.002"	Ethyl	2	2,900	-65°F to 180°F	Fixture – 20 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
	422™ Super Bonder®	42250 1 oz. bottle 42261 1 lb. bottle	Gap filling plastic bonder	Clear	0.008"	Ethyl	2,500	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	CFIA, Commercial item std. A-A-3097
	430™ Super Bonder®	43004 3 g tube 43050 1 oz. bottle 43061 1 lb. bottle	Metal bonder for close fitting parts	Clear	0.005"	Methyl	80	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	444™ Tak Pak®	12292 20 g bottle 20419 20 g kit† 12294 1 lb. bottle	Tak Pak® wire tacking	Clear	0.007"	Ethyl	700	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
	493™ Super Bonder®	49350 1 oz. bottle 49361 1 lb. bottle	Wicking type metal bonder	Clear	0.002"	Methyl	2	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	495™ Super Bonder®	49595 0.07 fl. oz. Gluematic® Pen 49504 3 g tube 49550 1 oz. bottle 49561 1 lb. bottle	General purpose	Clear	0.004"	Ethyl	45	2,750	-65°F to 180°F	Fixture – 20 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097, ABS
	496™ Super Bonder®	49650 1 oz. bottle 49661 1 lb. bottle	General purpose rubber bonder	Clear	0.005"	Methyl	125	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	498™ Super Bonder®	49850 1 oz. bottle 49861 1 lb. bottle	Thermal cycling	Clear	0.007"	Ethyl	500	3,000	-65°F to 180°F	Fixture – 50 sec. Full – 24 hrs.	1.10	N/A
	499™ Super Bonder®	49904 3 g tube 21924 10 g syringe 49945 20 g tube 49974 200 g tube	Thermal cycling gel	Clear	0.010"	Ethyl	Gel	3,200	-65°F to 200°F	Fixture – 75 sec. Full – 24 hrs.	1.10	N/A
	QuickTite®	39202 0.14 oz. bottle	General gel	Clear	0.010"	Ethyl	Gel	2,800	-65°F to 180°F	Fixture – 45 sec. Full – 24 hrs.	1.1	N/A

\* Grit blasted steel.

\*\* Varies with substrates.

† Contains Loctite® 382™ Tak Pak® Instant Adhesive (20 g bottle), Loctite® 7452™ Tak Pak® Accelerator (0.7 oz. net wt. aerosol can).

† Contains Loctite® 444™ Tak Pak® Instant Adhesive (20 g bottle), Loctite® 7452™ Tak Pak® Accelerator (0.7 oz. net wt. aerosol can).

A complete line of surface primers, accelerators and cleaners are available to further enhance the performance of Loctite® instant adhesives. Refer to the Surface Preparation section.



Indicates TOP CHOICE products.

[www.instantadhesives.loctite.com](http://www.instantadhesives.loctite.com)


# Hot Melts

Loctite® Hysol® hot melt adhesives were developed to bond a variety of substrates, including difficult-to-bond plastics. These adhesives can handle today's toughest applications in a broad range of industries. Loctite® Hysol® hot melts are ideal for applications that require high speed manufacturing, bonding versatility, very large gap filling, fast green strength, and minimal shrinkage. Loctite® Hysol® hot melts are solvent-free and contain environmentally-friendly materials with no harmful VOCs.

## SPRAYABLE / POLYOLEFIN-BASED

### LOCTITE® 0430™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

#### Medium Open Time

Suitable for bonding expanded polystyrene, polyethylene, and urethane foams. Can be used in applications where solvent-based aerosols are used.

### LOCTITE® 0437™ HYSOL® SPRAYPAC™ HOT MELT ADHESIVE

#### Medium Open Time

Formulated to be spray-applied to a wide variety of substrates.

### LOCTITE® 0450™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

#### Extended Open Time

Formulated for spray applications, this adhesive is well suited for use on expanded polystyrene or urethane foams.



### LOCTITE® 0452™ HYSOL® SPRAYPAC™ HOT MELT ADHESIVE

#### Extended Open Time

Formulated to be spray-applied to a wide variety of substrates. Excellent for bonding expanded polystyrene or urethane foams.

## POLYOLEFIN-BASED

### LOCTITE® 3651™ HYSOL® HOT MELT ADHESIVE

#### Plastic Bonder

An adhesive for plastic bonding. Ideal for polyethylene and polyolefin plastics. Long open time of 80 to 100 seconds.



## URETHANE-BASED

### LOCTITE® 3631™ HYSOL® HOT MELT ADHESIVE

#### High Strength

A toughened, high strength adhesive for use on plastics. Flexible bond with an open time of 60 seconds.



Item Number: 98011  
For use only with Loctite® 3631™  
300 ml cartridges



## DISPENSING OPTIONS

**Loctite® Hysol™ 050-HT ½" Superstick Dispenser** is a lightweight, ergonomically-designed, manual dispenser for industrial use. The dispenser contains a fixed precision thermostat control for consistent heating. The 050-HT is designed for high temperature polyamides. For available spare parts and dispense nozzles, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 98545



**Loctite® Hysol™ 050A ½" Superstick Dispenser** is an economical, industrial-designed applicator for applying EVA and polyolefin hot melts. It is designed to deliver up to 4 lbs./hr. melt rate with optimized shutoff control. For available spare parts and dispense nozzles, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 916282



## POLYAMIDE-BASED

### LOCTITE® 7460™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

#### *Sprayable*

Formulated for spray applications. High heat resistance and fast set time. Suitable for bonding foams, fabric, and wood.

### LOCTITE® 7500™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

#### *Long Open Time*

Formulated for long open time and high output for bonding surfaces up to 15 square feet.



### LOCTITE® 7809FR™ HYSOL® HOT MELT ADHESIVE

#### *Fire Retardant*

Modified with fire retardant materials. It has a UL 94V-O flammability rating.

### LOCTITE® 7811™ HYSOL® HOT MELT ADHESIVE

#### *High Temperature*

A high performance polyamide with exceptional high temperature resistance and impact at low temperatures.

### LOCTITE® 7901™ HYSOL® HOT MELT ADHESIVE

#### *Potting*

Low viscosity polyamide used extensively for potting and encapsulating.

## EVA-BASED

### LOCTITE® 1X™ HYSOL® HOT MELT ADHESIVE

#### *Fast Setting*

Medium to fast setting; recommended for bonding paper, wood, fabric, and foam.

### LOCTITE® 3X™ HYSOL® POLYSHOT™ HOT MELT ADHESIVE

#### *Porous Substrates*

Used extensively for bonding sand molds and other porous substrates.

### LOCTITE® 0232™ HYSOL® HOT MELT ADHESIVE

#### *Medium Open Time*

A medium setting adhesive with an open time of 15 seconds.

### LOCTITE® 1942™ HYSOL® HOT MELT ADHESIVE

#### *General Purpose*

Medium setting, general purpose hot melt adhesive. Excellent adhesion to wood and many plastics.



### LOCTITE® 4046™ HYSOL® HOT MELT ADHESIVE

#### *Extended Open Time*

Highly flexible, with a 60-second open time for demanding substrates such as rubber and polyethylene.

### LOCTITE® COOLMELT™ HYSOL® HOT MELT ADHESIVE

#### *Low Temperature*

Flexible material designed to be applied at low temperatures. Ideal for bonding heat-sensitive parts.

### LOCTITE® SUPERPAC™ HYSOL® HOT MELT ADHESIVE

#### *Cardboard Bonder*

A medium setting material with a 30-second open time. It is formulated to bond cardboard and foams.





[www.loctite.com](http://www.loctite.com)



Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.

## Loctite® Hysol® Hot Melt Adhesives Properties Chart

Properties Chart

PRODUCT		Item Number	Package Type & Size	COLOR	ATTRIBUTES	VISCOSITY (cP) AT DISPENSE TEMPERATURE	TENSILE STRENGTH (psi)	OPEN TIME	TEMPERATURE RESISTANCE	% ELONGATION	HARDNESS (SHORE A)	AGENCY APPROVALS
SPRAYABLE/POLYOLEFIN-BASED	0430™ Hysol® SprayPac™	83349	Polyshot™ 35 lb. carton	Cream	Medium open time	5,000	280	3.5 minutes sprayed	170°F	N/A	75	N/A
	0430™ Red Hysol® SprayPac™	83351	Polyshot™ 35 lb. carton	Pink	Medium open time	5,000	280	3.5 minutes sprayed	170°F	N/A	75	N/A
	0437™ Hysol® SprayPac™	83352	36 lb. carton bricks	Cream	Medium open time	5,200	270	3.5 minutes sprayed	170°F	N/A	75	N/A
	0450™ Hysol® SprayPac™ 	83353 83354	Polyshot™ 12 oz. sample bag Polyshot™ 35 lb. carton	Natural	Extended open time	4,500	N/A	5 to 8 minutes	156°F	N/A	N/A	N/A
	0450™ Red Hysol® SprayPac™	83356	Polyshot™ 35 lb. carton	Pink	Extended open time	4,500	N/A	5 to 8 minutes	156°F	N/A	N/A	N/A
	0452™ Hysol® SprayPac™	83257	SprayPac™ 21 lb. pucks	Natural	Extended open time	4,300	N/A	5 to 8 minutes	156°F	N/A	N/A	N/A
POLYOLEFIN - BASED	3651™ Hysol® 	31303	12 kg squares	Beige	Plastic bonder	10,000	334	80 to 100 seconds	266°F	790	55	N/A
URETHANE - BASED	3631™ Hysol® 	31291 31279	300 ml cartridge 5 gallon pail	Off-White	High strength	12,000	1,800	60 seconds	250°F	940	91	N/A
POLYAMIDE-BASED	7460™ Hysol® SprayPac™	83308	Polyshot™ 25 lb. pail	Pale Amber	Sprayable	6,700	N/A	30 seconds	210°F	N/A	N/A	N/A
	7500™ Hysol® SprayPac™ 	83312 83313	Polyshot™ 13 oz. sample bag Polyshot™ 25 lb. pail	Pale Amber	Long open time	1,900	N/A	2 minutes	200°F	N/A	N/A	N/A
	7804™ Hysol®	83325 83326 83327 83328 83330	5 lb. sample bag pellets 40 lb. carton pellets Superstick™ 10" 5 oz. sample bag Superstick™ 10" 32 lb. carton Polyshot™ 25 lb. pail	Amber	High viscosity	7,500	340	35 seconds	220°F	900	74	N/A
	7804FRM-HV™ Hysol®	83382 83384 83387	40 lb. carton pellets Superstick™ 10" 30 lb. pail Polyshot™ 25 lb. pail	Off White	Fire retardant	6,000	245	35 seconds	220°F	300	N/A	UL 94V-0
	7809FR™ Hysol®	83388	5 lb. sample bag pellets	Amber	Fire retardant	7,000	363	35 seconds	240°F	373	85	UL 94V-0
	7811™ Hysol®	83337 83339 83340	5 lb. sample bag pellets Polyshot™ 10" 13 oz. sample bag Polyshot™ 25 lb. pail	Amber	High temperature	6,400	400	35 seconds	266°F	1,200	N/A	N/A
	7901™ Hysol®	83341 83342 83344	5 lb. sample bag pellets 40 lb. carton pellets Polyshot™ 25 lb. pail	Amber	Potting	750	260	35 seconds	300°F	80	84	N/A

 Indicates TOP CHOICE products.

### DISPENSING OPTIONS

For more information, refer to the "Equipment" section or visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

3/4" Maxistick™ Dispenser	1 3/4" SprayPac® and Polyshot™ Applicators		
Loctite® Hysol™ 075/075-LT	Loctite® Hysol™ 175-Air/175-Air-HT	Loctite® Hysol™ 175-Spray/175-Spray-HT	Loctite® Hysol™ 175 Manual Applicator
			
Item # 98033 and 98034	Item # 98036 and 98040	Item # 98037 and 98041	Item # 98035

## Loctite® Hysol® Hot Melt Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	ATTRIBUTES	VISCOSITY (cP) AT DISPENSE TEMPERATURE	TENSILE STRENGTH (psi)	OPEN TIME	TEMPERATURE RESISTANCE	% ELONGATION	HARDNESS (SHORE A)	AGENCY APPROVALS
EVA-BASED	<b>1X™ Hysol®</b>	83357 5 lb. sample bag pellets 83358 40 lb. carton pellets 83360 Maxistick™ 35 lb. carton 83365 Superstick™ 10" 25 lb. carton 83368 Polyshot™ 35 lb. Carton	Light Yellow	Fast setting	2,000	370	15 seconds	150°F	90	N/A	FDA CFR175,105
	<b>3X™ Hysol®</b>	83369 Polyshot™ 12 oz. sample bag 83370 Polyshot™ 35 lb. carton	Tan	Porous substrates	4,000	580	60 seconds	135°F	300	N/A	FDA CFR175,105
	<b>0232™ Hysol®</b>	83239 40 lb. carton pellets 83241 Maxistick™ 35 lb. carton 83245 Superstick™ 10" 25 lb. carton 83247 Polyshot™ 35 lb. carton	Clear	Medium open time	11,000	N/A	15 seconds	153°F	N/A	N/A	FDA CFR175,105
	<b>236™ Hysol®</b>	83252 Superstick™ 10" 25 lb. carton	Clear	Medium viscosity	8,500	213	25 seconds	140°F	450	N/A	FDA CFR175,105
	<b>342™ Hysol®</b>	83255 Polyshot™ 35 lb. carton	Cream	Fast setting	8,250	800	5 seconds	166°F	60	N/A	FDA CFR175,105
	<b>740™ Hysol®</b>	83260 Superstick™ 10" 5 oz. sample bag 83261 Superstick™ 10" 25 lb. carton 83264 Polyshot™ 35 lb. carton	Light Yellow	High strength	9,000	750	10 seconds	168°F	75	N/A	FDA CFR175,105
	<b>740LV™ Hysol®</b>	83373 40 lb. carton pellets	Light Yellow	High temperature	3,500	700	10 seconds	215°F	80	N/A	FDA CFR175,105
	<b>1942™ Hysol®</b>	83266 5 lb. sample bag pellets 83267 40 lb. carton pellets 83269 Maxistick™ 35 lb. carton 83271 PT™ stick 35 lb. carton 83272 Ministick™ 35 lb. carton 83274 Superstick™ 10" 25 lb. carton 83275 Superstick™ 4" 25 lb. carton 83277 Polyshot™ 35 lb. carton	Tan	General purpose	5,000	250	30 seconds	142°F	500	N/A	FDA CFR175,105
	<b>4046™ Hysol®</b>	83278 Polyshot™ 12 oz. sample bag 83279 Polyshot™ 35 lb. carton	Cream	Extended open time	19,000	120	60 seconds	120°F	1,400	40	N/A
	<b>6002™ Hysol®</b>	83285 Polyshot™ 35 lb. carton	Amber	Fast setting	3,500	700	10 seconds	150°F	200	N/A	FDA CFR175,105
	<b>CoolMelt™ Hysol®</b>	83393 CoolMelt™ Maxistick™ 7 oz. sample bag 83394 CoolMelt™ Maxistick™ 35 lb. carton	Off White	Low temperature	7,200	195	15 seconds	140°F	800	N/A	FDA CFR175,105
	<b>SuperPac™ Hysol®</b>	83403 Maxistick™ 35 lb. carton 83404 Polyshot™ 12 oz. sample bag 83405 Polyshot™ 35 lb. carton	Light Yellow	Cardboard bonder	5,750	280	30 seconds	144°F	200	N/A	FDA CFR175,105
	<b>QuikPac™ Hysol®</b>	83395 5 lb. sample bag pellets 83397 Maxistick™ 7 oz. sample bag 83398 Maxistick™ 35 lb. carton 83400 Polyshot™ 35 lb. carton	Light Yellow	Low viscosity	4,645	N/A	15 seconds	174°F	N/A	N/A	FDA CFR175,105

 Indicates TOP CHOICE products.

## Loctite® Hysol® Hot Melt Stick Chart

DESCRIPTION	DIAMETER	LENGTHS	LOCTITE® APPLICATORS BY ITEM #
Superstick™	0.50"	4" / 10"	98544, 98545
Maxistick™	0.75"	2.4"	98033, 98034
Polyshot™	1.75"	1.5"	98035, 98036, 98040, 98037, 98041



# Light Cure Adhesives

Versatile Loctite® ultraviolet (UV) and visible light cure adhesives can be used in bonding, encapsulating, coating, tacking and sealing applications. These single-component, solvent-free products cure in seconds when exposed to UV / visible light sources. Some light cure adhesives can be combined with activator-curing methods to meet specific application requirements.

## EPOXY ADHESIVES

### LOCTITE® 3336™ LIGHT CURE ADHESIVE

A UV cure, medium viscosity, two-part epoxy. UV cure effects fast gelation. Complete cure at room temperature or heat cure. Tough and durable. Designed for potting, bonding, and sealing.

### LOCTITE® 3355™ LIGHT CURE ADHESIVE *Pre-Activated Epoxy*

A UV cure, medium viscosity, one-part epoxy. Unique delay feature allows UV cure of non-light-transmitting substrates. Extremely low shrinkage is ideal when alignment of small parts is critical. Low outgassing and acid free.

## CYANOACRYLATE ADHESIVES

### LOCTITE® 4306™/4307™ FLASHCURE® LIGHT CURE ADHESIVES

#### *Instant Adhesive*

New, patented technology. One-component, low or high viscosity fluorescent adhesives. Specifically formulated for extremely rapid UV or visible light cure and secondary cyanoacrylate cure mechanism. Eliminates the need for solvent-based accelerators.



## SILICONE ADHESIVES

### LOCTITE® 5031™ NUVA-SIL® SILICONE POTTING COMPOUND



#### *High Adhesion / Visible Light*

A UV or visible light curing silicone for high speed potting, coating and sealing applications. High adhesion for difficult-to-bond substrates.

### LOCTITE® 5033™ NUVA-SIL® SILICONE ADHESIVE SEALANT



#### *Paste / High Adhesion / Visible Light*

A UV or visible light and moisture curing silicone for high speed adhesion and sealing applications. High adhesion for difficult-to-bond substrates.

### LOCTITE® 5039™ NUVA-SIL® SILICONE ADHESIVE SEALANT



#### *Cure-In-Place Gasketing Compound*

A UV or visible light and moisture curing silicone for high speed adhesion, gasketing and sealing applications. High adhesion for difficult-to-bond substrates.

### LOCTITE® 5240™ NUVA-SIL® SILICONE ADHESIVE SEALANT



#### *Self-Leveling / Noncorrosive*

A UV or visible light and moisture curing silicone ideal for high speed adhesion and sealing applications. High adhesion for difficult-to-bond substrates.



## CURING AND DISPENSING OPTIONS

Loctite® CureJet™ 405 LED Item Number: 976420

Loctite® CureJet™ Indigo™ LED Item Number: 976418

Our highest power LED spot curing systems. Innovative design offers significantly wider cure area and curing intensity capability than our single point LED devices.





## ACRYLIC ADHESIVES

### LOCTITE® 352™ LIGHT CURE ADHESIVE

A high viscosity adhesive that creates a tough, flexible bond that is resistant to vibration and shock. Effective on a wide range of materials. Cures in minutes using an activator, UV light, or both.



### LOCTITE® 3103™ LIGHT CURE ADHESIVE

Thixotropic, flexible, low modulus, medium viscosity, UV / visible light cure adhesive for flexible bonds and reduced stress cracking on plastics. Cures through UV-blocked and tinted substrates. Also for potting, sealing, and gap filling.

### LOCTITE® 3105™ LIGHT CURE ADHESIVE

A high strength, low viscosity, UV / visible light cure adhesive. Primarily designed for bonding rigid and flexible PVC to polycarbonate. Enables easy assembly of components with close-fitting tolerances. Recommended for applications involving small gaps less than 0.25 mm.

### LOCTITE® 3106™ LIGHT CURE ADHESIVE

A high strength, medium viscosity, thixotropic, UV / visible light cure adhesive. Designed primarily for bonding rigid and flexible PVC to polycarbonate where large gap filling capabilities and a flexible joint are desired.



## CURING OPTIONS

**Loctite® ZETA® 7740 UV Wand Systems** utilize a 100 watt high-pressure mercury arc lamp with a universal power supply and a liquid-filled light wand. Operated manually or in the timed mode, they are capable of interfacing with a PLC controlled circuit. Continuous lamp intensity monitoring is also available by selecting item 958228 and the required Light Intensity Monitor (item 891494). Light guides are sold separately.

**Item Numbers:** 98157A and 958228



**Loctite® ZETA® 7411-S UV Flood System** is designed for use in a wide range of bonding, potting, tacking and sealing applications. Because of its reliability and simplicity, it is well suited for most production operations. The Loctite® ZETA® 7411-S can accept multiple part sizes. An optional timed control shutter (as displayed) or visible enhanced metal halide lamp are also available.

**Item Number:** 98413



For additional accessories, dispense tips and spare parts, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

### LOCTITE® 3107™ LIGHT CURE ADHESIVE

A low viscosity, UV / visible light cure adhesive for difficult-to-bond plastics including plasticized PVC. Very rapid cure. Flexible and fluorescent.

### LOCTITE® 3108™ LIGHT CURE ADHESIVE

A low durometer, rubbery, UV cure adhesive for potting and sealing of plastic, glass, and metal. Very flexible and resilient.

### LOCTITE® 3175™ LIGHT CURE ADHESIVE

A solvent-free adhesive designed for applications where a rapid cure and a dry-to-the-touch surface are required. Excellent for tacking and coating. Good adhesion to plastics.

### LOCTITE® 3491™ LIGHT CURE ADHESIVE

A fast curing, medium viscosity adhesive designed for bonding glass-to-glass and to a variety of other surfaces.

### LOCTITE® 3492™ LIGHT CURE ADHESIVE

A fast curing, low viscosity adhesive designed for bonding glass-to-glass and to a variety of other surfaces.

### LOCTITE® 3494™ LIGHT CURE ADHESIVE

A durable, UV / visible cure, medium viscosity adhesive designed for glass and metal bonding.

### LOCTITE® 3525™ LIGHT CURE ADHESIVE

A UV / visible cure, high viscosity adhesive. Fast cure, colorless bonds. Excellent flexibility, toughness, and durability to moisture exposure. Fluorescent. Used to bond glass, metal, and plastics.

### LOCTITE® 3526™ LIGHT CURE ADHESIVE

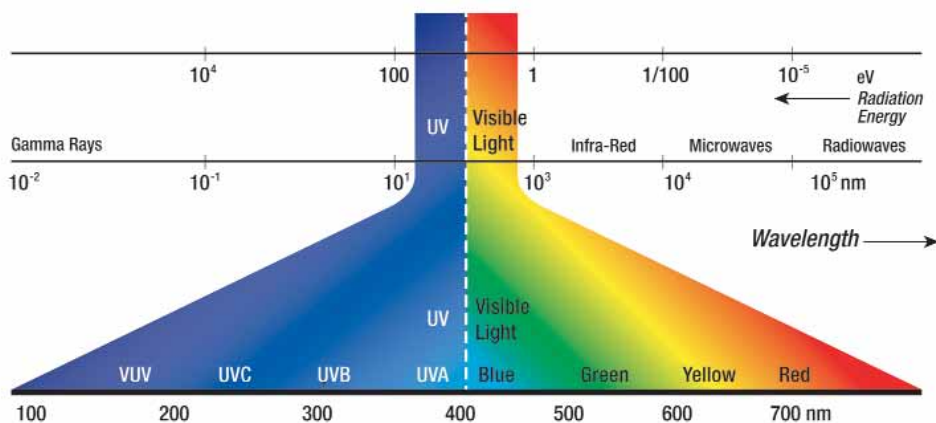
A UV / visible / heat cure version of Loctite® 3525™ Light Cure Adhesive. All the properties of Loctite® 3525™ plus low temperature, rapid, heat cure capabilities (250°F). Fast cure even under low energy sources. Fluorescent.

### LOCTITE® 3554™/3555™/3556™ INDIGO™ VISIBLE LIGHT CURE ADHESIVES

Low, medium, and high viscosity adhesives that cure in the visible spectrum, offering properties and performance similar to most UV / visible adhesives. Visible light adhesives cure with unique systems that minimize venting or specialized safety equipment. Benefits include lower initial investment and reduced maintenance costs.



## The Electromagnetic Spectrum



### Loctite® Light Cure Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	APPEARANCE, CLARITY, AND COLOR	CURE TYPE	KEY SUBSTRATES	VISCOSITY (cP), BROOKFIELD, 25°C	ELONGATION AT BREAK (%)	SHORE HARDNESS	TEMPERATURE RANGE	AGENCY APPROVALS
EPOXY ADHESIVES	3336™	31064 42 ml dual syringe 31065 400 ml dual syringe	Clear / Light Amber	Ultraviolet, room temperature, heat	Metal, thermoplastic	14,500	6	D 79	-65°F to 350°F	N/A
	3355™	40792 25 ml syringe 40793 1 liter bottle	Hazy White	Ultraviolet, delay cure	Metal, plastic, glass, ceramic	5,000	11.5	D 77	-65°F to 350°F	N/A
CYANOACRYLATE ADHESIVES	4306™ Flashcure®	37439 1 oz. bottle 37442 1 lb. bottle	Clear / Pale Green / Fluorescent	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	20	9	D 72	-65°F to 180°F	ISO 10993 Compliant
	4307™ Flashcure®	37441 1 oz. bottle 37443 1 lb. bottle	Clear / Pale Green / Fluorescent	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	900	6	D 477	-65°F to 180°F	ISO 10993 Compliant
SILICONE ADHESIVES	5031™ Nuva-Sil®	40086 300 ml cartridge 40087 40 lb. pail	Translucent	Visible, ultraviolet, moisture, acetoxo	Glass, metal, ceramic	5,500	100	A 34	-65°F to 350°F	N/A
	5033™ Nuva-Sil®	40088 300 ml cartridge 40089 40 lb. pail	Translucent / Colorless / Fluorescent	Visible, ultraviolet, moisture, acetoxo	Glass, metal, ceramic	145 g/min.†	170	A 55	-65°F to 350°F	N/A
	5039™ Nuva-Sil®	40438 300 ml cartridge 40439 40 lb. pail	Translucent / Colorless / Fluorescent	Visible, ultraviolet, moisture, acetoxo	Glass, metal, ceramic	220 g/min.†	210	A 37	-65°F to 350°F	N/A
	5083™ Nuva-Sil®	17528 300 ml cartridge 17635 40 lb. pail	Translucent / Colorless	Ultraviolet, moisture, acetoxo	Glass, metal, ceramic	145 g/min.†	170	A 55	-65°F to 350°F	UL Classified for U.S.
	5091™ Nuva-Sil®	17412 300 ml cartridge 18074 40 lb. pail	Translucent / Colorless	Ultraviolet, moisture, acetoxo	Glass, metal, ceramic	5,500	100	A 34	-65°F to 350°F	UL Classified for U.S.
	5240™ Nuva-Sil®	1010341 30 ml syringe 1010320 300 ml cartridge 1010343 40 lb. pail	Translucent / White	Visible, ultraviolet, moisture	Glass, metal, ceramic	18,000	270	A 45	-65°F to 350°F	ISO 10993 Compliant



Indicates worldwide availability.



Indicates TOP CHOICE products.

\* Made-to-order item.

† Extrusion rate, grams/minute, 1/8" orifice at 90 psi.


[www.visible.loctite.com](http://www.visible.loctite.com)

Visit the web for an all-access pass  
to distributors, safety & technical data sheets,  
literature, and product application assistance.



# Loctite® Light Cure Adhesives

## Properties Chart

Product					Item Number	Package Type & Size	Appearance, Clarity, and Color	Cure Type	Key Substrates	Viscosity (cP), Brookfield, 25°C	Elongation at Break (%)	Shore Hardness	Temperature Range	Shear Strength (psi)
ACRYLIC ADHESIVES	VISIBLE	3554™ Indigo™  	1072199 1072198	25 ml syringe 1 liter bottle	Clear / Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	300	7	77	-65°F to 300°F	3,350 <sup>3</sup>		
		3555™ Indigo™  	1072221 1072220	25 ml syringe 1 liter bottle	Clear / Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	3,000	10	76	-65°F to 300°F	2,350 <sup>3</sup>		
		3556™ Indigo™  	1072223 1072222	25 ml syringe 1 liter bottle	Clear / Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	5,000	29	70	-65°F to 300°F	2,900 <sup>3</sup>		
	ULTRAVIOLET / VISIBLE	3100™ 	19862	25 ml syringe	Slightly Hazy / Straw	Ultraviolet, visible	Glass, metal, thermoset plastic	6,000	210	D 66	-65°F to 300°F	1,670 <sup>2</sup>		
		3101™ 	19861	25 ml syringe	Slightly Hazy / Straw	Ultraviolet, heat, activator	Glass, metal, thermoset plastic	6,000	220	D 66	-65°F to 300°F	1,820 <sup>2</sup>		
		3102™ 	23690	1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic	3,750	265	D 59	-65°F to 300°F	2,291 <sup>3</sup>		
		3103™ 	23691 23692	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic	10,000 Thixotropic	260	D 51	-65°F to 300°F	2,849 <sup>3</sup>		
		3104™ 	23694 23693	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic, polyvinylchloride	160	50	D 69	-65°F to 300°F	3,155 <sup>3</sup>		
		3105™ 	23695 23696	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic, polyvinylchloride	300	265	D 64	-65°F to 300°F	3,640 <sup>3</sup>		
		3106™  	23697 23698	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic, polyvinylchloride	5,000	250	D 53	-65°F to 300°F	3,392 <sup>3</sup>		
		3107™	28419 28466	6 ml tube 1 liter bottle	Clear / Straw / Fluorescent	Ultraviolet, visible	Plasticized PVC, thermoplastic	500	220	D 27	-65°F to 300°F	783 <sup>4</sup>		
		3494™	30765 29487	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Glass, metal	5,500	190	D 65	-65°F to 300°F	2,440 <sup>1</sup>		
		3525™	30220 30221	25 ml syringe 1 liter bottle	Clear / Pale Straw / Fluorescent	Ultraviolet, visible	Glass, metal, thermoset plastic	15,000	260	D 60	-65°F to 300°F	1,480 <sup>1</sup>		
		3526™	30756 30764	25 ml syringe 1 liter bottle	Clear / Pale Straw / Fluorescent	Ultraviolet, visible, heat	Glass, metal, thermoset plastic	17,800	185	D 62	-65°F to 300°F	1,530 <sup>1</sup>		
	ULTRAVIOLET	349™ Impruv® 	34931 34990	50 ml bottle 1 liter bottle	Clear / Straw	Ultraviolet	Glass, metal	9,500	300	D 70	-65°F to 266°F	1,600 <sup>1</sup>		
		363™ Impruv®	36331 36390	50 ml bottle 1 liter bottle	Clear / Pale Straw	Ultraviolet	Metal, thermoset plastic	250	88	D 50	-65°F to 356°F	1,740 <sup>1</sup>		
		3108™	28400 28465	25 ml syringe 1 liter bottle	Translucent / Colorless	Ultraviolet	Thermoplastic, thermoset plastic	5,100	330	A 72	-65°F to 300°F	2,090 <sup>3</sup>		
		3175™	29505 29506	25 ml syringe 1 liter bottle	Clear / Straw	Ultraviolet	Various	4,000	14	D 70	-65°F to 300°F	370 <sup>1</sup>		
		3491™	28366 17944	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet	Glass, metal	1,100	27	D 75	-65°F to 300°F	1,450 <sup>1</sup>		
		3492™	28367 18666	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet	Glass, metal	500	5	D 79	-65°F to 300°F	1,200 <sup>1</sup>		
		3493™	28368 18751	25 ml syringe 1 liter bottle	Clear / Pale Straw	Ultraviolet	Glass, metal	5,500	260	D 75	-65°F to 300°F	1,250 <sup>1</sup>		
		3751™ LiteTak®	21362 21363	25 ml syringe 1 liter bottle	Clear / Colorless	Ultraviolet	Various	10,000	50	D 73	-65°F to 275°F	700 <sup>3</sup>		
		3761™ LiteTak®	21359 21360	25 ml syringe 1 liter bottle	Clear / Straw	Ultraviolet	Various	2,500	57	D 69	-65°F to 275°F	800 <sup>3</sup>		
		352™  	35241 35286	50 ml bottle 1 liter bottle	Clear / Light Amber	Ultraviolet, heat, activator	Glass, metal	19,500	290	D 60	-65°F to 275°F	2,400 <sup>1</sup>		
		366™ 	36631 12224	50 ml bottle 1 liter bottle	Clear / Light Amber	Ultraviolet, activator	Glass, metal	7,500	240	D 45	-65°F to 230°F	1,450 <sup>1</sup>		



Indicates worldwide availability.

<sup>1</sup> Grit Blasted Steel to Glass<sup>2</sup> Etched Aluminum<sup>3</sup> Polycarbonate to Polycarbonate<sup>4</sup> Polycarbonate to PVC

Indicates TOP CHOICE products.

Light Cure  
Adhesives

# Elastomeric Adhesives & Sealants

Elastomeric adhesives and sealants are the newest Loctite® product line. Products with “Flextec™ Technology” are based on Henkel’s proprietary polymer backbone. These products exhibit high resiliency while maintaining high tensile strength and good adhesion to many substrates – all without the use of a primer. All Loctite® elastomeric products are isocyanate and solvent-free, noncorrosive, and compatible with most paint systems.

When in contact with ambient moisture, elastomeric adhesives and sealants begin to cure into a strong thermoset polymer – ideal for bonding and sealing a multitude of substrates, as well as many applications where silicones cannot be used due to their incompatibility with paint systems.

## LOCTITE® 5512™ ADHESIVE SEALANT

High elongation and tensile strength give this product the best of both worlds. This product has good adhesion to many substrates, as well as good impact and peel resistance.

## LOCTITE® 5572™ ADHESIVE

This product exhibits the highest shear strength on a majority of substrates versus the other products in this line.

## LOCTITE® 5590™ ADHESIVE

A two-component adhesive for elastic bonding where the curing rate of one-component adhesives is too slow. The mixed adhesive is non-sag, has high tack, and fast set time. The cured product provides durable bonding to a wide variety of substrates.

## LOCTITE® 5510™ ADHESIVE / SEALANT

A multipurpose product based on Flextec™ Technology suitable for many adhesive and sealant applications. It offers a fast skin time and cures to a tack-free surface. Its outstanding adhesion and toughness make it ideal for bonding and sealing between dissimilar substrates that are subjected to joint movement or impact.



## LOCTITE® 5570™ ADHESIVE

A strong bonding adhesive based on Flextec™ Technology with elastic properties for bonding dissimilar substrates. High initial tack and fast setting make it ideal for high productivity applications.



Available in  
Clear Version




## INNOVATIVE TECHNOLOGY

Flextec™ Technology indicates the use of Henkel’s proprietary polymers to formulate outstanding handling and performance into adhesives and sealants. These non-silicone polymers are designed for primerless adhesion, speed, and durability in all elastomeric applications.





## Loctite® Elastomeric Adhesives & Sealants Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	EXTRUSION RATE** (G/MIN)	CURE METHOD	SKIN TIME (MIN)	TEMPERATURE RANGE	HARDNESS SHORE A	TENSILE STRENGTH* (psi)	ELONGATION AT BREAK (%)	SHEAR STRENGTH ON STEEL (psi)
5510™ 	1073344	300 ml cartridge	White	200	Moisture	30	-40°F to 200°F	40	250	300	250
	1073346	300 ml cartridge	Grey								
	1073347	300 ml cartridge	Black								
5512™	41380	300 ml cartridge	Black	90	Moisture	5	-40°F to 200°F	55	390	500	270
	41387	5 gallon pail									
5570™ 	1073348	300 ml cartridge	White	150	Moisture	30	-40°F to 200°F	55	380	230	400
	1073349	300 ml cartridge	Clear								
5572™	41379	300 ml cartridge	Black	90	Moisture	12	-40°F to 200°F	55	475	225	425
	41386	5 gallon pail									
5590™ 	1091896	400 ml dual cartridge	Black	N/A	Two-Component Static Mix	25	-40°F to 200°F	60	435	130	290
5590™ Part A	1091892	5 gallon pail	Black								
5590™ Part B	1091893	5 gallon pail	Black								

\* Grit blasted steel.

\*\* Evaluated at 73°F, 3.5 mm diameter, 3 bar, for 15 seconds.

 Indicates TOP CHOICE products.

## DISPENSING OPTIONS

### HIGH VISCOSITY PASTE PUMP SYSTEMS

A wide range of paste pumps are available for dispensing. The right pump for the application is critical to success. Henkel offers turnkey pump systems to meet any application. Contact Henkel Engineering Services for recommendations on a total system solution for your application.

For support, call 860-571-5325.



### Loctite® 300 ml Pneumatic Cartridge Dispenser

A manually controlled, pneumatically operated unit for dispensing Loctite® Elastomeric Adhesives & Sealants packaged in 300 ml cartridges. The operator controls the amount and rate of application using the dispense pressure, orifice size, and manual trigger.

**Item Number:** 97002

**Dimensions:** 8" H x 13.5" L x 1.5" D

**Weight:** 18 lbs. (800 g)



See our [Loctite® Equipment Sourcebook, LT-3669](#) or visit us at [www.equipment.loctite.com](http://www.equipment.loctite.com) for more details.



# Solvent - Based Adhesives

Loctite® solvent-based aerosol and liquid adhesives provide a combination of cure speed, impact resistance, strength, temperature range, and solvent and moisture resistance to meet tough on-the-job requirements.



## SOLVENT-BASED

### LOCTITE® BLACK CONTACT ADHESIVE

A professional, solvent-based adhesive with neoprene that blends in with black-colored fabrics, rubbers, weatherstripping, and other porous materials. Withstands temperature extremes and is resistant to gasoline, kerosene, and other solvents. Fast drying and waterproof. Allows repositioning of the parts after initial contact.

### LOCTITE® CONTACT ADHESIVE

A fast drying, solvent-based adhesive with neoprene that bonds rubber, insulation, weatherstripping, and other porous materials. Sets to a tack-free surface in 3 to 4 minutes, and the early strength is enough to hold most parts together. Allows repositioning of the parts after initial contact.

## SPRAY ADHESIVES

### LOCTITE® MAXIMUM STRENGTH HEADLINER ADHESIVE

A high strength, aerosol product designed for bonding foam, carpet, fabrics, plastics, rubber, etc. Loctite® Maximum Strength Headliner Adhesive is resistant to extreme seasonal temperatures, is water-resistant, and sprays on clear.

### LOCTITE® ALL-PURPOSE SPRAY ADHESIVE

Bonds lightweight, porous, and non-porous surfaces. Allows for repositionable and permanent bonds. Fast drying: won't shrink or bleed. Resists water and humidity. Contains no ozone-depleting compounds.



## Loctite® Solvent-Based Adhesives Properties Chart

PRODUCT		Item Number	Package Type & Size	TEMPERATURE RANGE	COLOR / APPEARANCE	FIXTURE / BOND TIME	FULL CURE	COMMON SURFACES ADHESIVE WILL BOND	AGENCY APPROVALS
SOLVENT-BASED	Black Contact Adhesive	30540	5 fl. oz. tube	Up to 180°F	Black Gel	Let breathe 2-3 minutes; sets up in 5 to 15 minutes.	24 hours at ambient temperature	Weatherstripping, vinyl, rubber, wood, and metal	CFIA
	Contact Adhesive	30537	5 fl. oz. tube	Up to 180°F	Yellow Gel				CFIA
SPRAY ADHESIVES	Maximum Strength Headliner Adhesive	37312	16.75 oz. net wt. aerosol	Up to 170°F	Clear Drying, Semi-translucent Foam	Let dry 15 to 20 minutes before assembly. Spray both sides for maximum strength.	24 hours at ambient temperature	Foam, carpet, fabrics, plastics, and rubber	N/A
	All-Purpose Spray Adhesive	30544	10.5 oz. net wt. aerosol	Up to 120°F					N/A

**1.800.LOCTITE (562.8483)**

**[www.loctite.com/distributor](http://www.loctite.com/distributor)**



*Visit the web  
for an all-access pass  
to distributors, safety  
& technical data sheets,  
literature, and product  
application assistance.*



### *Helpful Hints*

For faster fixturing of these solvent-based contact adhesives, apply the adhesive to both sides of the parts, and allow to breathe for one to two minutes. When the surface starts to appear dry, apply a small additional amount of adhesive to one side and assemble the sides together.

***The bond will be instant!***

# Structural Bonding – Magnet Bonding

Loctite® Structural Adhesives for magnet bonding combine the benefits of fast process speeds with tough, durable, environmentally resistant bond strengths, making them ideal for bonding ferrite, alnico and neodymium iron boron permanent magnets used in electric motors, small engines, speakers, transformers and other devices.



## FAST FIXTURE / NO-MIXING

### LOCTITE® 312™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Ultra-Fast Fixture

Single-component, medium viscosity, activator-cure acrylic. Fixtures in 30 seconds with 75% of full strength developed in 10 minutes. Ideal for bonding a variety of close-fitting parts, including metal, glass, and ceramic.

### LOCTITE® 325™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Chemical Resistant

Solvent resistant, activator-cured acrylic fixtures in minutes. Forms flexible bonds on gaps up to 0.04". Designed for severe environments and temperatures to 300°F.

### LOCTITE® 334™ STRUCTURAL ADHESIVE

#### High Temperature

Single-component, dual-cure acrylic. Forms tough, flexible bonds on gaps up to 0.02".

### LOCTITE® 392™ STRUCTURAL ADHESIVE

#### Toughened

Single-component, dual-cure acrylic. Provides fast fixture speed and tough, reliable bonds.



## FAST FIXTURE / NO-MIXING Acid-Free

### LOCTITE® 331™ STRUCTURAL ADHESIVE

#### Ultra-Fast Fixture

Single-component, toughened, activator-cure acrylic. Acid-free, non-corrosive to sensitive parts. Fixtures in 20 seconds and develops full strength in 30 minutes. Excellent high temperature resistance. Ideal for bonding close-fitting metals and magnets.



PATENT PENDING



### LOCTITE® 3060™ STRUCTURAL ADHESIVE

#### Gap Filling

Two-component, acid-free, toughened external-mix acrylic requires no static mixing or activators. Turns green when mixed. Excellent high temperature resistance. Ideal for bonding large metal parts and ferrite or rare earth magnets. Non-corrosive to sensitive parts. Excellent gap filling capability.



### LOCTITE® E-214HP™ HYSOL® EPOXY ADHESIVE

#### Oven Cure

Single-component, acid-free, heat cure epoxy. Light grey, temperature resistant, high strength, non-sag. Non-corrosive to sensitive parts.

### LOCTITE® E-220IC™ HYSOL® EPOXY ADHESIVE






#### Induction Cure

Single-component, acid-free, epoxy adhesive designed for induction cure operations. A fast curing paste formulated to reduce the risk of localized heating. Well-suited for metal and magnet bonding. Non-corrosive to sensitive parts.





## Loctite® Magnet Bonding Structural Adhesives

PRODUCT			Item Number	Package Type & Size	FEATURE	CHEMIST	COLOR	VISCOSI	GAP FILL	FIXTURE (Seconds)	CURE TIM (Hours)	SHEAR STRENGTH	IMPACT STRENGTH	TEMPER RESISTA	SUGGEST ACTUATI
FAST FIXTURE NO MIXING	ACID FREE	312™ Speedbonder™	03333 00144 31231 31243	10 ml kit² 50 ml kit³ 50 ml bottle 1 liter bottle	General Purpose Ultra-Fast Fixture	Two-Step Acrylic	Clear to Amber	1,000	0.003	30	24	>2,490	–	250°F (121°C)	Loctite® 736™ Primer NF™
		392™ 	39250 39275 39280	50 ml tube 300 ml cartridge 1 liter bottle	High Toughness	Two-Step Acrylic	Amber	6,500	0.025	60	24	2,500	–	250°F (121°C)	Loctite® 7387™ Activator
		334™	33403 33470	25 ml syringe 300 ml cartridge	Severe Environment High Temperature	Two-Step Acrylic	Yellow	80,000	0.02	90	24	2,800	5.2	350°F (177°C)	Loctite® 7387™ Activator
		325™ Speedbonder™	32530 32586	50 ml bottle 1 liter bottle	Severe Environment Chemical Resistant	Two-Step Acrylic	Clear Brown	20,000	0.04	300	24	2,200	–	300°F (149°C)	Loctite® 7075™ Activator
	ACID FREE	331™ (Patent Pending) 	 1057673 1057674* 1062124*	25 ml syringe 1 liter bottle 5 gallon pail	Room Temperature No Gap Acid Free	Two-Step Acrylic	Cream	20,000	0.04	20	24	3,100	>13	350°F (177°C)	Loctite® 7387™ Activator
		3060™ 	1087985 1087986 1087987 1087988* 1088035*	60 ml kit⁴ 1 liter, resin 1 liter, activator 10 liter, resin 10 liter, activator	Room Temperature Gap Filling Acid Free	Two-Part External Mix Acrylic	Yellow/Blue = Green	15,000	>0.05	55	24	3,800	>13	300°F (149°C)	N/A
		E-220IC™ 	1078250 1078261 1078499*	30 ml syringe 1 liter bottle 5 gallon pail	Induction Heat Cure Acid Free	One-Part Epoxy	Grey	Paste	–	N/A	0.03 (induction) 1 (oven)	5,900	>13	300°F (149°C)	N/A
		E-214HP™	29339 29340	30 ml cartridge 300 ml cartridge	Oven Heat Cure Acid Free	One-Part Epoxy	Light Grey	paste	–	N/A	2	4,820	–	300°F (149°C)	N/A

\* Made to order item

<sup>1</sup> Steel<sup>2</sup> 10 ml bottle of Loctite® 312™ Speedbonder™ and 40 g aerosol can of Loctite® 736™ Primer NF™<sup>3</sup> 50 ml bottle of Loctite® 312™ Speedbonder™ and 6 oz. aerosol can of Loctite® 736™ Primer NF™<sup>4</sup> 2 - 30 ml syringes

Indicates TOP CHOICE products.

### DISPENSING OPTIONS

#### Loctite® 50 ml Hand Pumps

are portable, precision, bottle-top applicators that thread directly onto any 50 ml Loctite® bottle. They are designed to dispense at any angle from 0.01 to 0.04 ml without leaks or product waste.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 98414



Loctite® 30 ml Manual Syringe Applicator is a handheld, manually-operated dispenser for any product packaged in a standard 30 ml syringe. This dispenser provides a convenient, cost-effective method to apply product.

For available accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 98026



# Structural Bonding – Metal Bonding

Loctite® Structural Adhesives for metal bonding have been specially formulated to provide tough, long-lasting bonds to metal surfaces, such as steel, galvanized steel, aluminum, sheet metal, and stainless steel. These adhesives are capable of reducing or replacing the need for threaded fasteners, welds, or rivets resulting in a higher quality assembly.



## GENERAL PERFORMANCE

### LOCTITE® H3151™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### *Extended Open time*

Extended open time allows for adjustment of parts. Excellent bond strength on aluminum and steel. Impact and peel resistant.

### LOCTITE® H4500™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### *Fast Fixture*

High strength structural adhesive for metals. Fixtures in 15 minutes.



### LOCTITE® H4710™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### *Corrosion Resistant*

Thixotropic, two-component, room temperature curing methacrylate adhesive designed for structural bonding of galvanized and galvanneal parts. Excellent environmental resistance. Its non-sag characteristics are well-suited for filling gaps up to 0.375". Delivers excellent peel and impact strength with no surface preparation.

### LOCTITE® H4720™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### *Corrosion Resistant*

Maintains superior strength in corrosive environments. Excellent general purpose metal bonder.

## HIGH TEMPERATURE / CHEMICAL RESISTANT Low Odor

### LOCTITE® E-20NS™ Hysol® EPOXY ADHESIVE

#### *Non-Sag*

A light tan, non-sag, high peel, high shear epoxy with a 20-minute work life.

### LOCTITE® E-60HP™ Hysol® EPOXY ADHESIVE

#### *Toughened*

A high strength epoxy with a 60-minute work life. Off-white, high peel and shear strength.

### LOCTITE® E-214HP™ Hysol® EPOXY ADHESIVE

#### *High Strength*

A one-component, heat cure epoxy. Grey, temperature resistant, paste.

### LOCTITE® 9432NA™ Hysol® EPOXY ADHESIVE

#### *High Temperature*

A grey, one-component paste, heat cure epoxy. Excellent high temperature performance, excellent chemical resistance, surface insensitive.



## HIGH TEMPERATURE / CHEMICAL RESISTANT High Toughness

### LOCTITE® 3050™ STRUCTURAL ADHESIVE

#### Paint Process Compatible

A weld-through capable, high temperature, acid resistant, two-component acrylic adhesive designed for weld / rivet reduction. Cures rapidly to form tough, durable bonds. Exhibits high resistance to phosphate and autophoretic metal treatment processes.

### LOCTITE® H8700™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Weld-Through Capable

A weld-through capable, toughened, two-component acrylic adhesive designed for weld / rivet reduction. Exhibits high resistance to paint bake temperatures.

## GALVANIZED BONDING

### LOCTITE® E-50GW™ HYSOL® EPOXY ADHESIVE

#### Galvanized Steel to Wood Bonder

A grey, two-component epoxy designed to bond galvanized steel to wooden surfaces. Extended, 50-minute work life makes for easy adjustment of larger parts.

### LOCTITE® H8600™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Medium Fixture

Excellent shear strength on steel and aluminum. Especially designed for severe environments.



### LOCTITE® H8610™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Fast Fixture

A fast curing, two-component acrylic designed for bonding galvanized steel, galvaneal, and galvalume. Excellent shear strength on steel and aluminum. Especially designed for long-term heat and humidity resistance.

## HIGH TOUGHNESS Steel Bonding

### LOCTITE® H8500™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Medium Fixture

Excellent peel strength on steel and aluminum. Contains 30 mil spacer beads to prevent excessive squeeze-out of adhesive due to over-clamping.

### LOCTITE® H8510™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Extended Fixture

Offers superior peel and impact strength on steel and aluminum. This grey, ultra-fracture toughened, two-component acrylic adhesive has an extended open time, making it ideal for the assembly and adjustment of larger parts. Contains 30 mil spacer beads to prevent excessive squeeze-out of adhesive due to over-clamping.

## HIGH TOUGHNESS Aluminum Bonding

### LOCTITE® H8000™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Medium Fixture

Exhibits excellent peel strength on multiple substrates, especially aluminum.



### LOCTITE® H8010™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Gap Control

Non-sag, two-component, room temperature curing, methacrylate adhesive, exhibits superior peel strength on multiple substrates, especially aluminum. Contains 5 mil spacer beads to prevent excessive squeeze-out of adhesive due to over-clamping.

## FLEXIBLE

### LOCTITE® U-05FL™ HYSOL® URETHANE ADHESIVE

#### High Strength

A two-part, high performance urethane adhesive for metal bonding with a 5-minute work life. Off-white, highly flexible, impact and moisture resistant, high peel, high shear.

## HEAT CURE

### LOCTITE® 3984™ HYSOL® EPOXY ADHESIVE

#### High Performance

Highly fluorescent, one-part, heat cure epoxy adhesive offering superior physical, environmental and performance properties.



## DISPENSING OPTIONS

Loctite® 50 ml Dual Cartridge Manual Applicators provide a convenient, cost-effective method to apply product with minimal waste. These applicators are compatible with 1:1, 2:1 and 10:1 mix ratio products.



98472	1:1, 2:1
1034026	10:1

For additional accessories, dispense tips and spare parts, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Loctite® 200 / 400 ml Dual Cartridge Manual and Pneumatic Applicators are ideally suited for production line applications and provide a convenient, cost-effective method to apply product with minimal waste. These applicators are available for 1:1, 2:1 and 10:1 mix ratio products.



		Item Numbers 1:1 / 2:1	Item Numbers 10:1
Manual	200 ml	983436	N/A
	400 ml	983438	985246
Pneumatic	200 ml	983437	N/A
	400 ml	983439	985249



# Loctite® Metal Bonding Structural Adhesives

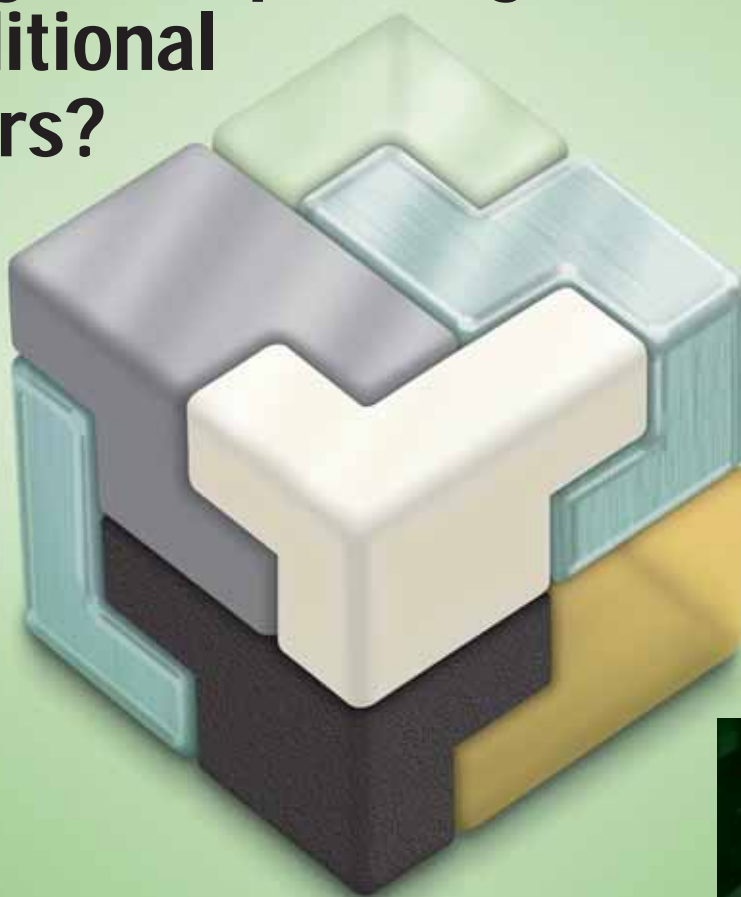
PRODUCT			Item Number	Package Type & Size	FEATURES	CHEMISTRY	COLOR	VISCOSITY (cP)	MIX RATIO	WORK LIFE (Minutes)	FIXTURE TIME (Minutes)	CURE TIME (Hours)	SHEAR STRENGTH <sup>1</sup> (psi)	IMPACT STRENGTH <sup>1</sup> (kJ/m <sup>2</sup> )	PEEL STRENGTH <sup>4</sup> (pli)	HOT STRENGTH <sup>2</sup> (psi)
GENERAL PERFORMANCE	CORROSION RESISTANT	<b>H4710™ Speedbonder™</b> 	1056941 39317	50 ml dual cartridge 490 ml dual cartridge	Medium Room Temperature Fixture	Two-Part Acrylic	Grey	70,000	10:1	11	40	48	In Testing	In Testing	In Testing	In Testing
		<b>H4720™ Speedbonder™</b>	996452 39011	50 ml dual cartridge 490 ml dual cartridge	Extended Room Temperature Fixture	Two-Part Acrylic	Teal	70,000	10:1	65	105	48	4,200	8.5	25.3	1,100
		<b>H4500™ Speedbonder™</b> 	996512 83041	50 ml dual cartridge 490 ml dual cartridge	Fast Room Temperature Fixture	Two-Part Acrylic	Pale Yellow	45,000	10:1	6	15	24	3,100	11.5	10.7	950
		<b>H3151™ Speedbonder™</b>	83015 83014	50 ml dual cartridge 400 ml dual cartridge	Extended Room Temperature Fixture	Two-Part Acrylic	Light Yellow	70,000	1:1	60	120	24	3,800	7.7	15	900
HIGH TEMPERATURE / CHEMICAL RESISTANT	LOW ODOR	<b>E-20NS™ Hysol®</b>	29334 29335 29336	50 ml cartridge 200 ml dual cartridge 400 ml dual cartridge	Low Sag	Two-Part Epoxy	Tan	60,000	2:1	20	Not Tested	24	2,790 <sup>3</sup>	Not Tested	Not Tested	Not Tested
		<b>E-60HP™ Hysol®</b>	29319 29320 29321 29322* 29323*	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Performance	Two-Part Epoxy	Off-White	47,000	2:1	60	Not Tested	24	4,320 <sup>3</sup>	Not Tested	Not Tested	430 <sup>3</sup>
		<b>E-214HP™ Hysol®</b>	29339 29340	30 ml cartridge 300 ml cartridge	Chemical Resistant High Strength	One-Part Epoxy	Grey	Paste	N/A	N/A	Not Tested	0.66 @ 218°F (120°C)	4,820 <sup>3</sup>	Not Tested	Not Tested	3,172 <sup>5</sup>
		<b>9432NA™ Hysol®</b> 	83217* 83216	2 lb. can 55 lb. pail	Chemical Resistant High Temperature	One-Part Epoxy	Grey	225,000	N/A	N/A	Not Tested	0.5 @ 218°F (120°C)	3,000	Not Tested	Not Tested	Not Tested
	HIGH TOUGHNESS	<b>3050™</b> 	1059617 1059616	50 ml dual cartridge 400 ml dual cartridge	Paint Process Compatible	Two-Part Acrylic	Yellow	75,000	2:1	6	Not Tested	24	2,900	>13	16	Not Tested
		<b>H8700™ Speedbonder™</b> 	1064166 1064321	50 ml dual cartridge 400 ml dual cartridge	Weld-Through Capable	Two-Part Acrylic	Blue	40,000	2:1	9	Not Tested	24	3,900	>21	45	Not Tested
GALVANIZED BONDING		<b>H8610™ Speedbonder™</b> 	1055263 1055839	50 ml dual cartridge 400 ml dual cartridge	Fast Room Temperature Fixture	Two-Part Acrylic	White	105,000	2:1	10	25	48	3,400	12	4.8	In Testing
		<b>H8600™ Speedbonder™</b> 	40875 38762 38760* 38761*	50 ml dual cartridge 400 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	Medium Room Temperature Fixture	Two-Part Acrylic	Blue	86,000	2:1	25	55	48	3,355	38	22.6	460
		<b>E-50GW™ Hysol®</b> 	1078249 1077864	50 ml dual cartridge 400 ml dual cartridge	Extended Room Temperature Fixture	Two-Part Epoxy	Grey	37,000	4:1	50	75	24	1,900 <sup>5</sup>	Not Tested	Not Tested	1,273 (500 hours)
HIGH TOUGHNESS	STEEL BONDING	<b>H8500™ Speedbonder™</b>	996514 40884 40888* 40889*	50 ml dual cartridge 490 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	Medium Room Temperature Fixture	Two-Part Acrylic	Grey	60,000	10:1	20	17	72	2,899	26.3	46.4	960
		<b>H8510™ Speedbonder™</b> 	996513 41330	50 ml dual cartridge 490 ml dual cartridge	Extended Room Temperature Fixture	Two-Part Acrylic	Grey	65,000	10:1	90	120	72	1,932	21.4	48.5	413
	ALUMINUM BONDING	<b>H8000™ Speedbonder™</b> 	996453 36160 35939* 35940*	50 ml dual cartridge 490 ml dual cartridge 35 lb. pail, adhesive 45 lb. pail, activator	Medium Room Temperature Fixture	Two-Part Acrylic	Green	190,000	10:1	15	20	24	3,250	17.4	40	450
		<b>H8100™ Speedbonder™</b> 	1056942 1056943	50 ml dual cartridge 490 ml dual cartridge	Fast Room Temperature Fixture	Two-Part Acrylic	Green	190,000	10:1	8	15	24	3,000	In Testing	In Testing	In Testing
		<b>H8010™ Speedbonder™</b> 	1056929 40594	50 ml dual cartridge 490 ml dual cartridge	Gap Control	Two-Part Acrylic	Grey	250,000	10:1	15	20	24	2,680	Not Tested	9 <sup>1</sup>	Not Tested
FLEXIBLE		<b>U-05FL™ Hysol®</b>	29348 29349 29350 29351 29352	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Strength	Two-Part Urethane	Off-White	100,000	1:2	5	—	24	930 <sup>3</sup>	636 <sup>7</sup>	Not Tested	Not Tested
HEAT CURE		<b>3984™ Hysol®</b> 	36768 37299*	30 ml syringe 1 liter bottle	High Performance	One-Part Epoxy	Light Grey	25,000	One Part	—	—	25 mins @ 212°F (100°C)	>2,000 <sup>5</sup>	Not Tested	Not Tested	Not Tested

\* Made to order item

<sup>1</sup> Steel<sup>2</sup> 220°F (104°C) Shear on Steel<sup>3</sup> Grit Blasted Steel<sup>4</sup> Aluminum<sup>5</sup> Etched Aluminum<sup>6</sup> Galvanized Steel<sup>7</sup> Abraded and Etched Aluminum

Indicates TOP CHOICE products.

# Are your design challenges too puzzling for traditional fasteners?

**LOCTITE®**


## Introducing a new line of advanced structural adhesives — stronger, tougher, and more reliable.



The advanced line of Loctite® Structural Adhesives has been engineered to keep pace with today's modern design requirements. With more than 20 new products, this new and improved line provides high bond strengths to a variety of materials, including metals, plastics, composites, polyolefins and magnets. So, no matter what your application, you can leave traditional fasteners where they belong – in the Stone Age.

To reduce fasteners or welds, or improve the strength and durability of your assembly, look to Loctite® Structural Adhesives to help piece it together.

THE IMMUTABLE LAWS OF  
**STRUCTURAL  
ENGAGEMENT™**

WE'RE WRITING THE LAW



Put the Laws to work for you. Contact your local Loctite® products representative at 1-800-LOCTITE. For a free sample, or to see all The Immutable Laws of Structural Engagement™, visit [www.loctite.com/structurals](http://www.loctite.com/structurals).

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# Structural Bonding – Multiple Surface Bonding

Loctite® Structural Adhesives for multiple surfaces bond a wide variety of materials, such as metal, ceramic, and plastic. They are available in a variety of formulations and performance capabilities, including fast cure, superior water / humidity resistance, ease of dispense, excellent hot strength, and a resistance to a wide range of chemicals.



## GENERAL PERFORMANCE No Mix / No Gap

### LOCTITE® 326™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Fast Fixture

An all-purpose bonder. Offers the strength of an epoxy and the speed of an instant adhesive. Solvent resistant. Cures in minutes. Ideal for applications requiring fast fixturing. Use with Loctite® 7649™ Primer N™.

### LOCTITE® 330™ DEPEND® ADHESIVE

#### General Purpose

A general purpose, high viscosity adhesive for a wide range of materials, including metal, wood, ferrite, ceramic, and plastic. Use with Loctite® 7387™ Depend® Activator.



## GENERAL PERFORMANCE Clear Bonding

### LOCTITE® 0151™ HYSOL® EPOXY ADHESIVE

#### Extended Work Life

A general purpose, thixotropic paste epoxy with a 60-minute work life. Allows for extended adjustment time.

### LOCTITE® 608™ HYSOL® EPOXY ADHESIVE

#### Non-Sag

A fast setting, low odor epoxy with a 5-minute work life. Cures at room temperature to form a clear bond line.

### LOCTITE® E-00CL™ HYSOL® EPOXY ADHESIVE

#### Flowable

A clear, flowable, fast setting epoxy with a 5-minute work life.

### LOCTITE® E-30CL™ HYSOL® EPOXY ADHESIVE

#### Chemical Resistant

An ultra-clear, low viscosity, impact resistant epoxy with a 30-minute work life. An excellent glass bonder. Exhibits exceptional chemical resistance.



## GENERAL PERFORMANCE Sandable

### LOCTITE® 615™ HYSOL® EPOXY ADHESIVE

#### Machinable

A high strength, low odor epoxy with a 10-minute work life. Blue, fast cure, gap filling.

## GENERAL PERFORMANCE Flexible

### LOCTITE® E-05CL™ HYSOL® EPOXY ADHESIVE

#### Fast Fixture

A clear, high peel, low odor epoxy with a 5-minute work life.



### LOCTITE® E-40FL™ HYSOL® EPOXY ADHESIVE

#### Toughened

A grey, impact resistant, toughened epoxy with a 40-minute work life.




### LOCTITE® E-90FL™ HYSOL® EPOXY ADHESIVE

#### Impact Resistant

A grey, impact resistant, toughened epoxy with a 90-minute work life.



# Loctite® Multiple Surface Bonding Structural Adhesives

PRODUCT			Item Number	Package Type & Size	FEATURES	CHEMISTRY	COLOR	VISCOSITY (cP)	MIX RATIO	WORK LIFE (Minutes)	FIXTURE TIME (Minutes)	CURE TIME (Hours)	SHEAR STRENGTH <sup>1</sup> (psi)	TEMPERATURE RESISTANCE
GENERAL PERFORMANCE	NO MIX / NO GAP		<b>326™ Speedbond™</b>	32629 50 ml bottle 32685 1 ml bottle	Ultra-Fast Fixture	Two-Step Acrylic	Light Amber	17,000	N/A	N/A	1	24	3,500	250°F (121°C)
			<b>330™ Depend®</b>	20253 3 ml kit <sup>4</sup> 20251 25 ml kit <sup>6</sup> 20252 250 ml kit <sup>6</sup> 33058 250 ml tube 33064 300 ml cartridge 33081 1 liter bottle	Fast Fixture	Two-Step Acrylic	Pale Yellow	67,500	N/A	N/A	5	24	3,300	250°F (121°C)
	CLEAR BONDING		<b>D609™ Hysol®</b>	83089 50 ml dual cartridge	Fast Fixture UV Resistant	Two-Part Epoxy	Clear	15,000	1:1	5	15	24	2,970	180°F (82°C)
			<b>E-00CL™ Hysol®</b>	29289 50 ml dual cartridge 29290 200 ml dual cartridge 29291 400 ml dual cartridge	Fast Fixture Flowable	Two-Part Epoxy	Clear	10,000	1:1	5	15	24	2,160	180°F (82°C)
			<b>608™ Hysol®</b>	83086 4 g foil pack 83075 50 ml dual cartridge 83082 EPK 2.8 oz. kit 83083* 5 lb. kit 83088* 45 lb. pail, resin 83087* 45 lb. pail, hardener	Fast Fixture Non-Sag	Two-Part Epoxy	Clear	100,000	1:1	5	15	24	2,980	180°F (82°C)
			<b>E-00NS™ Hysol®</b>	29294 50 ml dual cartridge 29295 200 ml dual cartridge 29296 400 ml dual cartridge	Fast Fixture Low Odor	Two-Part Epoxy	Translucent	100,000	1:1	5	15	24	3,000	180°F (82°C)
			<b>E-30CL™ Hysol®</b>	29329 50 ml dual cartridge 29330 200 ml dual cartridge 29331 400 ml dual cartridge	Medium Fixture Chemical Resistant	Two-Part Epoxy	Clear	10,000	2:1	30	Not Tested	24	3,100	350°F (177°C)
			<b>0151™ Hysol®</b>	83069 50 ml dual cartridge 83176 EPK 3.3 oz. kit 83179 2.6 lb. kit 83178 10.7 lb. kit 83181* 40 lb. pail, resin 83180* 6.8 lb. can, hardener	Extended Fixture	Two-Part Epoxy	Clear	60,000	2.7:1	60	>180	24	2,675	350°F (177°C)
	SANDABLE		<b>615™ Hysol®</b>	83094 EPK 3.2 oz kit 83095* 12 lb. kit	Fast Fixture	Two-Part Epoxy	Light Blue	200,000	1:1	10	25	24	3,825	350°F (177°C)
	POTTING		<b>U-09LV™ Hysol®</b>	38588 50 ml dual cartridge 38589 200 ml dual cartridge 38590 45 gallon pail, resin 38591 5 gallon pail, hardener	Medium Fixture Low Viscosity	Two-Part Urethane	Clear	1,000	1:1	10	Not Tested	24	1,146	Not Tested
			<b>E-60NC™ Hysol®</b>	29324 50 ml dual cartridge 29325 200 ml dual cartridge 29326 400 ml dual cartridge	Extended Fixture Non-Corrosive	Two-Part Epoxy	Black	8,000	1:1	60	Not Tested	24	2,630	250°F (121°C)
	FLEXIBLE		<b>E-05CL™ Hysol®</b>	29299 50 ml dual cartridge 29300 200 ml dual cartridge 29301 400 ml dual cartridge	Fast Fixture	Two-Part Epoxy	Clear	2,500	1:1	5	Not Tested	24	1,430	300°F (148°C)
			<b>E-40FL™ Hysol®</b>	29304 50 ml dual cartridge 29305 200 ml dual cartridge 29306 400 ml dual cartridge	Medium Fixture	Two-Part Epoxy	Opaque Grey	70,000	1:1	40	Not Tested	24	640	350°F (177°C)
			<b>E-90FL™ Hysol®</b>	29309 50 ml dual cartridge 29310 200 ml dual cartridge 29311 400 ml dual cartridge 29312* 5 gallon pail, resin 29313* 5 gallon pail, hardener	Extended Fixture	Two-Part Epoxy	Opaque Grey	40,000	1:1	90	Not Tested	24	810	350°F (177°C)

\* Made to order item

<sup>1</sup> Grit Blasted Mild Steel<sup>2</sup> Block Grit Blasted Mild Steel<sup>3</sup> Etched Aluminum<sup>4</sup> Contains 0.2 fl. oz. tube of Loctite® 330™ Depend® Adhesive and 0.7 fl. oz. ampule of Loctite® 7387™ Depend® Activator.<sup>5</sup> Contains 25 ml syringe of Loctite® 330™ Depend® Adhesive and 25 g aerosol can of Loctite® 7387™ Depend® Activator.<sup>6</sup> Contains 0.2 fl. oz. tube of Loctite® 330™ Depend® Adhesive and 0.7 fl. oz. ampule of Loctite® 7387™ Depend® Activator.

Indicates worldwide availability.



Indicates TOP CHOICE products.



## HIGH TOUGHNESS Fast Room Temperature Fixture

### LOCTITE® 324™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### High Impact

Ideal for larger gap applications. Offers the strength of an epoxy and the speed of an instant adhesive. Solvent resistant. Fixtures in minutes. Specially formulated for toughness and impact strength. Use with Loctite® 7075™ Activator.

### LOCTITE® E-05MR™ Hysol® EPOXY ADHESIVE

#### Moisture Resistant

Clear, two-component, fast room temperature curing epoxy adhesive provides excellent moisture resistance and exceptional toughness for a 5-minute epoxy. Its low odor and non-skinning properties make bulk dispensing possible.



## HIGH TOUGHNESS Medium Room Temperature Fixture

### LOCTITE® E-20HP™ Hysol® EPOXY ADHESIVE

#### High Performance

A high strength epoxy with a 20-minute work life. Off-white, toughened, high peel, high shear.



### LOCTITE® E-30UT™ Hysol® EPOXY ADHESIVE

#### Ultra-Tough

A two-component room temperature curing epoxy adhesive that contains Kevlar® to provide exceptional fracture toughness characteristics for the most demanding structural bonding requirements. 35-minute work life.

## HIGH TOUGHNESS Extended Room Temperature Fixture

### LOCTITE® 9430™ Hysol® EPOXY ADHESIVE

#### Impact Resistant

An off-white, toughened, high peel, high shear strength epoxy with a 50-minute work life.

### LOCTITE® 9460™ Hysol® EPOXY ADHESIVE

#### Non-Sag

A grey, impact resistant, high viscosity, high peel, high shear epoxy with a 50-minute work life.



### LOCTITE® 9462™ Hysol® EPOXY ADHESIVE

#### High Strength

A beige, toughened two-component room temperature cure epoxy with a 50-minute work life. Its medium viscosity, 1 to 1 mix ratio, and non-sag features make it very easy to apply. Excellent impact resistance for bonding a variety of surfaces, including metal, plastic, and wood.

### LOCTITE® E-60HP™ Hysol® EPOXY ADHESIVE

#### Flowable

A high strength epoxy with a 60-minute work life. Off-white, high peel, high shear.

## HIGH TOUGHNESS Heat Cure / One Part

### LOCTITE® 3981™ Hysol® EPOXY ADHESIVE

#### High Performance

Highly fluorescent, one-component, heat cure epoxy adhesive offers superior physical, environmental and performance properties.



### LOCTITE® 3985™ Hysol® EPOXY ADHESIVE

#### Non-Sag

A one-component, heat cure epoxy. Ideal for bonding wires to motor armatures.

## HIGH TEMPERATURE / CHEMICALLY RESISTANT Fast Room Temperature Fixture

### LOCTITE® 332™ STRUCTURAL ADHESIVE

#### No Mix

An activator-cured, no-mix adhesive that provides high temperature capability with thermal durability up to 400°F. Use with Loctite® 7387™ Depend® Activator.

## HIGH TEMPERATURE / CHEMICALLY RESISTANT Medium Room Temperature Fixture

### LOCTITE® 1C™ Hysol® EPOXY ADHESIVE

#### Gap Filling

A high viscosity adhesive with a 25-minute work life. Excellent gap filling capability and performance properties.

## HIGH TEMPERATURE / CHEMICALLY RESISTANT Extended Room Temperature Fixture

### LOCTITE® 9340™ Hysol® EPOXY ADHESIVE

#### Non-Sag

A grey, high viscosity epoxy with a 90-minute work life. Excellent high temperature and chemical resistance.

### LOCTITE® E-40HT™ Hysol® EPOXY ADHESIVE

#### High Strength

A two-component toughened adhesive that combines high peel strength at room temperature with tensile lap shear strength at elevated temperatures. An off-white paste exhibiting exceptional high temperature performance.



### LOCTITE® E-50CR™ Hysol® EPOXY ADHESIVE

#### Chemically Resistant

A flowable, two-component, extended room temperature curing epoxy with excellent chemical resistance properties. Black, 50-minute work life.









## HIGH TEMPERATURE / CHEMICALLY RESISTANT Heat Cure / One Part

### LOCTITE® 9459™ Hysol® EPOXY ADHESIVE

#### Self-leveling


A one-component, heat cure epoxy. Low viscosity, self-leveling. Light grey, excellent high temperature performance, excellent chemical resistance.

# Loctite® Multiple Surface Bonding Structural Adhesives (continued)

PRODUCT			Item Number	Package Type & Size	FEATURES	CHEMISTRY	COLOR	VISCOSITY (cP)	MIX RATIO	WORK LIFE (Minutes)	FIXTURE TIME (Minutes)	CURE TIME (Hours)	SHEAR STRENGTH <sup>1</sup> (psi)	TEMPERATURE RESISTANCE
HIGH TOUGHNESS	FAST ROOM TEMP. FIXTURE	E-05MR™ Hysol® 	1087601 1086598 1086600 1086599 1087602 1087603	25 ml dual cartridge 50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Moisture Resistant	Two-Part Epoxy	Ultra-Clear	25,000	1:1	5	15	24	3,200	250°F (121°C)
		324™ Speedbonder™ 	32430 32490	50 ml bottle 1 liter bottle	No Mix / No Gap	Two-Step Acrylic	Amber	17,000	N/A	N/A	5	24	3,600	300°F (148°C)
	MEDIUM ROOM TEMP. FIXTURE	E-30UT™ Hysol® 	1078234 1078235	50 ml dual cartridge 400 ml dual cartridge	Ultra-Tough	Two-Part Epoxy	Purple	12,200	2:1	35	180	24	5,090	Not Tested
		E-20HP™ Hysol® 	29314 29315 29316 29317 29318	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Easy Mix	Two-Part Epoxy	Off-White	30,000	2:1	20	Not Tested	24	3,270	350°F (177°C)
	EXTENDED ROOM TEMPERATURE FIXTURE	9460™ Hysol® 	83129 83128 83127* 83131 83130 83133 83134	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 lb. kit 20 lb. kit 50 lb. pail, hardener 50 lb pail, resin	Non-Sag	Two-Part Epoxy	Grey	200,000	1:1	50	>180	24	3,500 <sup>2</sup>	350°F (177°C)
		9430™ Hysol®	83114 83113	2 lb. kit 10 lb. kit	Impact Resistant	Two-Part Epoxy	Off-White	12,000	3.78:1	50	>180	24	4,230	180°F (82°C)
		E-60HP™ Hysol®	29319 29320 29321 29322* 29323*	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Performance	Two-Part Epoxy	Off-White	45,000	2:1	60	Not Tested	24	4,320	350°F (177°C)
		9462™ Hysol®	83142 83135*	50 ml dual cartridge 200 ml dual cartridge	High Strength	Two-Part Epoxy	Beige	70,000	1:1	50	>180	24	4,180	350°F (177°C)
	HEAT CURE / ONE PART	3981™ Hysol® 	36766 37297	30 ml cartridge 1 liter bottle	Flowable	One-Part Epoxy	Transparent Yellow	5,000	N/A	N/A	N/A	0.5 @ 257°F (125°C)	4,930	250°F (121°C)
		3985™ Hysol®	40870 34731*	1 liter bottle 5 gallon pail	Non-Sag	One-Part Epoxy	Black	50,000	N/A	N/A	N/A	0.5 @ 272°F (150°C)	Not Tested	Not Tested
HIGH TEMPERATURE / CHEMICAL RESISTANT	FAST ROOM TEMP. FIXTURE	332™	33201 33275 33290	25 ml syringe 300 ml cartridge 1 liter bottle	No Mix / No Gap	Two-Step Acrylic	Amber	100,000	N/A	N/A	3	24	3,000	400°F (204°C)
	MED. ROOM TEMP. FIXTURE	1C™ Hysol®	83200 83202 83201 83206* 83183*	EPK 4 oz. kit 4 lb. kit 17 lb. kit 60 lb. pail, resin 43 lb. pail, hardener	Gap Filling	Two-Part Epoxy	White	350,000	2.5:1	25	210	24	1,750 <sup>3</sup>	350°F (177°C)
	EXTENDED ROOM TEMP. FIXTURE	E-40HT™ Hysol® 	1086065 1086081	50 ml dual syringe 400 ml dual cartridge	High Strength	Two-Part Epoxy	Off-White	430,000	2:1	45	Not Tested	24	5,000 <sup>3</sup>	Not Tested
		E-50CR™ Hysol® 	1079594 1079593	50 ml dual syringe 400 ml dual cartridge	Flowable	Two-Part Epoxy	Black	5,000	1:1	50	Not Tested	24	2,500 <sup>3</sup>	Not Tested
		9340™ Hysol®	83104 83105	EPK 2.7 oz. kit 5 lb. kit	Non-Sag	Two-Part Epoxy	Grey	Paste	1:1	90	Not Tested	24	2,300 <sup>3</sup>	Not Tested
	HEAT CURE / ONE PART	9459™ Hysol®	83126	10 lb. can	Self-Leveling	One-Part Epoxy	Light Grey	40,000	N/A	N/A	N/A	1 @ 250°F (121°C)	3,000 <sup>3</sup>	Not Tested

\* Made to order item  
<sup>1</sup> Grit Blasted Mild Steel

<sup>2</sup> Block Grit Blasted Mild Steel  
<sup>3</sup> Etched Aluminum

 Indicates worldwide availability.

 Indicates TOP CHOICE products.



# Structural Bonding – Plastic/Composite Bonding

Loctite® Structural Adhesives for plastic, composite and polyolefin surfaces are capable of bonding a variety of materials, including fiberglass, gel coat, thermoplastics, polycarbonate, ABS, PVC, polyethylene, and polypropylene. They have been specially formulated to provide UV resistance, high impact resistance, and peel resistance.



## HIGH TOUGHNESS Fast Room Temperature Fixture

### LOCTITE® H4100™ SPEEDBONDER™ STRUCTURAL ADHESIVE *Ultra-Fast Fixture*

A non-sagging, two-component methacrylate adhesive ideal for bonding PVC, polycarbonate, acrylic, ABS, and FRP. Ultra-fast adhesive develops handling strength in 3 to 5 minutes. Forms resilient bonds and maintains its strength over a wide range of temperatures.

### LOCTITE® H4200™ SPEEDBONDER™ STRUCTURAL ADHESIVE *Toughened*

A plastic and composite bonder with high peel and impact resistance. Fixtures in 15 minutes.

## HIGH TOUGHNESS Medium Room Temperature Fixture

### LOCTITE® H4000™ SPEEDBONDER™ STRUCTURAL ADHESIVE *Non-Sag*

A medium fixturing structural adhesive for bonding various plastic and composite substrates, including epoxy coat and glass fiber reinforced polyester.

### LOCTITE® H4800™ SPEEDBONDER™ STRUCTURAL ADHESIVE *Toughened*

Excellent peel and impact resistance. Provides high bond strengths on composites.



### LOCTITE® H6051™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### *UV Resistance*

A white UV resistant adhesive ideal for bonding gel-coated surfaces. Excellent non-sagging properties.

## HIGH TOUGHNESS Extended Room Temperature Fixture

### LOCTITE® E-120HP™ Hysol® EPOXY ADHESIVE

#### *Ultra-Strength*

An amber, non-sag, aerospace grade epoxy with an extended open time to allow for large parts adjustment.

## HIGH TOUGHNESS Heat Cure

### LOCTITE® 3982™ Hysol® EPOXY ADHESIVE

#### *High Performance*

Highly fluorescent, one-component, heat cure epoxy adhesive offering superior physical, environmental, and performance properties.



### LOCTITE® E-119HP™ Hysol® EPOXY ADHESIVE

#### *Non-Wicking*

One-component, heat cure epoxy adhesive exhibits very low wicking during cure when exposed to elevated cure temperatures. A thixotropic, non-sag, beige paste that bonds extremely well to carbon fiber composite and aluminum materials.



## GENERAL BONDING Fast Room Temperature Fixture

### LOCTITE® H3000™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Low Viscosity

A low viscosity adhesive ideal for bonding a variety of substrates.

### LOCTITE® H3300™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Fast Fixture

A non-sag, fast fixturing structural adhesive for bonding a variety of substrates.

## GENERAL BONDING Medium Room Temperature Fixture

### LOCTITE® U-09FL™ HYSOL® URETHANE ADHESIVE

#### Flexible

A two-part, high performance urethane adhesive for plastic bonding with a 10-minute work life. Clear, impact resistant, high peel.

## GENERAL BONDING Extended Room Temperature Fixture

### LOCTITE® H3101™ SPEEDBONDER™ STRUCTURAL ADHESIVE

#### Extended Work Life

A medium viscosity adhesive ideal for bonding a variety of substrates.



## POLYOLEFIN BONDING Fast Room Temperature Fixture

### LOCTITE® 3032™ STRUCTURAL ADHESIVE

#### Fast Fixture

A fast fixturing, thixotropic acrylic adhesive. Designed to bond low energy plastic substrates. Excellent polypropylene bonder.



## POLYOLEFIN BONDING Medium Room Temperature Fixture

### LOCTITE® 3034™ STRUCTURAL ADHESIVE

#### Toughened

Extended open time allows for adjustment of parts. Excellent peel and shear strength on polyethylene plastics.



## DISPENSING OPTIONS

### Loctite® 50 ml Dual Cartridge Pneumatic Applicator

A handheld, pneumatically operated dispenser. It provides a convenient, cost-effective method for applying two-part adhesive products with minimal effort and waste. The applicator can accept various 50 ml dual cartridge designs for 1:1, 2:1 and 10:1 mix ratios.

Item Number: 97042



For more information, refer to the "Equipment" section or visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Loctite® Caulking Gun Conversion Kits for 50 ml Cartridges provide an inexpensive means of converting a household caulking gun into a handheld meter mix dispenser. Ideal for 1:1, 2:1, and 10:1 ratio two-part adhesives.

For available spare parts and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).



Item Number: 98415

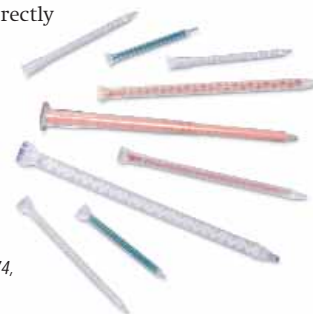


Item Number: 98466

Loctite® Mix Nozzles are plastic, disposable nozzles that attach directly to Loctite® Speedbonder™ dual cartridges. They are designed to mix adhesive automatically as it travels through the static-mix nozzle.

For available dispense tips and package sizes, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Numbers: 98473, 98454, 98463, 98474, 98459, and 98461



# Loctite® Plastic / Composite Bonding Structural Adhesives

PRODUCT			Item Number	Package Type & Size	FEATURES	CHEMISTRY	COLOR	VISCOSITY (cP)	MIX RATIO	WORK LIFE (Minutes)	FIXTURE TIME (Minutes)	CURE TIME (Hours)	SHEAR STRENGTH <sup>1</sup> (psi)	IMPACT STRENGTH <sup>1</sup> (kJ/m <sup>2</sup> )	PEEL STRENGTH <sup>4</sup> (pli)
HIGH TOUGHNESS	FAST ROOM TEMP. FIXTURE	H4100™ Speedbonder™	83032	490 ml dual cartridge	Ultra-Fast Fixture	Two-Part Acrylic	Pale Yellow	100,000	10:1	2	5	24	3,140	8	13
		H4200™ Speedbonder™	83038	490 ml dual cartridge	Impact Resistant	Two-Part Acrylic	Pale Yellow	90,000	10:1	5	15	24	4,020	>42	55
	MEDIUM ROOM TEMPERATURE FIXTURE	H4000™ Speedbonder™	83025 83031* 83028	490 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	Non-Sag	Two-Part Acrylic	Pale Yellow	130,000	10:1	8	14	24	3,500	20	45
		H6051™ Speedbonder™	83062 83063 83063	490 dual cartridge 38 lb. pail, adhesive 60 lb. pail, activator	UV Resistant	Two-Part Acrylic	White	100,000	10:1	35	50	24	2,400	Not Tested	35
		H4800™ Speedbonder™	996515 83045 83047* 83046*	50 ml dual cartridge 490 ml dual cartridge 40 lb. pail, adhesive 36 lb. pail, activator	Impact Resistant	Two-Part Acrylic	Light Yellow	50,000	10:1	25	35	24	3,930	>42	50
	EXTENDED ROOM TEMP. FIXTURE	E-120HP™ Hysol®	29353 29354 29355 29356* 29357*	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Temperature / Chemical Resistant	Two-Part Epoxy	Amber	30,000	2:1	120	180	24	4,300	Not Tested	20 to 50
		3982™ Hysol®	36767 37298	30 ml cartridge 1 liter bottle	Fluorescent	One-Part Epoxy	Off-White	8,000	N/A	N/A	N/A	0.5 @ 257°F (125°C)	5,830 <sup>3</sup>	Not Tested	Not Tested
	HEAT CURE	E-119HP™ Hysol®	1078992 1080008	30 ml cartridge 300 ml cartridge	Carbon Fiber Composite Bonder	One-Part Epoxy	Beige	Thixotropic	N/A	N/A	N/A	0.5 @ 252°F (122°C)	4,930	–	–
		H3000™ Speedbonder™	83001 83000	50 ml dual cartridge 400 ml dual cartridge	Low Viscosity	Two-Part Acrylic	Cream	45,000	1:1	5	15	24	3,830	25	45
GENERAL BONDING	FAST ROOM TEMP. FIXTURE	H3300™ Speedbonder™	83020 83019 83024* 83022*	50 ml dual cartridge 400 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	Ultra-Fast Fixture	Two-Part Acrylic	Yellow	110,000	1:1	5	6	24	3,350	20	40
		U-09FL™ Hysol®	29460 29461* 29462* 29370* 29371*	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 45 gallon pail, resin 5 gallon pail, hardener	Flexible	Two-Part Urethane	Clear	5,000	1:1	10	120	72	1,459	5 to 30	Not Tested
	MED. ROOM TEMP. FIXTURE	H3101™ Speedbonder™	83007 83006	50 ml dual cartridge 400 ml dual cartridge	Medium Viscosity	Two-Part Acrylic	Cream	75,000	1:1	20	25	24	2,510	20	35
	EXT. RM. TEMP. FIXTURE														
POLYOLEFIN BONDING	FAST RM. TEMP. FIXTURE	3032™	1051591 40760* 1057610* 1070646*	50 ml dual cartridge 490 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	Fast Fixture	Two-Part Acrylic	Off-White	14,000	10:1	3	25	72	2,275 <sup>3</sup>	6	3
	MED. ROOM TEMP. FIXTURE	3034™	1051330 960973 1057671* 1070646*	50 ml cartridge 490 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	Toughened	Two-Part Acrylic	Translucent	63,000	10:1	14	55	72	2,450 <sup>3</sup>	Not Tested	6

\* Made to order item

<sup>1</sup> Steel<sup>2</sup> Aluminum<sup>3</sup> Block Shear on High Density Polyethylene<sup>4</sup> Block Shear – Grit Blasted Steel

Indicates TOP CHOICE products.



# Structural Bonding Selector Guide

Simply determine which substrates you're bonding and find the adhesive recommendations in the table below. Refer to the previous charts for typical performance properties of the recommended adhesive. These recommendations should be used as a starting point only. It is recommended that you evaluate the selected product in your application to determine suitability.

## Loctite® Structural Adhesives Bond to a Variety of Substrates

These recommendations should only be used as a starting point. <b>TESTING is always recommended.</b> <b>IMPORTANT!</b> Read substrate specific recommendations first.							
	Galvanized	Steel, Aluminum, Stainless	Polypropylene, UHMW, HDPE, Polyethylene, Nylon, Acetal	Acrylic, Polycarbonate, Styrene, PVC, ABS	Fiberglass, Polyester or Epoxy.	Glass, Ceramic	Wood, Leather, Cardboard
Galvanized	H8600™, E-50GW™	H8600™, E-50GW™	U-05FL™	H8600™	H8600™	9460F™, H8600™, E-50GW™	E-50GW™, 9460F™, E-20HP™
Steel, Aluminum, Stainless	H8600™	E-30UT™, H8000™, H3151™, 9460F™, E-60HP™	3032™, U-05FL™	H8000™, U-05FL™	H8000™, H3151™, H3000™, 9460F™	9460F™, E-20HP™	9460F™, E-20HP™
Polypropylene, UHMW, HDPE, Polyethylene, Nylon, Acetal	U-05FL™	3032™, U-05FL™	3032™, U-05FL™	3032™, U-05FL™	3032™, U-05FL™	3032™, U-05FL™	CA or Hot Melt
Acrylic, Polycarbonate, Styrene, PVC, ABS	H8600™	H8000™, U-05FL™	3032™, U-05FL™	H8000™, H3151™, H3000™	H8000™, H3000™	H8000™	Cyanoacrylate
Fiberglass, Polyester or Epoxy	H8600™	H8000™, H3151™, H3000™, 9460F™	3032™, U-05FL™	H8000™, H3000™	H8000™, H4800™, H3000™, 9460F™, E-20HP™, E-00NS™	9460F™, E-20HP™, E-30CL™, Depend 330™	9460F™, E-20HP™
Glass, Ceramic	9460F™, H8600™, E-50GW™	9460F™, E-20HP™	U-05FL™, 3032™	H8000™	9460F™, E-20HP™, E-30CL™, Depend 330™	E-30CL™, 9460F™, Depend 330™	9460F™, E-20HP™, E-00NS™
Wood, Leather, Cardboard	E-50GW™, 9460F™, E-20HP™	9460F™, E-20HP™	CA or Hot Melt	Cyanoacrylate	9460F™, E-20HP™	9460F™, E-20HP™, E-00NS™	9460F™, E-20HP™, E-00NS™, E-50GW™

# Coatings

## PROTECTIVE COATINGS

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Protective coatings serve many functions including:

- Protection
- Sealing
- Insulating
- Corrosion protection

They can also be used to add gripping power or to color code equipment. Many of these products also offer protection from harsh chemicals like acids, salts and alkalis that are damaging to most industrial equipment.

### ***What is the difference between a treatment and a coating?***

A treatment, such as Loctite® Extend® Rust Treatment, is used to treat existing rust in an effort to correct a corrosion problem.

A coating is a product used for preventative maintenance and should be used on a clean part or a treated part. If corrosion exists on a surface, a coating will not correct the problem, and the substrate will continue to corrode underneath the protective coating. Using surface treatments and protective coatings together is the most effective solution to surface protection.

## WEAR-RESISTANT COATINGS

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### ***Asset Protection***

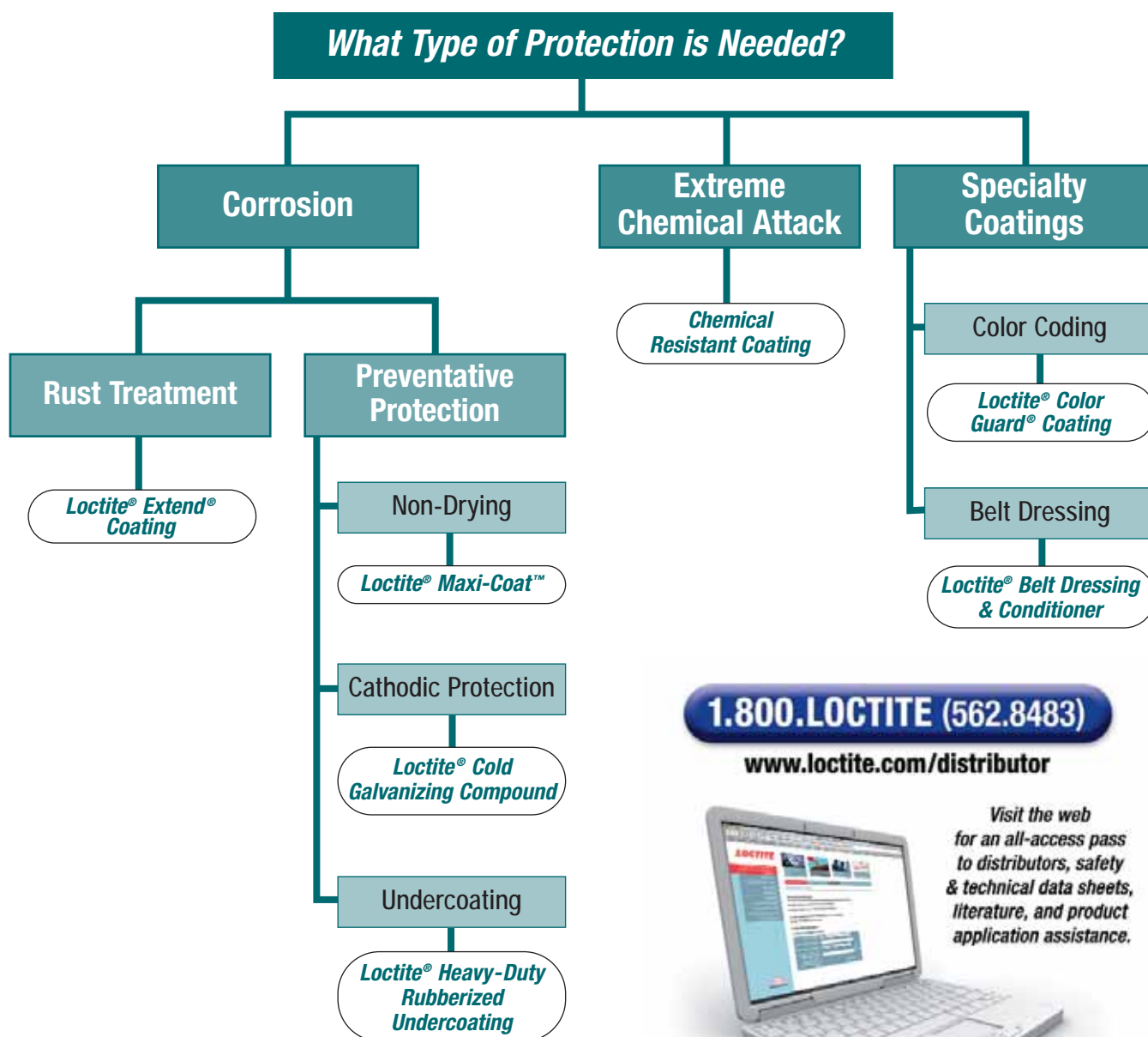
Wear and corrosion are common causes for failure in industrial equipment. Oftentimes this equipment is very expensive, and repairing and protecting these assets offers a significant cost savings. Loctite® Nordbak® wear-resistant coatings offer superior wear protection for new and worn equipment in a variety of applications. Extending service life and increasing efficiency through reduced friction are just two examples of the benefits of using protective coatings to safeguard your assets.

### ***What is the proper surface preparation for wear-resistant coatings?***

A properly prepared surface is one that has been cleaned, dried, and abraded. Substrates should be free from contamination including oils, grease, dust, etc. It is also important that a surface is dry before working with a wear-resistant coating, because moisture on the surface can interfere with the curing process. The final step is to abrade the surface, which provides an increased surface area for bonding. When working with metals, the surface should be abraded to a near white metal finish, which also helps to ensure that all surface corrosion is removed.

Loctite® Adhesives and Sealants Product Specialists are available to assist you. For application assistance, call **1-800-LOCTITE** (562-8483) or visit [www.loctite.com](http://www.loctite.com) and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

## Coatings Selector Guide



**NOTE:** Please refer to pages 38-39 for more information on these products.



# Wear-Resistant Coatings Selector Guide

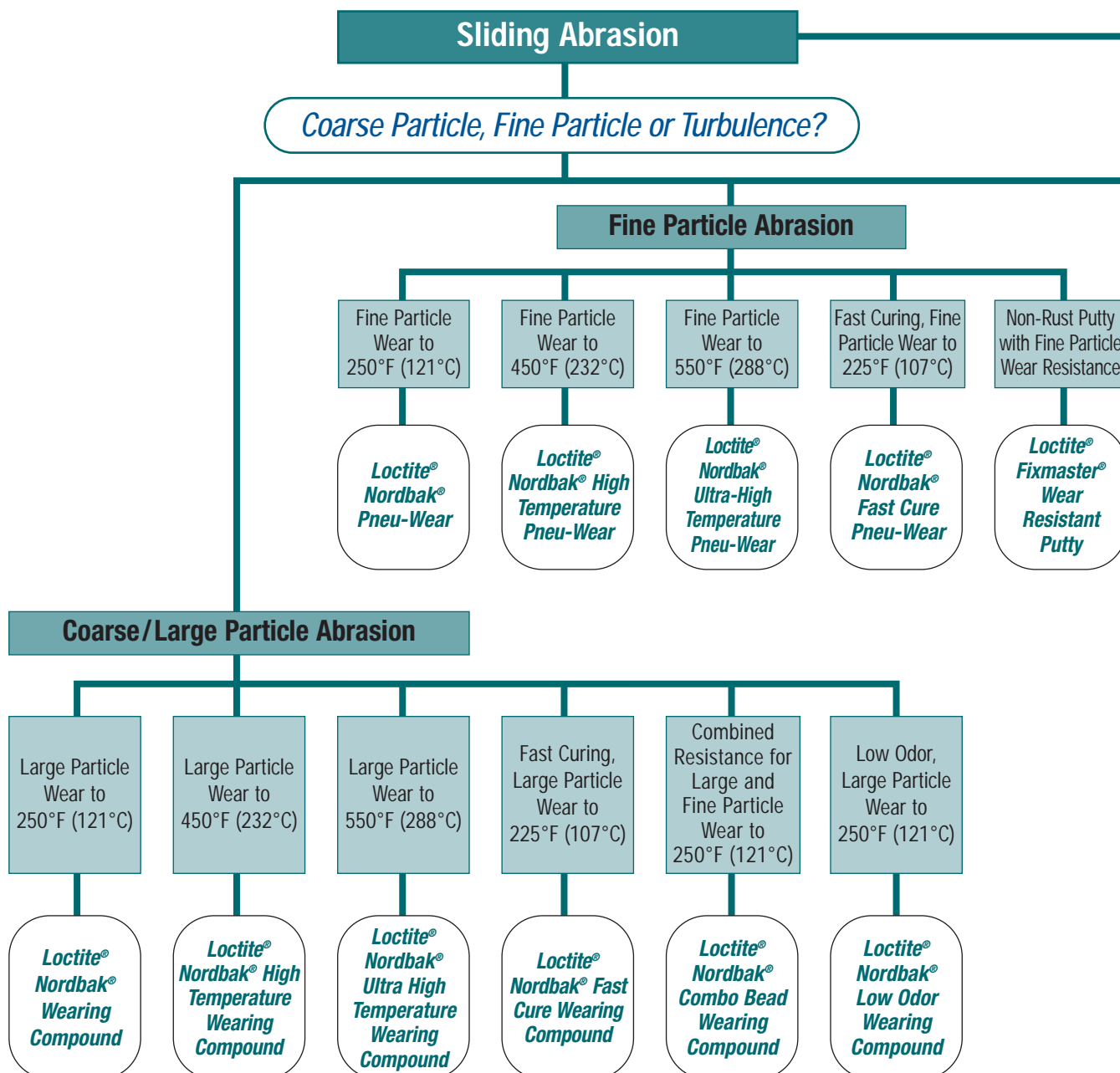
- ✓ Provide superior protection from environmental impact
- ✓ Eliminate and break corrosion/erosion cycle
- ✓ Non-shrink and non-sag formulations
- ✓ High compression strength
- ✓ Broad chemical resistance
- ✓ Broad range tailored to specific applications

## ADDITIONAL OFFERINGS

Let Henkel help you select the proper coating for your application.

Refer to Loctite® Wear Resistant Coatings Technical Catalog and Brochure by visiting [www.loctite.com](http://www.loctite.com).

Click on **Product & Service Solutions** and then select **Literature** to view the guides or request copies.



**NOTE:** Please refer to pages 40-43 for more information on these products.

*Are you experiencing mechanical wear/abrasion or corrosion/erosion?*

**Wear/Abrasion**

**Extreme Corrosion/Erosion**

*Sliding Abrasion or Impact Resistance?*

**Loctite® Nordbak®  
Chemical Resistant Coating**

**Liquid / Slurry Turbulence**

Low Friction,  
Turbulence  
Resistance to  
200°F (93°C)

Low Friction,  
Turbulence  
Resistance to  
550°F (288°C)

Thin Mil,  
Low Friction,  
Turbulence  
Resistance to  
200°F (93°C)

**Loctite®  
Nordbak®  
Brushable  
Ceramic**

**Loctite®  
Nordbak®  
High  
Temperature  
Brushable  
Ceramic**

**Loctite®  
Nordbak®  
Brushable  
Ceramic –  
Thin Mil**

**Impact**

**Specialty**

**Loctite®  
Nordbak®  
High Impact  
Wearing  
Compound**

**Loctite®  
Fixmaster®  
Flex 80™  
Putty**

**Loctite®  
Nordbak®  
Castable  
Wearing  
Compound**

**Loctite®  
Nordbak®  
Ceramic Tile  
Adhesive**

**NOTE:** Please refer to pages 40-43 for more information on these products.



# Protective Coatings

Henkel offers a variety of Loctite® coatings to protect, seal, insulate, prevent corrosion, color code and add gripping power. Many products provide excellent resistance to acids, alkalis, salt, and moisture that can damage equipment.



## LIQUID RUBBER COATINGS

### LOCTITE® COLOR GUARD® COATING

*Inhibits rust and corrosion.*

*Seals, insulates, and identifies.*

A solvent-based, modified thermoplastic liquid coating that dries to a durable, flexible, rubber-like protective coating on parts and equipment. Dip, spray or brush to apply. Great for tools, metals, electrical connections, masonry, wood, conveyors, glass, rope, and fabric. Meets ASTM E-96 moisture resistance, ASTM B-117 salt spray testing, ASTM G-53-84 accelerated 10-year weather test, and CFIA.

## ASSISTANCE PRODUCTS

### LOCTITE® COLOR GUARD® PRIMER

Promotes adhesion on metals; highly recommended for use when coating metal hand tools. Allow the primer to dry for 10 to 15 minutes before coating with Loctite® Color Guard® Coatings. Use with pressure pot or airless spray systems.

### LOCTITE® COLOR GUARD® THINNER

Thinner is required for use when spraying any of the Loctite® Color Guard® Coatings. Helps reduce any clogging and is recommended for use with pressure pot or airless spray systems. See technical data sheets on [www.loctite.com](http://www.loctite.com) for other helpful suggestions. This product can also be used to remove cured Loctite® Color Guard® Coating.

## RUST TREATMENT

### LOCTITE® EXTEND® RUST TREATMENT

Converts existing rust (rust required) into a stable base. Cured product acts as a primer ready for painting with oil- or solvent-based paint. Protects surface from corrosion. Use on metal pipes, valves, fittings, outside surfaces of storage tanks, fences, guardrails, wrought iron furniture, conveyors, construction and agricultural equipment.

## SPECIALTY COATINGS

### LOCTITE® HEAVY-DUTY RUBBERIZED UNDERCOATING

This heavy-duty undercoating seals, protects, and insulates. Rubberized for maximum durability.

### LOCTITE® MAXI-COAT™

Heavy-duty coating provides long-term protection for metal parts, equipment, and machinery. Forms a protective, waxy film that seals out moisture, air, acid, and other corrosive elements. Great for protecting parts in storage. Removable with Loctite® Electrical Contact Cleaner.

### LOCTITE® COLD GALVANIZING COMPOUND

Sprays on metal surfaces to prevent corrosion even when the surface is scratched. Ideal touch-up for welded seams. Highly resistant to salt corrosion and water. Not resistant to acid or alkaline solutions. Contains no ozone-depleting compounds.

### LOCTITE® BELT DRESSING & CONDITIONER

Recommended to prevent slipping and increase friction for all types of belts. Extends belt life. Penetrates the cord fibers of "V" belts to restore pliability and flexibility. Eliminates squeaking and glazing.

### LOCTITE® NORDBAK® CHEMICAL RESISTANT COATING

Smooth, glossy, low friction finish protects against turbulence, abrasion, and cavitation. This advanced epoxy protects equipment from extreme chemical attack and corrosion. Low viscosity epoxy can be applied by brush.



## Helpful Hints

- When coating any surface, make sure the parts are clean and dry. Try doing a small test piece first to confirm that the coating meets your expectations. This will save you time and money if desired results are not achieved.
- Loctite® Color Guard® Thinner can be used to remove cured Loctite® Color Guard® Coating.
- Loctite® Color Guard® Coating colors can be mixed to make different colors.

## Loctite® Protective Coatings Properties Chart

Properties Chart				Color / Appearance	Temperature	Dry Time	Full Cure	Coverage	Application Method	Agency Approvals
Product		Item Number	Package Type & Size							
Liquid Rubber Coatings	Color Guard® Coating	34894 34979 34980 34981*	11 oz. net wt. aerosol can 14.5 fl. oz. can 1 gallon can 54 gallon drum	Black	up to 200°F (93°C)	4 hours (allow 30 minutes between coats)	24 hours at ambient temperature	180 sq. ft. per gallon at 2.5 mils thickness	Dip, brush or spray	CFIA, ASTM E-96, ASTM B-117, ASTM G-53-84
	Color Guard® Coating	34895 34982 34983 34984*	11 oz. net wt. aerosol can 14.5 fl. oz. can 1 gallon can 54 gallon drum	Blue						
	Color Guard® Coating	34896 34985 34986 34987*	11 oz. net wt. aerosol can 14.5 fl. oz. can 1 gallon can 54 gallon drum	Red						
	Color Guard® Coating	34897 34988 34989 34991*	11 oz. net wt. aerosol can 14.5 fl. oz. can 1 gallon can 54 gallon drum	Yellow						
Assistance Products	Color Guard® Primer <i>(Promotes adhesion on metals)</i>	34994	1 gallon can	Grey	N/A	10 to 15 minutes	10 to 15 minutes before dipping or coating	150 to 200 sq. ft. per gallon at 0.5 to 1 mil thickness	Brush or spray	N/A
	Color Guard® Thinner	34995	1 gallon can	Clear Solvent	N/A	Mixed in coating	N/A	Brushing: 1 part thinner to 2 parts coating	Brush or spray	N/A
Rust Treatment	Extend® Rust Treatment	30539	10.25 oz. net wt. aerosol	Clear Liquid	up to 250°F (121°C)	Recoat in 2 to 3 minutes	24 hours at ambient temperature	200 sq. ft. per gallon at 2.5 mils thickness	Aerosol spray	ABS, CFIA
		75430	1 quart bottle	Converts from a White Liquid to Matte Black	up to 250°F (121°C)	Recoat in 20 minutes			Brush or commercial sprayer	
75448		1 gallon bottle								
75465		5 gallon pail								
Specialty Coatings	Heavy-Duty Rubberized Undercoating	30538	16 oz. net wt. aerosol	Brown to Black	up to 200°F (93°C)	20 minutes	24 hours at ambient temperature	Recommended 2 coats	Aerosol spray	N/A
	Maxi-Coat™	51211 51213	12 oz. net wt. aerosol 1 gallon can	Brown	up to 200°F (93°C)	Non-drying	Waxy coat	Apply heavy coat with brush	Brush on	CFIA
	Cold Galvanizing Compound	82039	15 oz. net wt. aerosol	Low Gloss Grey	up to 400°F constant; 600°F intermittent	15 minutes to touch	24 hours at ambient temperature	Apply heavy coat at 12 to 15 inches away	Aerosol spray	CFIA
	Belt Dressing & Conditioner	30527	12 oz. net wt. aerosol	White	up to 200°F (93°C)	Penetrates belt	Increases friction right away	Spray light coating	Aerosol spray	CFIA
	Nordbak® Chemical Resistant Coating	96092	12 lb. kit	Grey	up to 150°F (65°C) wet, > 200°F (93°C) dry	16 hours	16 hours	74 sq. ft. at 20 ml thickness	Roll or brush on	CFIA

\* Made-to-order item. May require 6 week lead time.



# Wear-Resistant Coatings

Loctite® Nordbak® wear-resistant coatings utilize the superior wear properties of ceramic and the convenience of two-part epoxies to protect equipment like pumps, chutes, and augers in harsh industrial environments. Available in trowelable and brushable formulations with special fillers for tough conditions, Loctite® Nordbak® products stand up to almost any corrosion, abrasion and wear problem you can encounter, and are ideal for all those large-scale repairs that have to last.



## COARSE / LARGE PARTICLE ABRASION

### LOCTITE® NORDBAK® WEARING COMPOUND

Large ceramic beads and fine silicon carbide in a high performance epoxy system protect against sliding abrasion to 250°F. Non-sagging. Trowelable.

### LOCTITE® NORDBAK® HIGH TEMPERATURE WEARING COMPOUND

Resists sliding abrasion and temperatures to 450°F. Must be post-cured for maximum temperature resistance and performance. Trowelable.

### LOCTITE® NORDBAK® ULTRA-HIGH TEMPERATURE WEARING COMPOUND

Resists sliding abrasion and temperatures to 550°F. Must be post-cured for maximum temperature resistance and performance. Trowelable.

### LOCTITE® NORDBAK® FAST CURE WEARING COMPOUND

A faster curing version of Loctite® Nordbak® Wearing Compound, this epoxy renews worn surfaces fast, reducing downtime to put equipment back in service in as little as three hours. Trowelable.

### LOCTITE® NORDBAK® COMBO BEAD WEARING COMPOUND

This epoxy system combines the abrasion resistance qualities of both large and small ceramic beads and silicon carbide. Protects against hard sliding abrasion and extends the life of material handling equipment. Trowelable.

### LOCTITE® NORDBAK® LOW ODOR WEARING COMPOUND

**NEW**

Loctite® Nordbak® Low Odor Wearing Compound offers the same protection against coarse / large particle abrasion as Loctite® Nordbak® Wearing Compound, while offering a low odor formulation. This coating is particularly suited for applications in areas where ventilation may be limited.

## FINE PARTICLE ABRASION

### LOCTITE® NORDBAK® PNEU-WEAR

Filled with small ceramic beads and silicon carbide for maximum protection against fine particle abrasion to 250°F. Trowelable.

### LOCTITE® NORDBAK® HIGH TEMPERATURE PNEU-WEAR

Protects against fine particle abrasion and temperatures to 450°F. Must be post-cured for maximum temperature resistance and performance. Trowelable.

### LOCTITE® NORDBAK® ULTRA-HIGH TEMPERATURE PNEU-WEAR

Protects against fine particle abrasion and temperatures to 550°F. Must be post-cured for maximum temperature resistance and performance. Trowelable.

### LOCTITE® NORDBAK® FAST CURE PNEU-WEAR

Fast cure version of standard Loctite® Nordbak® Pneu-Wear protects against fine particle abrasion to 225°F and cures in just 3 hours. Trowelable.

### LOCTITE® FIXMASTER® WEAR-RESISTANT PUTTY

Ceramic fibers give this trowelable putty excellent wear and abrasion resistance properties. Cures to a smooth, low friction surface. For surfaces exposed to wear, erosion, and cavitation.



### LIQUID/SLURRY TURBULENCE

#### LOCTITE® NORDBAK® BRUSHABLE CERAMIC AND THIN MIL BRUSHABLE CERAMIC

**NEW**

Brushes on to form a smooth, corrosion-resistant coating. Protects against turbulence, abrasion, and cavitation. Can also be used as a topcoat over Loctite® Nordbak® Wearing Compound for surface rebuilding and lasting protection. Resists temperatures up to 200°F.



#### LOCTITE® NORDBAK® HIGH TEMPERATURE BRUSHABLE CERAMIC

Provides protection against turbulence, abrasion and cavitation up to 550°F. Must be post-cured for maximum temperature resistance and performance.



### IMPACT WEAR RESISTANCE

#### LOCTITE® NORDBAK® HIGH IMPACT WEARING COMPOUND

Rubber-modified epoxy protects against sliding abrasion and impact to 250°F. Trowelable.

#### LOCTITE® FIXMASTER® FLEX 80™ PUTTY

A trowelable, two-part urethane for rebuilding and repairing rubber parts and linings, providing impact, abrasion and corrosion-resistant protection.

### SPECIALTY WEAR RESISTANCE

#### LOCTITE® NORDBAK® CASTABLE WEARING COMPOUND

For casting wear-resistant parts. Pourable ceramic compound can be cast into any shape. Resists temperatures to 225°F.

#### LOCTITE® NORDBAK® CERAMIC TILE ADHESIVE










High strength. For securing ceramic wear tiles to vertical, horizontal and overhead surfaces. Excellent shock and impact resistance. Trowelable. Resists temperatures to 200°F.



### Helpful Hints

- You may smooth out any composite repair product using IPA or acetone and a gloved hand.
- When applying two coats of Loctite® Nordbak® Brushable Ceramic, a different color can be used for each: grey and white. When the first coat begins to wear, the second color coat will show through, providing an accurate visual indicator of wear.

## Loctite® Wear-Resistant Coatings Properties Chart

PRODUCT		Item Number	Package Type & Size	COVERAGE (FT. <sup>2</sup> @ 1/4" THICKNESS)	COLOR	MAXIMUM OPERATING TEMPERATURE (°F)	COMPRESSIVE STRENGTH (PSI)	HARDNESS (SHORE D)	WORKING TIME (MINUTES) 77°F	FUNCTIONAL CURE (HOURS) 77°F	MIX RATIO BY VOLUME (R:H)	MIX RATIO BY WEIGHT (R:H)	AGENCY APPROVALS
COARSE / LARGE PARTICLE ABRASION	Nordbak® Wearing Compound	99813 99812	5 lb. kit 25 lb. kit	1.75 8.75	Grey	250	16,000	90	30	7	2:1	2:1	NEHC, NAVSEA
	Nordbak® High Temperature Wearing Compound	99112	25 lb. kit	9	Grey	450	15,000	85	30	◆	4:1	3.9:1	N/A
	Nordbak® Ultra-High Temperature Wearing Compound	96392	25 lb. kit	9	Red	550	N/A	90	30	◆	2.44:1	2.85:1	N/A
	Nordbak® Fast Cure Wearing Compound	96373	6 lb. kit	2.1	Blue	225	10,000	90	10	3	2:1	2:1	N/A
	Nordbak® Combo Bead Wearing Compound	96303	6 lb. kit	2.3	Grey	250	13,000	90	25	8	2:1	2:1	N/A
	Nordbak® Low Odor Wearing Compound 	41343	25 lb. kit	8.75	Grey	250	16,000	90	30	7	2:1	2:1	N/A
FINE PARTICLE ABRASION	Nordbak® Pneu-Wear	98383 98382	3 lb. kit 25 lb. kit	1.1 9	Grey	250	15,000	90	30	6	4:1	4:1	ABS, CFIA, NEHC, NAVSEA, Lloyd's
	Nordbak® High Temperature Pneu-Wear	98372	25 lb. kit	8.8	Grey	450	15,000	90	30	◆	4:1	4:1	N/A
	Nordbak® Ultra-High Temperature Pneu-Wear	96332	25 lb. kit	8.8	Red	550	N/A	90	30	◆	2:1	2.27:1	N/A
	Nordbak® Fast Cure Pneu-Wear	96363	6 lb. kit	2.1	Blue	225	12,000	90	10	3	2:1	2:1	CFIA
	Fixmaster® Wear Resistant Putty	98742 98743	1 lb. kit 3 lb. kit	0.37 1.11	Grey	225	11,600	89	30	◆	2:1	2:1	N/A
LIQUID / SLURRY TURBULENCE	Nordbak® Brushable Ceramic – Grey 	98733 98732	2 lb. kit 6 lb. kit	12* 36*	Grey	200	12,500	85	30	6	2.75:1	4.8:1	ABS, CFIA, NSF
	Nordbak® Brushable Ceramic – White 	96443	2 lb. kit	12*	White	200	12,500	85	15	5	2.8:1	4.5:1	CFIA
	Nordbak® Brushable Ceramic – Grey (Thin Mil)  	40592	2 lb. kit	12*	Grey	200	12,500	85	30	6	2.75:1	4.8:1	N/A
	Nordbak® Brushable Ceramic – Blue (Thin Mil)  	40591	2 lb. kit	12*	Blue	200	12,500	85	30	6	2.75:1	4.2:1	NSF
	Nordbak® Brushable Ceramic – Black (Thin Mil)  	40590	2 lb. kit	12*	Black	200	12,500	85	30	6	2.75:1	4.8:1	N/A
	Nordbak® High Temperature Brushable Ceramic	96433	2 lb. kit	12*	Red	550	16,000	90	120	◆	2.6:1	4.25:1	N/A
IMPACT WEAR RESISTANCE	Nordbak® High Impact Wearing Compound	39918	25 lb. kit	8.75	Grey	250	15,000	85	30	6	2:1	2:1	N/A
	Fixmaster® Flex 80™ Putty	97423 97422	1 lb. kit 6 lb. kit	94** 560**	Black	180	N/A	87 <sup>†</sup>	10	8	100:40	72:28	ABS
SPECIALTY WEAR RESISTANCE	Nordbak® Castable Wearing Compound	98992	25 lb. kit	277 in. <sup>3</sup>	Grey	225	18,500	90	30	6	2:1	6.8:1	N/A
	Nordbak® Ceramic Tile Adhesive	97762	20 lb. kit	12	Beige	200	14,000	88	60	12	1:1	1:1.25	N/A

Properties based on mixing 1 lb. mass at 77°F, ultimate cure.

\* 20 mil thickness.

◆ Requires heat cure. See Technical Data Sheet.










\*\* in.<sup>2</sup> at 1/4" thickness

† Shore A



Indicates TOP CHOICE products.

## Loctite® Wear-Resistant Coatings Application Chart

PRODUCT		FINE PARTICLE ABRASION	MULTIPLE PARTICLE ABRASION	IMPACT RESISTANCE	CHEMICAL CORROSION PROTECTION	HIGH TEMPERATURE RESISTANCE	FAST CURE	CORROSION PROTECTION	TILE INSTALLATION	PUMP REPAIR	ELBOWS	FAN HOUSINGS	CYCLONES	CHUTES
COARSE / LARGE PARTICLE ABRASION	Nordbak® Wearing Compound									●	●	●	●	●
	Nordbak® High Temperature Wearing Compound					●				●	●	●	●	●
	Nordbak® Ultra-High Temperature Wearing Compound					●				●	●	●	●	●
	Nordbak® Fast Cure Wearing Compound						●			●	●	●	●	●
	Nordbak® Combo Bead Wearing Compound	●	●								●	●	●	●
	Nordbak® Low Odor Wearing Compound 	●	●											
FINE PARTICLE ABRASION	Nordbak® Pneu-Wear	●	●							●	●	●	●	●
	Nordbak® High Temperature Pneu-Wear	●	●			●				●	●	●	●	●
	Nordbak® Ultra-High Temperature Pneu-Wear	●	●			●				●	●	●	●	●
	Nordbak® Fast Cure Pneu-Wear	●	●				●			●	●	●	●	●
	Fixmaster® Wear Resistant Putty									●	●	●	●	●
LIQUID / SLURRY TURBULENCE	Nordbak® Brushable Ceramic – Grey 				●			●		●				
	Nordbak® Brushable Ceramic – White 				●			●		●				
	Nordbak® Brushable Ceramic – Grey (Thin Mil)  				●			●		●				
	Nordbak® Brushable Ceramic – Blue (Thin Mil)  				●			●		●				
	Nordbak® Brushable Ceramic – Black (Thin Mil)  				●			●		●				
	Nordbak® High Temperature Brushable Ceramic				●	●		●		●				
IMPACT WEAR RESISTANCE	Nordbak® High Impact Wearing Compound			●										
	Fixmaster® Flex 80™ Putty			●										
SPECIALTY WEAR RESISTANCE	Nordbak® Castable Wearing Compound										●		●	
	Nordbak® Ceramic Tile Adhesive			●					●					

● Preferred Choice

● Good Choice



Indicates TOP CHOICE products.



# Flooring & Concrete Repair

## ANTI-SLIP COATINGS

### *Choosing an anti-slip coating*

When choosing an anti-slip coating, there are several factors to consider – the most important of which is profile size. A more aggressive profile will provide better traction and a higher coefficient of friction. A lower profile will provide a better walking surface and will be easier to clean, in addition to the anti-slip properties.

It is also important to consider the substrate that is being coated and the type of exposure the coating will endure. Information and charts on the following pages will help guide you through your selection process.

### *When do I need to use a primer?*

It is always recommended that a primer be used before applying an anti-slip coating. Primers increase adhesion to the substrate and also seal porosity when applied on concrete. The decision on which primer to use is based on the product being used and the substrate. The following chart will assist you in choosing the right primer for your application.

## FLOORING, CONCRETE REPAIR, AND GROUTING

Industrial floors require maintenance approximately every six months. Damage from day-to-day traffic, heavy load, and chemical erosion can lead to a floor that needs a lot of work. Loctite® flooring and grouting products can address all of your floor repair needs and help you maintain a safe, efficient workplace.

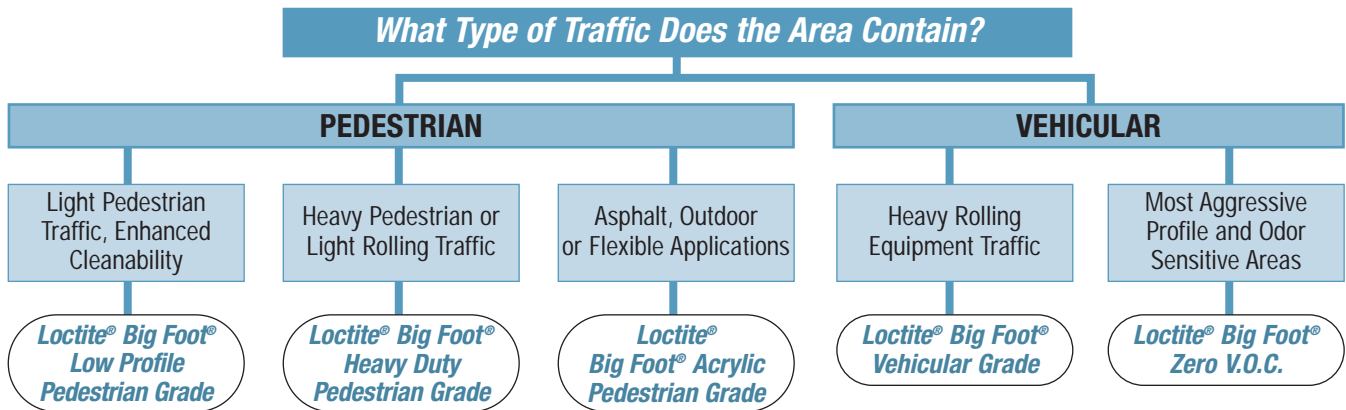
When choosing a floor or concrete repair product, the important things to consider are substrate condition, traffic and chemical exposure, and time available to complete the repair. Information and charts on the following pages will help you choose a product that will provide superior protection against the harshest environments or get your floor back in service in under an hour!

### *How important is surface preparation?*

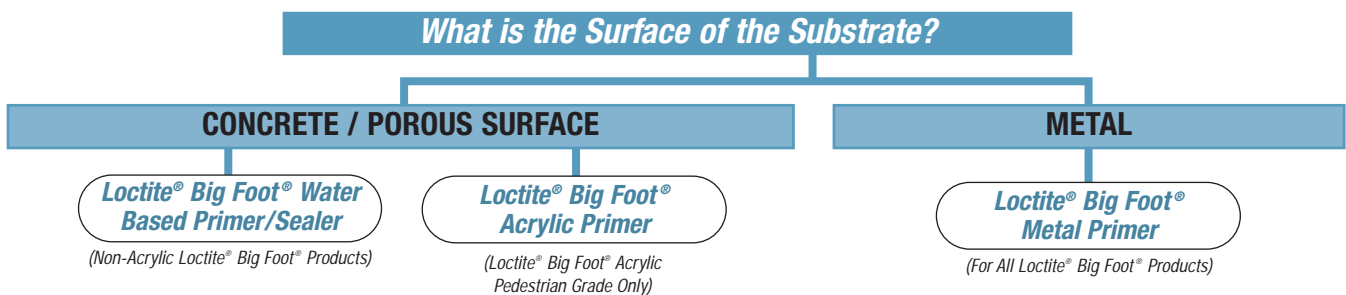
A floor repair is only as good as the concrete or substrate to which it is adhering. It is important to thoroughly check for damaged or loose concrete, because a failure of the substrate below the repair would eventually degrade the integrity of the repair itself. Surface preparation is the most important aspect of any concrete or floor repair.

Loctite® Adhesives and Sealants Product Specialists are available to assist you. For application assistance, call **1-800-LOCTITE** (562-8483) or visit [www.loctite.com](http://www.loctite.com) and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

## Anti-Slip Coatings Selector Guide

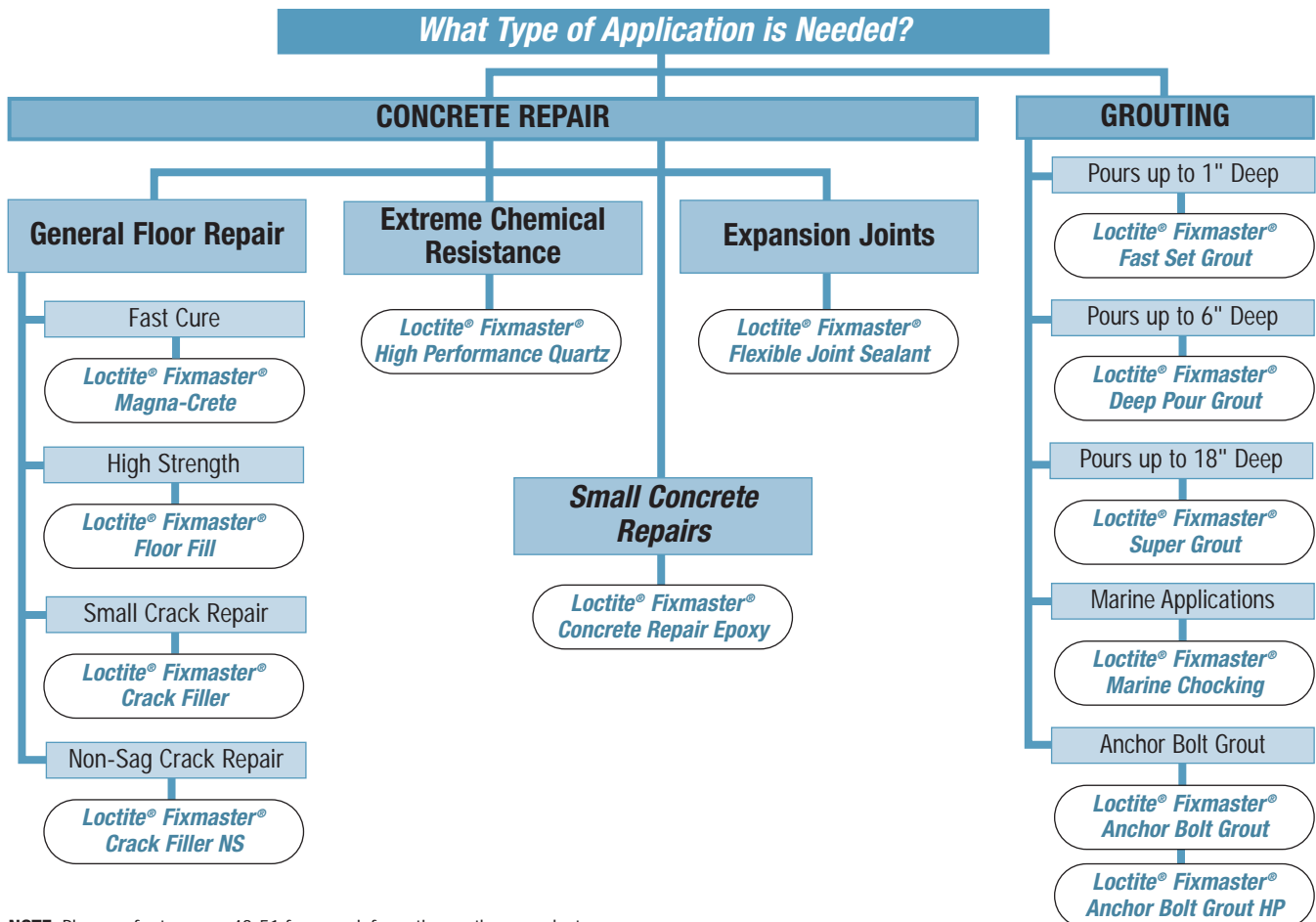


## Anti-Slip Primer Selector Guide



**NOTE:** Please refer to pages 46-47 for more information on these products.

## Flooring and Grouting Selector Guide



**NOTE:** Please refer to pages 48-51 for more information on these products.

# Anti-Slip Coatings

Loctite® Big Foot® epoxy flooring products provide tough, long-lasting anti-skid surfaces for added safety. Anti-slip coatings can be applied easily, using Loctite® phenolic or bristle rollers, to concrete, metal or wood surfaces. These products stand up to heavy traffic and harsh environments. For maximum adhesion, use Loctite® Big Foot® primers.

## ADHESIVES / COATINGS

### LOCTITE® BIG FOOT® LOW PROFILE PEDESTRIAN GRADE

**NEW**

A two-component coating that combines water-borne epoxy resins and tough, fine-grained abrasives to produce a self-sealing, non-slip floor and deck coating. Enhanced cleanability, chemical resistance and coverage are but a few of the reasons Loctite® Big Foot™ Low Profile Pedestrian Grade is the first choice for low-profile applications.

### LOCTITE® BIG FOOT® HEAVY DUTY PEDESTRIAN GRADE

**NEW**

For areas with heavy pedestrian or light rolling traffic. Ideal for ramps, walkways, locker rooms, stairs, and assembly areas.

*Now available in Safety Yellow.*

### LOCTITE® BIG FOOT® VEHICULAR GRADE

Withstands even the heaviest rolling equipment traffic. Resists liquids as harsh as jet fuels and hydraulic fluids. Superior adhesion forms a solid bond to metal, concrete, and wood.

### LOCTITE® BIG FOOT® ZERO V.O.C.

This 100% reactive, solvent-free epoxy has the most aggressive profile in the Loctite® Big Foot™ line. Use in odor-sensitive areas such as wineries, food processing plants, hospitals, or for confined spaces.

### LOCTITE® BIG FOOT® ACRYLIC PEDESTRIAN GRADE

A single-component, elastomeric, anti-slip floor and deck coating for optimum adhesion to asphalt and flexible applications. UV resistant.

## PRIMERS / SEALERS

### LOCTITE® BIG FOOT® METAL PRIMER

Two-component, epoxy-polyimide primer increases adhesion between all Loctite® Big Foot™ anti-slip coatings and metal surfaces.

### LOCTITE® BIG FOOT® ACRYLIC PRIMER

A single-component, clear, zero V.O.C., water-based primer designed for use with Loctite® Big Foot™ Acrylic Pedestrian Grade.

### LOCTITE® BIG FOOT® WATER-BASED PRIMER/SEALER

Specially formulated to increase adhesion and coverage of all Loctite® Big Foot™ anti-slip coatings except Loctite® Big Foot™ Acrylic Pedestrian Grade. For use on concrete, wood, tile, and other porous substrates.



### Helpful Hints

- Use a primer before applying any anti-slip coating to increase adhesion and seal porosity on concrete surfaces. See the selector chart at the beginning of this section for assistance in choosing the right primer for your application.



## Loctite® Big Foot® Anti-Slip Coatings Properties Chart

PRODUCT		Item Number	Package Type & Size	COLOR	COVERAGE	MIX RATIO BY WEIGHT (RESIN:HARDENER)	MIX RATIO BY VOLUME (RESIN:HARDENER)	MIXTURE TEMPERATURE (°F)	WORKING TIME (MINUTES)	FUNCTIONAL CURE (HOURS)*	AGENCY APPROVALS
ADHESIVES / COATINGS	Big Foot® Low Profile Pedestrian Grade <b>NEW</b>	40352	1 gallon kit	Safety Yellow	90 ft <sup>2</sup>	5.7:1	3.7:1	130	60	72	CFIA
	Big Foot® Heavy Duty Pedestrian Grade	96211	1 gallon can	Black	50 ft <sup>2</sup> per gallon	Single Component	Single Component	140	N/A	12/72	CFIA
		96261	1 gallon can	Grey							
		96265	5 gallon pail	Grey							
	Big Foot® Vehicular Grade <b>NEW</b>	40302	1 gallon can	Safety Yellow	40 ft <sup>2</sup> per gallon	17.6:1	8.9:1	140	120	12/72	CFIA
		40303	5 gallon pail								
		96221	1 gallon kit	Black	35 ft <sup>2</sup> per gallon	8.5:1	3.75:1	140	60	24/72	CFIA
	Big Foot® Zero V.O.C.	96251	1 gallon kit	Grey							
		96255	5 gallon kit	Grey							
	Big Foot® Acrylic Pedestrian Grade	39915	1 gallon kit	Grey	70 ft <sup>2</sup>	Single Component	Single Component	140	N/A	4/24	CFIA
		96231	1 gallon kit	Black							
PRIMERS / SEALERS	Big Foot® Metal Primer	96132	1 gallon kit	Grey	250 ft <sup>2</sup>	3.2:1	3:1	140	240	12	N/A
	Big Foot® Acrylic Primer	95581	1 gallon pail	Clear	250 ft <sup>2</sup>	Single Component	Single Component	140	N/A	1-2	N/A
	Big Foot® Water-Based Primer/Sealer	94142	1 gallon kit	Clear	320 ft <sup>2</sup>	1:1	1:1	140	120	3-6	N/A

\* Cure Time is for light pedestrian / heavy pedestrian traffic. Values are temperature and thickness specific.

NOTE: For best adhesion results, it is critical to follow surface preparation procedures outlined in the technical data sheet for the primer/sealer to be used in your application.

## Loctite® Big Foot® Anti-Slip Coatings Application Chart

PRODUCT	ASPHALT	WOOD	CONCRETE	METAL	FLEXIBLE COATING	WATER RESISTANT	WATER-BASED	CHEMICAL RESISTANT	ANTI-SLIP (PEDESTRIAN)	ANTI-SLIP (VEHICULAR)	ANTI-SLIP (ZERO V.O.C.)
Big Foot® Low Profile Pedestrian Grade		●	●	●			●	○	●		
Big Foot® Heavy Duty Pedestrian Grade		●	●	●				●	●	○	
Big Foot® Vehicular Grade		●	●	●				●	○	●	
Big Foot® Zero V.O.C.		●	●	●				●	○	○	●
Big Foot® Acrylic Pedestrian Grade	●	●	●	●	●	●			●		

● Preferred Choice

○ Good Choice

## Loctite® Big Foot® Accessories Chart

PRODUCT	Item Number	Package Type & Size	Application Use
Phenolic Rollers	96121	1 each	For use with Loctite® Big Foot® Low Profile, Heavy Duty, Vehicular and Zero V.O.C. Grades
Bristle Rollers	96153	1 each	For use with Loctite® Big Foot® Acrylic Pedestrian Grade, Acrylic Primer, Metal Primer and Water Based Primer/Sealer
Mixer Blades	96131	1 each	For use with all Loctite® Big Foot® Coatings (1 gallon kits only)





# Flooring, Concrete Repair & Grouting



## GROUTS

### LOCTITE® FIXMASTER® DEEP POUR GROUT

Aggregate-filled, epoxy system for pours up to 6" deep, including self-leveling applications under rails and sole plates. High strength material bonds to steel, concrete, and itself. Withstands high torque loading.

### LOCTITE® FIXMASTER® FAST SET GROUT

Self-leveling, non-shrinking grout for installing machinery and setting anchor bolts. Cures quickly. Can be poured up to 1" thick. Compression strength and chemical resistance are superior to concrete. Forms strong bonds to old concrete and to itself.

### LOCTITE® FIXMASTER® SUPER GROUT

Aggregate-filled epoxy system designed for grouting up to 18" deep, including self-leveling applications under rails and sole plates under typical dry service temperatures of -29°C to +107°C (-20°F to +225°F). A 100% solids epoxy system that is non-shrinking, chemical and corrosion resistant, stronger than concrete, and withstands high torque loading.

### LOCTITE® FIXMASTER® ANCHOR BOLT GROUT AND ANCHOR BOLT GROUT HP NEW

This two-part structural epoxy is solvent-free, no odor, high strength and non-sag. It is formulated to anchor threaded rod, bolts, rebar, and smooth dowels into concrete, grout-filled block, and masonry. The HP (high performance) product offers greater tension load capacity.

## FLOOR REPAIR AND RESURFACING

### LOCTITE® FIXMASTER® HIGH PERFORMANCE QUARTZ

Trowelable epoxy for repairing and protecting floors exposed to concentrated acids, alkalis, and solvents. Recommended for restoring and protecting old concrete.

### LOCTITE® FIXMASTER® FLOOR FILL

Self-leveling for repairing and resurfacing cracks in concrete floors. Bonds to old and new concrete and provides greater strength and chemical resistance properties. Typical dry service temperatures range from -26°C to +54°C (-15°F to +130°F).

### LOCTITE® FIXMASTER® MAGNA-CRETE

A two-component, rapid setting concrete repair and grouting system. Chemically resistant to most common liquids and chemicals, and can be mixed and applied at temperatures from -26°C to +54°C (-15°F to +130°F). Bonds to concrete, wood, glass, steel, and other construction materials. Ready for service in one hour. Summer and winter additives are also available to aid cure times.

### LOCTITE® FIXMASTER® CONCRETE REPAIR EPOXY NEW

Enables permanent repairs to concrete and masonry. Convenient stick contains pre-measured portions of activator and base. Once cured, it can be tapped, drilled, screwed, sawed, filed or painted, and will have an appearance and texture similar to concrete. Sets in 5 to 10 minutes.



## Helpful Hints

- When checking for damaged concrete, tap around the repair area with a hammer and listen for hollow spots. This will help to reveal damaged areas that are not apparent.
- Use Loctite® Fixmaster® Magna-Crete Summer Additive or Winter Additive with Loctite® Fixmaster® Magna-Crete to accelerate or slow the cure in high temperature or speed the cure in low temperature environments.

### FLOOR REPAIR AND RESURFACING (continued)

#### LOCTITE® FIXMASTER® FLEXIBLE JOINT SEALANT

NEW

A two-component, pourable, urethane-based sealant that is 100% solids and contains no solvents. Excellent adhesion, high chemical resistance and excellent tensile strength, flexibility, and elongation for expansion and control joints.

#### LOCTITE® FIXMASTER® CRACK FILLER

NEW

A two-component, natural in color, epoxy repair adhesive that is 100% solids and contains no solvents. It has excellent workability and flow. Fills cracks in concrete, wood, masonry, and previously coated surfaces.

#### LOCTITE® FIXMASTER® CRACK FILLER NS

NEW

Non-drip, non-sag formula will repair holes, spalls and cracks in concrete, brick, block and masonry on horizontal or vertical surfaces. This two-part, rapid curing, high strength epoxy will not soften over time and can be used indoors or outdoors.

### CHOCKING COMPOUND

#### LOCTITE® FIXMASTER® MARINE CHOCKING

NEW

Self-leveling, fast curing, non-shrinking grout. Outstanding chemical and vibration resistance and compressive strength to withstand maximum loads.

### DISPENSING OPTIONS

#### Loctite® Heavy Duty Manual Cartridge Applicators

The non-sag, high viscosity formulas of Loctite® Fixmaster® Crack Filler NS, Anchor Bolt Grout and Anchor Bolt Grout HP requires a heavy duty dispensing tool.

**Item Number:** 1093940, for use with 300 ml (8.6 oz.) cartridges.



**Item Number:** 1093981, for use with 300 ml (8.6 oz.) cartridges.



### Loctite® Fixmaster® Concrete Repair Epoxy 3-Step Process










### Loctite® Fixmaster® Floor Fill 6-Step Process





## Loctite® Fixmaster® Flooring & Grouting Properties Chart

Loctite® Fixmaster® Flooring & Grouting Properties Chart													
PRODUCT		Item Number	Package Type & Size	COLOR	COVERAGE	MIXTURE VISCOSITY (cP)	MAXIMUM TEMPERATURE (°F)	COMPRESSIVE STRENGTH (psi)	WORKING TIME	FUNCTIONAL CURE	MIX RATIO BY VOLUME (RESIN:HARDENER)	MIX RATIO BY WEIGHT (RESIN:HARDENER)	AGENCY APPROVALS
GROUTS	Fixmaster® Deep Pour Grout	99545	5 gallon kit	Black	660 in. <sup>3</sup>	Pourable	225	14,500	30 minutes	24 hours	4.1:1 to 8.2 Filler	16.4:3.6 to 80 Filler	CFIA
	Fixmaster® Fast Set Grout	39637	2 gallon kit	Red	347 in. <sup>3</sup>	5,500	200	14,500	10 minutes	12 hours	100:11.7	100:6.5	CFIA
	Fixmaster® Super Grout	33510	5 gallon kit	Red	620 in. <sup>3</sup>	Pourable	225	12,900	285 minutes	24 hours	N/A	10:5 to 85 Aggregate	N/A
FLOOR REPAIR AND RESURFACING	Fixmaster® High Performance Quartz <i>(Extreme Chemical Resistance)</i>	96495	42 lb. kit	Grey	15 ft. <sup>2</sup> *	Paste	150	12,000	Primer - 45 min. Topcoat - 1 hr.	24 hours	Primer - 100:61 Topcoat - 100:60 to 282 Filler	N/A	CFIA
	Fixmaster® Floor Fill	99361 99365	10 lb. kit 40 lb. kit	Grey	133 in. <sup>3</sup> 532 in. <sup>3</sup>	Semi-Pourable	225	15,000	40 minutes	24 hours	4.6:1 to 9.8 Filler	16:3.2 to 80.8 Filler	CFIA
	Fixmaster® Magna-Crete	95551 95555	1 gallon kit 5 gallon kit	Grey	4.8 ft. <sup>2</sup> 21.6 ft. <sup>2</sup> *	N/A	2,000	13,000	5 to 20 minutes	1 to 2 hours	N/A	N/A	CFIA
	Winter Additive	40270	1 lb. tub	White	N/A					Speeds cure by about 10 min.			
	Summer Additive	40271	1 lb. tub							Slows cure by about 10 min.			
	Fixmaster® Magna-Crete Activator	36334	10 lb. bottle	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
	Fixmaster® Concrete Repair Epoxy 	39366	4 oz. stick	Grey	N/A	Putty	250	12,000	4 to 7 minutes	1 hours	N/A	N/A	N/A
	Fixmaster® Flexible Joint Sealant 	40347	1 gallon kit	Grey	231 in. <sup>3</sup>	17,000	180	N/A	30 minutes	6 hours	1:1	N/A	N/A
	Fixmaster® Crack Filler 	40346	1 gallon kit	Off-White	231 in. <sup>3</sup>	80,000	180	N/A	30 min.	6 hours	1:1	N/A	N/A
	Fixmaster® Crack Filler NS 	1108886	8.6 oz. cartridge	Gray	15.5 in. <sup>3</sup>	N/A	N/A	N/A	20 min.	2 hours	1:1	N/A	N/A
CHOCKING COMPOUND	Fixmaster® Marine Chocking 	39136 97572	1 gallon kit 2 gallon kit	Green	167 in. <sup>3</sup> 370 in. <sup>3</sup>	15,000	250	22,000	10 minutes	24 hours	100:11.6	100:6.9	ABS, CFIA, Lloyd's
		37316 96102	1 gallon kit 2 gallon kit	Orange	167 in. <sup>3</sup> 370 in. <sup>3</sup>								ABS, CFIA, Lloyd's, NAVSEA, NEHC
ANCHOR BOLT GROUT	Fixmaster® Anchor Bolt Grout HP 	1108757 1108758	8.6 oz. single cart. 20.7 oz. dual cart.	Grey	15.5 in. <sup>3</sup> 37.36 in. <sup>3</sup>	N/A	110 115	9,880	20 minutes	4 hours	1:1	N/A	N/A
	Fixmaster® Anchor Bolt Grout 	1108885	20.7 oz. dual cart.	Grey	37.36 in. <sup>3</sup>	N/A	110	11,890	20 minutes	2 hours	1:1	N/A	N/A

\* Coverage at 1/4" thickness.





## Loctite® Fixmaster® Flooring & Grouting Application Chart

PRODUCT		ANCHOR BOLT FASTENING	CHOCKING (SHIPS)	CONCRETE FLOOR REPAIR	NON-SAG CONCRETE REPAIR	ENGINE INSTALLATION	GROUT HEAVY EQUIPMENT 1" TO 6"	GROUT HEAVY EQUIPMENT TO 18"	GROUT LIGHT EQUIPMENT 1" OR LESS	LEVELING EQUIPMENT	ACID/CHEMICAL RESISTANT FLOOR REPAIR	RAMPS AND LOADING DOCKS	HIGHWAYS AND ROADWAYS	LEVELING FLOORS
GROUTS	Fixmaster® Deep Pour Grout					●	●		●	●				
	Fixmaster® Fast Set Grout					●	●		●	●				
	Fixmaster® Super Grout					●	●	●		●				
	Fixmaster® Anchor Bolt Grout and Anchor Bolt Grout HP <b>NEW</b>	●												
FLOOR REPAIR AND RESURFACING	Fixmaster® High Performance Quartz			●							●			
	Fixmaster® Floor Fill			●		●					●			
	Fixmaster® Magna-Crete			●			●		●			●	●	●
	Fixmaster® Concrete Repair Epoxy <b>NEW</b>	●		●						●	●	●		
	Fixmaster® Flexible Joint Sealant <b>NEW</b>			●							●			
	Fixmaster® Crack Filler <b>NEW</b>			●							●			
	Fixmaster® Crack Filler NS <b>NEW</b>				●									
CHOCKING COMPOUND	Fixmaster® Marine Chocking <b>NEW</b>		●			●			●	●				

● Preferred Choice

● Good Choice

[www.concreterepair.loctite.com](http://www.concreterepair.loctite.com)
[www.flooring.loctite.com](http://www.flooring.loctite.com)




# Gasketing & Sealing

Gaskets are used to prevent fluid or gas leaks by forming impervious barriers. For successful gasketing, the seal must remain intact and leak-free over a prolonged period of time. Therefore, the gasket must resist the fluid and / or gaseous medium being sealed or excluded, and withstand the operating temperatures and pressures to which it is subjected.

## ***There are three types of flange gaskets.***

1. *Conventional pre-cut compression gaskets* are made from paper, rubber, cork, metal or other materials.
2. *Formed-in-Place (FIP) gaskets* are applied as a liquid sealant to one of the flange surfaces before the parts are assembled. After assembly, the FIP gasket spreads and cures between the flanges, filling gaps, scratches, and surface irregularities to provide a durable seal.
3. *Cured-in-Place (CIP) gaskets* are applied as liquids by tracing machines that dispense the gasket material in precise beads to one of the flanges. The material is cured by ultraviolet (UV) light to form an elastomeric material with adhesion to the flange surface. Sealing is achieved through compression of the cured gasket during flange assembly.

## ***What is the best gasket for my application?***

Many factors influence gasket choice. The following chart is intended to serve as a general guideline to help you determine which gasket type is best suited for your application. The data presented herein reflects typical properties for each gasket type; however, there may be exceptions to the data presented. Individual product information can then be found on the following pages and will help you narrow your search.

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any gasketing product.*

*Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **[www.loctite.com](http://www.loctite.com)** and select "Contact Loctite." In Canada, please call **1-800-263-5043**.*

## Gasketing & Sealing Selector Guide

GENERAL COMPARISON	GASKET TYPE				
	Conventional Gasket Dressings	Cured-In-Place Silicones	Formed-In-Place Anaerobics	Formed-In-Place Modified Silanes	Formed-In-Place Silicones
<b>BENEFITS</b>	Versatile, immediate green strength (sticky)	High gap filling, reusable / serviceable gasket, immediate fill properties	Improved structural strength, long open time, high pressure seal	High gap filling, improved strength / adhesion over silicones, paintable	High gap filling, resistant to dynamic fatigue, on-line pressure testing
<b>LIMITATIONS</b>	Non-curing, limited gap fill, % shrinkage	Requires process equipment	Limited fill	Limited temperature performance	Short open time
PERFORMANCE CONSIDERATIONS	GASKET TYPE				
	Conventional Gasket Dressings	Cured-In-Place Silicones	Formed-In-Place Anaerobics	Formed-In-Place Modified Silanes	Formed-In-Place Silicones
<b>TEMPERATURE RESISTANCE</b>					
Continuous Operation	-65°F to +400°F	-60°F to +400°F	-40°F to +300°F	-40°F to +200°F	-60°F to +400°F
Maximum	+600°F	+500°F	+400°F	+200°F	+725°F
<b>FLUID RESISTANCE</b>					
Oil	Yes	Yes	Yes	Limited	Yes
Water/Glycol	Yes	Yes	Yes	Yes	Yes
Fuel	Limited	No	Limited	Limited	No
Transmission Fluid	Yes	Yes	Yes	Limited	Yes
<b>GAP FILL</b>					
Ideal	0.001" to 0.005"	0.020" to 0.125"	0.001" to 0.005"	0.001" to 0.125"	0.001" to 0.125"
Maximum	0.010"	0.240"	0.050"	0.240"	0.240"
<b>INSTANT SEAL</b>	High Pressure	High Pressure	Low Pressure	Low Pressure	Low Pressure
<b>FLANGE TYPE</b>	Rigid or Flexible	Rigid or Flexible	Rigid	Rigid or Flexible	Rigid or Flexible
<b>SUITABLE FOR USE WITH:</b>					
Metals	Yes	Yes	Yes	Yes	Yes
Plastics *	Yes	Yes	No	Yes	Yes
PROCESS CONSIDERATIONS	GASKET TYPE				
	Conventional Gasket Dressings	Cured-In-Place Silicones	Formed-In-Place Anaerobics	Formed-In-Place Modified Silanes	Formed-In-Place Silicones
<b>NUMBER OF COMPONENTS</b>	1	1	1	1	1
<b>CURE METHOD</b>	Not Applicable	UV / RTV	Anaerobic	Moisture	RTV
<b>CURE TEMPERATURE</b>	Room Temperature	Room Temperature	Room Temperature	Room Temperature	Room Temperature
<b>CURE SPEED</b>					
Initial Cure	Immediate	15 to 30 seconds	15 to 30 minutes	15 to 30 minutes	15 to 30 minutes
Full Cure	Not Applicable	30 seconds	24 to 72 hours	1 to 7 days	1 to 7 days
<b>PROCESSING OPTIONS</b>					
Manual	Yes	No	Yes	Yes	Yes
Automated	No	Yes	Yes	Yes	Yes
<i>For more information on each adhesive category refer to pages...</i>	55-57	60-63	54, 56-57	58-59	60, 62-63

\* Uncured liquid adhesives may cause stress cracking of certain thermoplastics (e.g., polycarbonates, acrylics, and polysulfone). Special products and process techniques are available. Consult the *Loctite® Design Guide to Bonding Plastics* (LT-2197) or call 1-800-LOCTITE for more information.

# Anaerobics

Anaerobic gasketing technology has revolutionized flange sealing in the automotive industry, the assembly of heavy equipment, and the manufacture of various types of fluid power equipment. Loctite® anaerobic gasketing materials remain liquid when exposed to air, but cure when confined between mating flanges. Anaerobic gasketing products are best suited for small gap applications and rigid metal-to-metal assemblies.

## RIGID ASSEMBLY FLANGE SEALANTS

### LOCTITE® 504™ GASKET ELIMINATOR® FLANGE SEALANT

#### Gap Filling

A single-component, instant, low pressure flange sealant that fills gaps to 0.050".

### LOCTITE® 509™ GASKET ELIMINATOR® FLANGE SEALANT

#### Flexible

Product withstands minor flange movements caused by vibrations. It will not run when applied to vertical surfaces. Fluorescent blue properties allow visual inspection during assembly.

### LOCTITE® 510™ GASKET ELIMINATOR® FLANGE SEALANT

#### High Temperature

Product withstands temperatures to 400°F and has excellent solvent and chemical resistance. Fills gaps up to 0.010" (0.254 mm) and maintains clamping loads for strong, leakproof assemblies. Makes or dresses gaskets in rigid assemblies. Eliminates gasket compression set.

### LOCTITE® 515™ GASKET ELIMINATOR® FLANGE SEALANT

Makes flexible gaskets for rigid machined flanges with less than 0.050" gap. Flexes when flanges move in-service.



### LOCTITE® 518™ GASKET ELIMINATOR® FLANGE SEALANT

Forms a flexible, solvent-resistant seal that will not tear or decay. Seals to 300°F and fills gaps to 0.050". Can be used on flexible metal assemblies, including aluminum surfaces. Easy disassembly and cleaning. Ideal for on-the-spot and emergency repairs, or when a conventional gasket is out of stock.

### LOCTITE® QUICKSTIX™ 548™ GASKET ELIMINATOR® FLANGE SEALANT

NEW

Patented semisolid formula is ideal for on-the-spot repairs or when a conventional gasket is out of stock. Can be applied quickly and neatly on a variety of metal surfaces, including aluminum, and forms a flexible, solvent-resistant seal. Seals to 300°F (149°C) and fills gaps to 0.010".

## INNOVATIVE TECHNOLOGIES

New semisolid anaerobic gasketing QuickStix™ products are available!

Visit [www.quickstix.loctite.com](http://www.quickstix.loctite.com) for more details.





## SEALANTS / DRESSINGS FOR EXISTING GASKETS

### LOCTITE® QUICKSTIX™ 534™ HI-TACK GASKET DRESSING



No mess, semisolid formula offers added control and ease of use. Patented package is portable and won't leak or spill. Seals and holds the heaviest gaskets during assembly. Solvent-free and low odor. Suitable to 300°F (149°C).

### LOCTITE® GASKET SEALANT 1

Reliable, paste-like gasket sealant, dressing, and coating. Sets quickly to a hard set and is recommended for rigid, permanent assemblies. Use to 400°F. Resistant to gasoline and other solvents.

### LOCTITE® GASKET SEALANT 2

Reliable, paste-like gasket sealant, dressing, and coating. Sets slowly to a pliable film. Best suited for non-rigid, vibrating assemblies. Use to 400°F. Resistant to gasoline and other solvents.

### LOCTITE® HIGH TEMPERATURE GASKET MAKER

Slow-setting, non-hardening, high temperature sealant. Recommended for heavy-duty applications. Temperature range is -50°F to 600°F (-45°C to 315°C) intermittent. Resists common shop fluids.

### LOCTITE® HI-TACK GASKET SEALANT

Red-colored, liquid sealant that holds gaskets in place during assembly. Seals and bonds rubber, cork, paper, felt, metal, and asbestos gaskets. Sets quickly to a very tacky film. Suitable to 500°F (260°C). Contains no ozone-depleting compounds.

### LOCTITE® AVIATION GASKET SEALANT

Reliable, liquid gasket sealant, dressing, and coating. Thin brushable dressing or sealant for close-fitting parts. Use to 400°F. Resistant to gasoline and other solvents.

### LOCTITE® COPPER GASKET ADHESIVE

Fast drying, metallic, copper sealant helps dissipate heat, prevent gasket burnout, and improve heat transfer. Fills hot spots and surface imperfections. Temperature range is -50°F to 500°F (-45°C to 260°C). Resists shop fluids.

## DISPENSING OPTIONS

Loctite® Pump-A-Bead™ II is an all-pneumatic dispense system for pumping Loctite® anaerobic gasketing materials from 850 ml cartridges.

A pneumatically driven, reciprocating positive displacement piston pump provides for consistent dispensing and ensures that air is not introduced into the product. This system is well-suited for stationary or bead dispensing.

For available spare parts, valves and accessories, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 986000

Dimensions: 16.2" H x 36" W x 10" D



### Loctite® 300 ml Pneumatic Cartridge Dispenser

is a manually controlled, pneumatically operated unit for dispensing Loctite® Elastomeric Adhesives & Sealants packaged in 300 ml cartridges. The operator controls the amount and rate of application using the dispense pressure, orifice size, and manual trigger. For available valves, spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 97002







Dimensions: 8" H x 13.5" L x 1.5" D

Weight: 18 lbs. (800 g)







## Loctite® Rigid Assembly Gasketing Products Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	TYPICAL USE	GAP FILL	CURED STATE	VISCOSITY (cP)	TEMPERATURE RANGE	CURE SPEED	RECOMMENDED PRIMER	SPECIFIC GRAVITY	AGENCY APPROVALS
<b>504™ Gasket Eliminator®</b>	50441 50480	250 ml tube 300 ml cartridge	Orange	Gap filling	Unprimed – 0.030" Primed – 0.050"	Rigid	500,000 / 1,200,000 Thixotropic	-65°F to 300°F	Unprimed – 4 to 24 hrs. Primed – 30 min. to 4 hrs.	N™ or T™	1.08	N/A
<b>509™ Gasket Eliminator®</b>	21525 50965	300 ml cartridge 850 ml cartridge	Blue	Very flexible	Unprimed – 0.010" Primed – 0.020"	Flexible	65,000 / 200,000 Thixotropic	-65°F to 300°F	Unprimed – 6 to 48 hrs. Primed – 1 to 6 hrs.	N™	1.12	N/A
<b>510™ Gasket Eliminator®</b> 	51031 51041 51074	50 ml tube 250 ml tube 300 ml cartridge	Red	High temperature applications, excellent solvent resistance	Unprimed – 0.010" Primed – 0.020"	Rigid	188,000 / 500,000 Thixotropic	-65°F to 400°F	Unprimed – 4 to 24 hrs. Primed – 30 min. to 4 hrs.	N™	1.16	UL Classified for U.S.
<b>515™ Gasket Eliminator®</b> 	<b>51517</b> <b>51531</b> <b>51580</b>	<b>6 ml tube</b> <b>50 ml tube</b> <b>300 ml cartridge</b>	Purple	For flexible applications	Unprimed – 0.010" Primed – 0.050"	Flexible	<b>275,000 / 950,000</b> Thixotropic	<b>-65°F to 300°F</b>	<b>Unprimed – 1 to 12 hrs.</b> <b>Primed – 15 min. to 2 hrs.</b>	<b>N™</b>	<b>1.10</b>	<b>UL Classified for U.S.</b>
<b>518™ Gasket Eliminator®</b> 	22423 22424 51817 51831 51845	Kit Kit 6 ml tube 50 ml tube 300 ml cartridge	Red	For all metals, including aluminum flanges	Unprimed – 0.010" Primed – 0.050"	Flexible	800,000 / 3,750,000 Thixotropic	-65°F to 300°F	Unprimed – 4 to 24 hrs. Primed – 30 min. to 4 hrs.	N™	1.13	NSF/ANSI 61, CFIA
<b>QuickStix™ 548™ Gasket Eliminator®</b> 	39151 39152 39153	9 g stick 18 g stick 37 g stick	Orange	Vertical applications, cast metal housings	0.010"	Rigid	Semi-solid	-65°F to 300°F	Less than 3 hours with or without primer	N™	1.13	CFIA
<b>549™</b>	54941	250 ml tube	Orange	Instant seal plastic gasket	Unprimed – 0.020" Primed – 0.050"	Rigid	22,500	-65°F to 300°F	Unprimed – 6 to 24 hrs. Primed – 2 to 24 hrs.	N™ or T™	1.25	N/A
<b>568™</b>	56841	250 ml tube	Orange	Plastic gasket	Unprimed – 0.015" Primed – 0.050"	Rigid	6,500	-65°F to 300°F	Unprimed – 12 to 24 hrs. Primed – 2 hrs. to 24 hrs.	N™ or T™	1.12	N/A
<b>573™</b> 	26392	250 ml tube	Green	Slow curing for extended assembly operations	Unprimed – 0.010" Primed – 0.020"	Semi-Rigid	19,000 / 60,000 Thixotropic	-65°F to 300°F	Unprimed – 6 to 48 hrs. Primed – 1 to 6 hrs.	N™	1.25	N/A
<b>574™</b> 	24018 26338	50 ml tube 250 ml tube	Orange	Fast curing, large gaps	Unprimed – 0.010" Primed – 0.020"	Semi-Rigid	30,000 / 100,000 Thixotropic	-65°F to 300°F	Unprimed – 1 to 12 hrs. Primed – 15 min. to 2 hrs.	N™	1.11	N/A
<b>5127™</b>	17430	300 ml cartridge	Blue	For flexible applications, high elongation	Unprimed – 0.010" Primed – 0.010"	Flexible	100,000 / 500,000 Thixotropic	-65°F to 300°F	Unprimed – 4 to 24 hrs. Primed – 1 to 24 hrs.	N™	1.10	N/A
<b>5182™</b>	18010	850 ml cartridge	Red	Robotic application on flanges, seals, covers	Unprimed – 0.010" Primed – 0.020"	Flexible	140,000 / 580,000 Thixotropic	-65°F to 300°F	Unprimed – 4 to 24 hrs. Primed – 30 min. to 24 hrs.	N™	1.10	N/A




## Loctite® Sealing / Dressings for Existing Gaskets Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	TYPICAL USE	CONSISTENCY	VISCOSITY	TEMPERATURE RANGE	CURE SPEED	OIL RESISTANCE	NONCORROSIVE	AGENCY APPROVALS
<b>QuickStix™ 534™ Hi-Tack Gasket Sealant</b> 	39155 39156 39157	9 g stick 19 g stick 38 g stick	Purple	Vertical, repositionable	Semi-Solid	N/A	-65°F to 300°F	5 minutes to set	Oil resistant	✓	N/A
<b>Gasket Sealant 1</b>	30510 30511 30512	1.5 oz. tube 3 oz. tube 7 fl. oz. tube	Reddish Brown	Fast dry, rigid cure	Paste	75,000 / 110,000 cP	-65°F to 400°F	Full strength – 24 hours	Oil resistant	✓	CFIA
<b>Gasket Sealant 2</b>	30513 30514 30515 80964	1.5 oz. tube 3 oz. tube 7 fl. oz. tube 5 gallon can	Black	Slow drying, flexible cure	Paste	75,000 / 110,000 cP	-65°F to 400°F	Remains tacky	Oil resistant	✓	N/A
<b>High Temperature Gasket Maker</b>	30558	7 fl. oz. tube	Black	High temperature	Paste	75,000 / 110,000 cP	-50°F to 600°F	3 to 5 hours to set	Oil resistant	✓	CFIA
<b>Hi-Tack Gasket Sealant</b>	30524 30525 30526	0.25 pt. brush can 1 pt. brush can 9 oz. net wt. aerosol	Red	Improved heat transfer, repositionable	Liquid	420 / 650 cP	-65°F to 500°F (aerosol to 600°F)	5 minutes to set	Increased oil resistance	✓	N/A
<b>Aviation Gasket Sealant</b>	30517 30516	0.25 pt. brush can 1 pt. brush can	Dark Reddish Brown	Close tolerance, slow cure	Liquid	85 / 140 cP	-65°F to 400°F	Full strength – 12 hours	Oil resistant	✓	CFIA
<b>Copper Gasket Adhesive</b>	30535	9 oz. net wt. aerosol	Copper	Improved heat transfer, fills surface imperfections	Aerosol	N/A	-50°F to 500°F	Remains tacky	Oil resistant	✓	N/A

 Indicates worldwide availability.

 Indicates TOP CHOICE products.

## Loctite® Gasketing & Sealing Anaerobics Attribute and Application Chart

PRODUCT		MAIN ATTRIBUTES	APPLICATIONS
RIGID ASSEMBLY FLANGE SEALANTS	504™ Gasket Eliminator® Flange Sealant	Rigid, low viscosity, self-shimming, 0.030" gap fill without primer	Rigid flange applications
	509™ Gasket Eliminator® Flange Sealant	Flexible at temperatures up to 300°F, fluorescent, blue	Gearbox, engine casings
	510™ Gasket Eliminator® Flange Sealant	Resists low on-line test pressures, uncured	General gasketing
	515™ Gasket Eliminator® Flange Sealant 	<b>Flexes with flanges that move in service</b>	<b>General gasketing</b>
	518™ Gasket Eliminator® Flange Sealant	Resists low on-line test pressures, uncured	Gearbox, engine casting
	QuickStix™ 548™ Gasket Eliminator® 	Vertical applications, uses less product	Transmissions, cast metal housings
SEALANT / DRESSING FOR EXISTING GASKETS	QuickStix™ 534™ Hi-Tack Gasket Sealant 	Vertical applications, uses less product, repositionable	Holds gaskets in place (rubber, cork, paper, felt and metal)
	Gasket Sealant 1	Extended gasket life, fast drying, rigid cure	Threaded connections, air ducts, plumbing connections
	Gasket Sealant 2	Extended gasket life, slow drying, flexible cure	Valve cover and oil pan gaskets, threaded connections
	High Temperature Gasket Maker	Reliability at high temperatures, seals up to 5,000 psi	Aircraft heating systems, steam lines
	Hi-Tack Gasket Sealant	Prevents seizing, corrects gasket alignment, easy disassembly	Weatherstripping, waterproofing electrical connections
	Aviation Gasket Sealant	Close tolerance flanges, slow drying, flexible cure	Aviation and marine engines, threaded connections
	Copper Gasket Adhesive	Improved heat transfer, fills surface imperfections, repositionable	Cylinder head, exhaust manifolds, turbo charger flanges, carburetor gaskets

 Indicates TOP CHOICE products.



**www.loctite.com**

*Visit the web for an  
all-access pass to distributors,  
safety & technical data sheets,  
literature, and product application assistance.*

# Elastomeric Adhesives & Sealants

Elastomeric adhesives and sealants are the newest Loctite® product line. Products with “Flextec™ Technology” are based on Henkel’s proprietary polymer backbone. These products exhibit high resiliency while maintaining high tensile strength and good adhesion to many substrates – all without the use of a primer. All Loctite® elastomeric products are isocyanate and solvent-free, noncorrosive, and compatible with most paint systems.



When in contact with ambient moisture, elastomeric adhesives and sealants begin to cure into a strong thermoset polymer – ideal for bonding and sealing a multitude of substrates, as well as many applications where silicones cannot be used due to their incompatibility with paint systems.

## LOCTITE® 5512™ ADHESIVE SEALANT

High elongation and tensile strength give this product the best of both worlds. This product has good adhesion to many substrates, as well as good impact and peel resistance.

## LOCTITE® 5572™ ADHESIVE

This product exhibits the highest shear strength on a majority of substrates versus the other products in this line.

## LOCTITE® 5590™ ADHESIVE

A two-component adhesive for elastic bonding where the curing rate of one-component adhesives is too slow. The mixed adhesive is non-sag, has high tack, and fast set time. The cured product provides durable bonding to a wide variety of substrates.

## LOCTITE® 5510™ ADHESIVE / SEALANT

A multipurpose product based on Flextec™ Technology suitable for many adhesive and sealant applications. It offers a fast skin time and cures to a tack-free surface. Its outstanding adhesion and toughness make it ideal for bonding and sealing between dissimilar substrates that are subjected to joint movement or impact.



## LOCTITE® 5570™ ADHESIVE

A strong bonding adhesive based on Flextec™ Technology with elastic properties for bonding dissimilar substrates. High initial tack and fast setting make it ideal for high productivity applications.



Available in  
Clear Version




## INNOVATIVE TECHNOLOGY

Flextec Technology™ indicates the use of Henkel’s proprietary polymers to formulate outstanding handling and performance into adhesives and sealants. These non-silicone polymers are designed for primerless adhesion, speed, and durability in all elastomeric applications.





## Loctite® Elastomeric Adhesives & Sealants Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	EXTRUSION RATE** (G/MIN)	CURE METHOD	SKIN TIME (MIN)	TEMPERATURE RANGE	HARDNESS SHORE A	TENSILE STRENGTH* (psi)	ELONGATION AT BREAK (%)	SHEAR STRENGTH ON STEEL (psi)
5510™ 	1073344	300 ml cartridge	White	200	Moisture	30	-40°F to 200°F	40	250	300	250
	1073346	300 ml cartridge	Grey								
	1073347	300 ml cartridge	Black								
5512™	41380	300 ml cartridge	Black	90	Moisture	5	-40°F to 200°F	55	390	500	270
	41387	5 gallon pail									
5570™ 	1073348	300 ml cartridge	White	150	Moisture	30	-40°F to 200°F	55	380	230	400
	1073349	300 ml cartridge									
5572™	41379	300 ml cartridge	Black	90	Moisture	12	-40°F to 200°F	55	475	225	425
	41386	5 gallon pail									
5590™ 	1091896	400 ml dual cartridge	Black	N/A	Two-Component Static Mix	25	-40°F to 200°F	60	435	130	290
5590™ Part A	1091892	5 gallon pail	Black								
5590™ Part B	1091893	5 gallon pail	Black								

\* Grit blasted steel.

\*\* Evaluated at 73°F, 3.5 mm diameter, 3 bar, for 15 seconds.

 Indicates TOP CHOICE products.

## DISPENSING OPTIONS

### HIGH VISCOSITY PASTE PUMP SYSTEMS

A wide range of paste pumps are available for dispensing. The right pump for the application is critical to success. Henkel offers turnkey pump systems to meet any application. Contact Henkel Engineering Services for recommendations on a total system solution for your application.

For support, call 860-571-5325.



### Loctite® 300 ml Pneumatic Cartridge Dispenser

A manually controlled, pneumatically operated unit for dispensing Loctite® Elastomeric Adhesives & Sealants packaged in 300 ml cartridges. The operator controls the amount and rate of application using the dispense pressure, orifice size, and manual trigger. For available valves, spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).



**Item Number:** 97002

**Dimensions:** 8" H x 13.5" L x 1.5" D

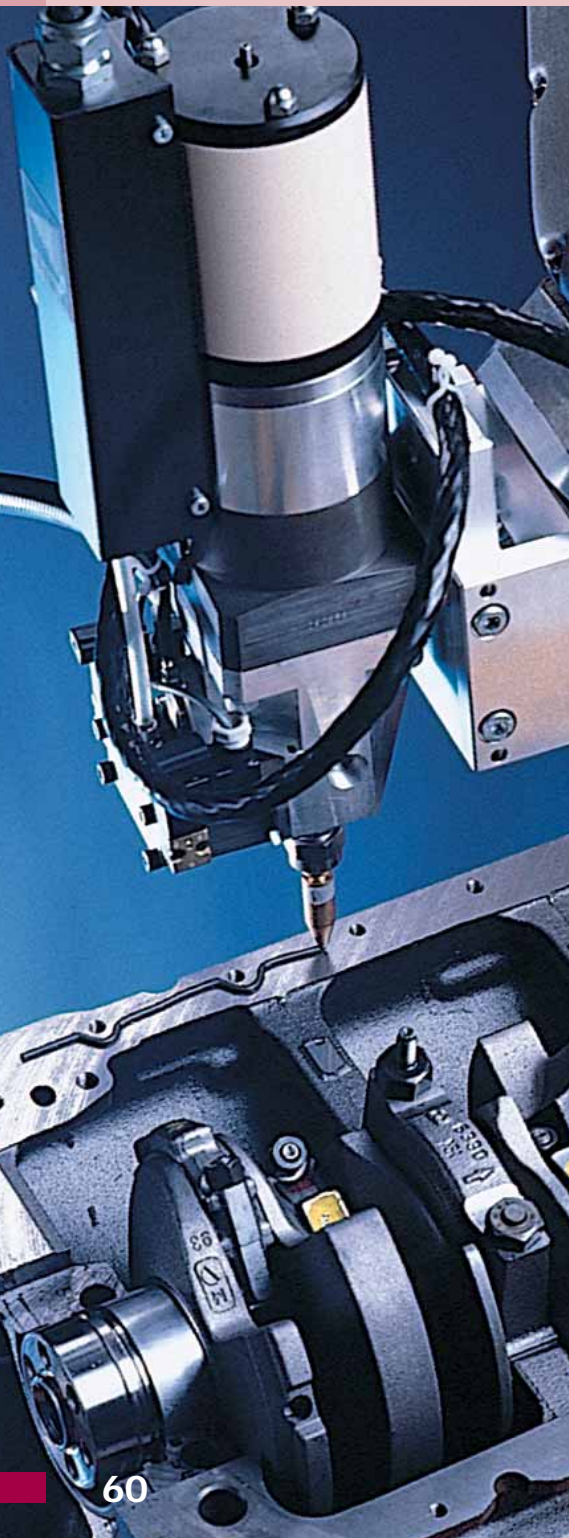
**Weight:** 18 lbs. (800 g)

See our [Loctite® Equipment Sourcebook, LT-3669](http://www.equipment.loctite.com) or visit us at [www.equipment.loctite.com](http://www.equipment.loctite.com) for more details.



# Silicone Adhesives & Sealants

Loctite® silicone gasketing materials include unique products with excellent fluid resistance, formulations for high operating temperatures and UV-curing formulations for cure-in-place production requirements. Silicone gasketing products are best suited for large gap applications and stamped metal assemblies where flange flexing occurs.



## FORMED-IN-PLACE

### LOCTITE® 5045™ FLANGE SEALANT

*Noncorrosive, Alkoxy Silicone*

RTV paste, excellent for adhesion, sealing and gasketing applications.

### LOCTITE® 5600™ SILICONE SEALANT

*Two-Part, Noncorrosive*

Fast, 5-minute fixture, high adhesion, flexible adhesive / sealant. Available in black, grey, and almond.

**NEW**

### LOCTITE® 5699™ GREY, HIGH PERFORMANCE RTV SILICONE GASKET MAKER

For rigid flange assemblies. Excellent fluid resistance. Easy to dispense, noncorrosive, low odor, low volatility. Grey in color.

### LOCTITE® 5900™ FLANGE SEALANT

*Heavy Body RTV Silicone*

Superior flexibility and adhesion. Provides instant seal. Excellent fluid resistance. Noncorrosive, low odor, low volatility. Black in color.

### LOCTITE® 5905™ FLANGE SEALANT

*RTV Silicone*

Superior flexibility and adhesion, fast depth of cure. Offers excellent fluid resistance. Now available in black and white.

**NEW**

### LOCTITE® 5910™ FLANGE SEALANT

*RTV Silicone*

Superior flexibility and adhesion. Excellent fluid resistance. Medium body and easy to dispense. Noncorrosive, low odor, low volatility. Black in color.

### LOCTITE® 5920™ COPPER, HIGH PERFORMANCE RTV SILICONE GASKET MAKER

High performance for rigid flange assemblies. Low volatility. Copper in color.

### LOCTITE® 5999™ FLANGE SEALANT

*Heavy Body / Grey High Performance RTV Silicone Gasket Maker*

For rigid flange assemblies. Provides instant seal. Excellent fluid resistance. Noncorrosive, low odor, low volatility. Grey in color.

## CURED-IN-PLACE

### LOCTITE® 5039™ NUVA-SIL® SILICONE ADHESIVE SEALANT

Designed for automated assembly. Rapid, 30-second, UV or visible light cure permits in-line processing. Secondary moisture cure insures full cure even in shadowed areas. Translucent in color.

### LOCTITE® 5950™/5951™ FASTGASKET® FLANGE SEALANTS

Designed for automated assembly. Rapid, 30-second, UV cure permits in-line processing. Secondary moisture cure insures full cure even in shadowed areas. Black/clear in color.

### LOCTITE® 5960™ FASTGASKET® FLANGE SEALANT

Designed for automated assembly. Rapid, 30-second, UV cure permits in-line processing. Fluid resistant. Available in clear and blue.

### LOCTITE® 5963™ PROCURE® CURE-IN-PLACE GASKET

*Heat Cure Compression*

Superior compression set resistance. One-component, exceptional fluid resistance, and heat resistance to 150°C. Great for powertrain applications. Grey in color.

**Loctite® Instant Gasket —**

Return equipment to service immediately when you make leakproof gaskets in just one minute with Loctite® Instant Gasket. Outperforms pre-cut gaskets.

**CURED-IN-PLACE (continued)****LOCTITE® 5964™ PROCURE® CURE-IN-PLACE GASKET****Heat Cure Compression**

Soft, with greater elongation. Cures with either convection heat or microwave. One-component, good compression set for powertrain applications. Brown in color.

**HIGH PERFORMANCE RTV SILICONES****LOCTITE® INSTANT GASKET**

Makes high performance, leakproof gaskets in one minute. Equipment can be returned to service immediately. Blowout resistant. Outperforms pre-cut gaskets.

**LOCTITE® 598™ BLACK, HIGH PERFORMANCE RTV SILICONE GASKET MAKER**

Retains high flexibility and oil resistance for longer gasket life. Temperature range is -75°F to 625°F (-59°C to 329°C) intermittent. Low odor, noncorrosive, low volatility. Resistant to most chemicals and solvents. Fills gaps to 0.25".

**LOCTITE® 587™ BLUE, HIGH PERFORMANCE RTV SILICONE GASKET MAKER**

Forms tough, flexible gaskets directly on the flange. Offers excellent adhesion to oily surfaces. Low odor, noncorrosive, low volatility. Withstands temperatures to 500°F (260°C) intermittent. Resistant to most chemicals and solvents. Fills gaps to 0.25".

**SUPERFLEX® RTV SILICONES****LOCTITE® SUPERFLEX® BLUE RTV SILICONE ADHESIVE SEALANT**

Cures to a tough, flexible rubber. Makes reliable "formed-in-place" gaskets that resist shrinking, cracking, and migrating. Coats pre-cut gaskets to increase reliability. Temperature range is -65°F to 500°F (-54°C to 260°C) intermittent. Low volatility. Fills gaps to 0.25".

**LOCTITE® SUPERFLEX® RED HIGH TEMP RTV SILICONE ADHESIVE SEALANT**

Makes gaskets that resist temperatures to 600°F (315°C) intermittent. Resists aging, weather, and thermal cycling without shrinking, cracking, or hardening. Fills gaps to 0.25".

**LOCTITE® SUPERFLEX® NONCORROSIVE RTV CLEAR SILICONE ADHESIVE SEALANT**

Neutral curing and noncorrosive. For aluminum, concrete, and electrical applications. Temperature resistant to 400°F (204°C) continuous service, 500°F (260°C) intermittent.

**LOCTITE® SUPERFLEX® RTV SILICONE ADHESIVE SEALANT**

General purpose, one-part silicone adhesive sealant cures at room temperature to form a tough rubber seal. Will not slump in overhead or vertical applications. Formulated to withstand extreme temperature cycling, UV light, and ozone. Cannot be painted. Available in black, clear, and white.

**URETHANE SEALANT****LOCTITE® URETHANE SEALANT**

Single-component, gun-grade caulk that bonds, seals, and waterproofs up to 180°F. Outstanding adhesion properties to concrete, masonry, glass, plastics, wood, aluminum, and most other metals.

**DISPENSING OPTIONS****EASY DISPENSE AEROSOL CAN SYSTEMS FOR LOCTITE® SILICONES**

Several Loctite® silicones are now available in the most advanced system for dispensing silicones. This new package offers effortless fingertip control, ease-of-use (even upside down), and accurate dispensing while eliminating the waste, mess, and caulking guns needed for other silicone dispense systems.








**Available Item Numbers:** 40462, 40463, 40464, 40466, 40479, 40481, 40482, 40505

**1.800.LOCTITE (562.8483)**  
**www.loctite.com/distributor**  
 Call or visit our website to locate your nearest distributor.



**New Easy Dispense Aerosol Cans**

## Loctite® Formed-In-Place Silicone Gasketing Properties Chart


PRODUCT	Item Number	Package Type & Size	COLOR / MIX RATIO	TYPICAL USE	GAP FILL	EXTRUSION RATE (g/min.)	TEMPERATURE RANGE (INTERMITTENT)	CURE METHOD	CURE SPEED*	SPECIFIC GRAVITY	DUROMETER**	% ELONGATION	TENSILE STRENGTH (psi†)	AGENCY APPROVALS
<b>5045™</b>	40409 40408 40724	3 oz. tube 300 ml cartridge 40 lb. pail	Clear / N/A	Military, high tensile	0.250"	40	-65°F to 400°F	Moisture	Tack Free – 1.5 hours Full Cure – 24 hours	1.14	25	>500	>493	ML-A-46146B
<b>5600™</b> 	Part A - 41327 Part B - 41732	440 lb. drum 575 lb. drum	Black / 2:1 A:B by volume	High adhesion, fast fixture	Unlimited	N/A	-40°F to 450°F	Two-part	Tack Free – 10 minutes	1.4	40	200	205	UL Listed for U.S.
	Part A - 922122 Part B - 922089	4.5 gallon pail 3.5 gallon pail												
	922546	400 ml dual cartridge												
	Part A - 922129 Part B - 41732	440 lb. drum 575 lb. drum	Grey / 2:1 A:B by volume	High adhesion, fast fixture	Unlimited	N/A	-40°F to 450°F	Two-part	Tack Free – 10 minutes	1.4	40	200	205	UL Listed for U.S.
	Part A - 922128 Part B - 922089	4.5 gallon pail 3.5 gallon pail												
	922544	400 ml dual cartridge												
	Part A - 924107 Part B - 922089	4.5 gallon pail 3.5 gallon pail	Almond / 2:1 A:B by volume	High adhesion, fast fixture	Unlimited	N/A	-40°F to 450°F	Two-part	Tack Free – 10 minutes	1.4	40	200	205	UL Listed for U.S.
	924104	400 ml dual cartridge												
<b>5699™ Grey</b>	18718 18581 18582 18583 40505	70 ml tube 300 ml cartridge 50 lb. pail 550 lb. drum 190 ml can	Grey	Oil / water resistant	0.250"	250	-75°F to 625°F	Moisture	Tack Free – 30 minutes Full Cure – 24 hours	1.45	55	160	435	CFIA
<b>5900®</b> 	20166 20167 20168	300 ml cartridge 50 lb. pail 550 lb. drum	Black	High adhesion, instant seal	0.250"	35	-65°F to 500°F	Moisture	Tack Free – 20 minutes Full Cure – 24 hours	1.34	35	550	200	CFIA, NSF P1
<b>5905™</b>  	38535 36923	300 ml cartridge 50 lb. pail	Black	High adhesion, fast depth of cure	0.240"	350	-65°F to 500°F	Moisture	Tack Free – 20 minutes Full Cure – 24 hours	1.30	39	345	270	CFIA
	40969 40515	300 ml cartridge 50 lb. pail	White											
<b>5910®</b> 	21746 21747 21748	300 ml cartridge 50 lb. pail 550 lb. drum	Black	High adhesion	0.240"	600	-65°F to 500°F	Moisture	Tack Free – 20 minutes Full Cure – 24 hours	1.34	30	550	200	CFIA
<b>5920™ Copper</b> 	30542 82046 21472	70 ml tube 300 ml cartridge 40 lb. pail	Copper	High temperature	0.240"	>300	-65°F to 700°F	Moisture	Tack Free – 60 minutes Full Cure – 24 hours	1.05	31	355	275	CFIA
<b>5999™</b> 	21744 28298 20170	300 ml cartridge 50 lb. pail 550 lb. drum	Grey	Oil / water resistant, instant seal	0.240"	105	-75°F to 625°F	Moisture	Tack Free – 10 minutes Full Cure – 24 hours	1.45	60	175	500	N/A


\* Varies with substrates.

\*\* Shore A.

† Grit blasted steel.

## Loctite® Cured-In-Place Silicone Gasketing Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	EXTRUSION RATE (g/min.)	CURE METHOD	CURE SPEED*	HARDNESS	% ELONGATION	TENSILE STRENGTH (psi†)	AGENCY APPROVALS
<b>5039™ Nuva-Sil®</b>	40438 40439	300 ml cartridge 40 lb. pail	Translucent / Colorless / Fluorescent	222	UV or Visible / Moisture	30 seconds @ 120 mW/cm²	37	210	290	N/A
<b>5950™ Fastgasket®</b> 	29287 18495	300 ml cartridge 40 lb. pail	Black	350	UV / Moisture	30 seconds @ 120 mW/cm²	30	200	150	UL Classified for U.S.
<b>5951™ Fastgasket®</b>	18198	40 lb. pail	Clear	350	UV / Moisture	30 seconds @ 120 mW/cm²	30	200	150	N/A
<b>5960™ Fastgasket®</b>	31132 24707 929334	300 ml cartridge 40 lb. pail 40 lb. pail	Clear Clear Blue	350	UV	30 seconds @ 120 mW/cm²	50	260	600	N/A
<b>5963™ Procure®</b>	34337	50 lb. pail	Grey	250	Heat	10 minutes @ 150°C	50	360	620	N/A
<b>5964™ Procure®</b>	34348 34347	300 ml cartridge 50 lb. pail	Brown	120	Heat / Microwave	10 minutes @ 150°C VFM 2 to 4 minutes	32	530	635	N/A
<b>3407™ OptiLOC®</b>	35173	30 ml syringe	Black	5	Heat	60 minutes @ 150°C	33	>600	>493	N/A

 Indicates worldwide availability.



## Loctite® Silicones and Urethane Gasketing Properties Chart

Octyl-Trimethylsiloxanes and Urethane Gasketing Properties Chart										
PRODUCT		Item Number	Package Type & Size	COLOR	CONSISTENCY	OIL RESISTANCE	NONCORROSIVE	TEMPERATURE RANGE (INTERMITTENT)	SEALING TIME	AGENCY APPROVALS
HIGH PERFORMANCE RTV SILICONES	Instant Gasket	30509 30507 40479 40478	5 oz. cartridge 7 oz. can 190 ml can 90 ml can	Black	Paste	Increased oil resistance	✓	-75°F to 500°F (-59°C to 260°C)	Operating strength 15 psi – 1 minute	GM 998-5990 Type 1, Ford WSE-M4G323-A6, Daimler Chrysler MS-GF44 Grade A, CFIA
	598™ Black	34018 59830 59875 59891 40463	0.5 ml tube 70 ml tube 300 ml cartridge 49 lb. pail 190 ml can	Black	Paste	Excellent oil resistance	✓	-75°F to 625°F (-59°C to 329°C)	Tack Free – 30 minutes Full Strength – 24 hours	ABS, CFIA
	587™ Blue	58730 58775 58791 40462	70 ml tube 300 ml cartridge 17 liter pail 190 ml can	Blue	Paste	Increased oil resistance	✓	-75°F to 500°F (-59°C to 260°C)	Tack Free – 30 minutes Full Strength – 24 hours	UL Listed for U.S., NSF P1, CFIA, ABS
	5699™ Grey	18718 18581 40505	70 ml tube 300 ml cartridge 190 ml can	Grey	Paste	Increased oil resistance	✓	-75°F to 625°F (-59°C to 329°C)	Tack Free – 30 minutes Full Strength – 24 hours	CFIA
	5920™ Copper	30542 82046	70 ml tube 300 ml cartridge	Copper	Paste	Increased oil resistance	✓	-65°F to 700°F (-54°C to 371°C)	Tack Free – 60 minutes Full Strength – 24 hours	CFIA
	5905™ Black	38535	300 ml cartridge	Black	Paste	Excellent oil resistance	✓	-65°F to 500°F (-54°C to 260°C)	Tack free – 20 minutes Full Strength – 24 hours	CFIA
SUPERFLEX® RTV SILICONES	Superflex® Blue RTV	30560 30533 30518 40482	80 ml tube 300 ml cartridge 12 oz. tube 190 ml can	Blue	Paste	N/A	N/A	-65°F to 500°F (-54°C to 260°C)	Tack Free – 30 minutes Full Strength – 24 hours	N/A
	Superflex® Red High Temp RTV	59630 59675 82279 40465	80 ml tube 300 ml cartridge 12 oz. tube 190 ml can	Red	Paste	N/A	N/A	-75°F to 600°F (-59°C to 316°C)	Tack Free – 30 minutes Full Strength – 24 hours	CFIA
	Superflex® Clear Noncorrosive RTV	51387 51388	80 ml tube 300 ml cartridge	Clear	Paste	Oil resistant	✓	-75°F to 500°F (-59°C to 260°C)	Tack Free – 25 minutes Full Strength – 24 hours	UL Listed for U.S.
	Superflex® RTV	59330 59375 40464	80 ml tube 300 ml cartridge 190 ml can	Black	Paste	N/A	N/A	-65°F to 450°F (-54°C to 232°C)	Tack Free – 30 minutes Full Strength – 24 hours	UL Listed for U.S., NSF/ANSI 51, CFIA
		59530 59575 40481	80 ml tube 300 ml cartridge 190 ml can	Clear						
59430 59475 40466		80 ml tube 300 ml cartridge 190 ml can	White							
URETHANE SEALANT	Urethane Sealant	39916	10.2 oz. cartridge	Grey	Paste	N/A	N/A	-40°F to 180°F (-40°C to 82°C)	Heavy Skin over 2 to 4 hrs. Full Cure – 3 days	CFIA
		36132	10.2 oz. cartridge	Black						

## Loctite® Gasketing Silicones and Urethane Attribute and Application Chart

PRODUCT	MAIN ATTRIBUTES	APPLICATIONS
Instant Gasket	Instant seal and blowout resistance, replaces most cut gaskets, low odor, sensor-safe	Timing gear and valve covers, water pumps, gearboxes, transmission pans
598™ Black	Forms a tough, flexible silicone rubber gasket	Oil pans, valve covers, timing gear covers, differential covers
587™ Blue	Plant maintenance and small- to large-sized OEM	Typical automotive gasketing applications
5699™ Grey	Excellent oil resistance	Rigid flange sealing of transmissions and cast metal housings
5920™ Copper	Fills voids in surfaces for a positive seal	Adheres to most surfaces
5905™ Black	Fast cure, excellent fluid resistance	Large gap applications, flange flexing
Superflex® Blue RTV	Forms a tough, flexible silicone rubber gasket, oxygen sensor-safe	Typical automotive gasketing applications
Superflex® Red High Temp RTV	Plant maintenance and small- to large-sized OEM, low silicone volatiles	Automotive gasketing, industrial furnaces, boilers, ducting
Superflex® Clear Non-Corrosive RTV	Resists steam, chemical and UV ozone exposure	Adheres to most surfaces
Superflex® RTV	Resists aging, weathering and thermal cycling without hardening, shrinking, or cracking	Adheres to most surfaces
Urethane Sealant	Lifelong flexibility, paintable, weather resistant	Forming expansion joints, sealing gutters, filling concrete cracks



# Lubricating

## ANTI-SEIZE

Loctite® anti-seize products provide protection against rust, corrosion, seizing and galling as well as lubrication. Anti-seizes are typically the products of choice for high temperature applications because of their unique ability to provide protection in extreme temperature conditions. Each product contains a combination of solid lubricating agents resulting in different high temperature limits and lubricities. These are the two major factors in choosing the right anti-seize product for your application.

### ***Metal-Free***

The “Metal-Free” products utilize non-metallic fillers to achieve high temperature resistance properties as well as lubricity. These fillers typically provide a much higher temperature resistance than that of metallic fillers and, due to the less abrasive nature of these fillers, they also typically provide lower K-values, resulting in higher lubricity.

## LUBRICANTS

Loctite® lubricants offer superior protection for industrial equipment. When choosing a lubricant, it is important to consider the intended application as well as the environment of the application. The typical function of a lubricant is to protect against friction and wear; however, in an industrial environment there are other factors working against the product, including high temperature, harsh chemicals, and contaminants. Lubricants are also used to protect against corrosion by displacing moisture and leaving a film on the part.

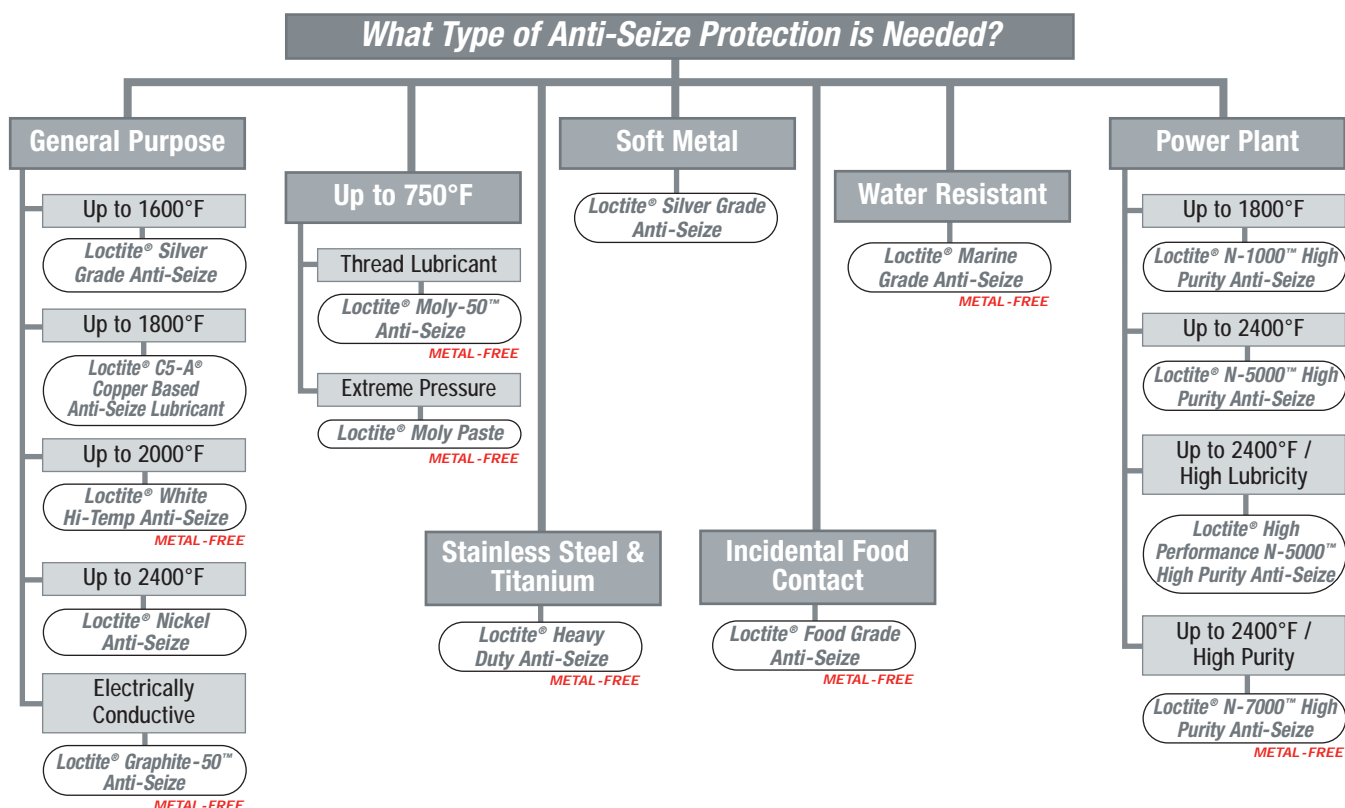
### ***Why choose a synthetic lubricant?***

- Improved high temperature performance
- Higher lubricity
- Superior water-washout properties
- Higher purity

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any anti-seize or lubricant.*

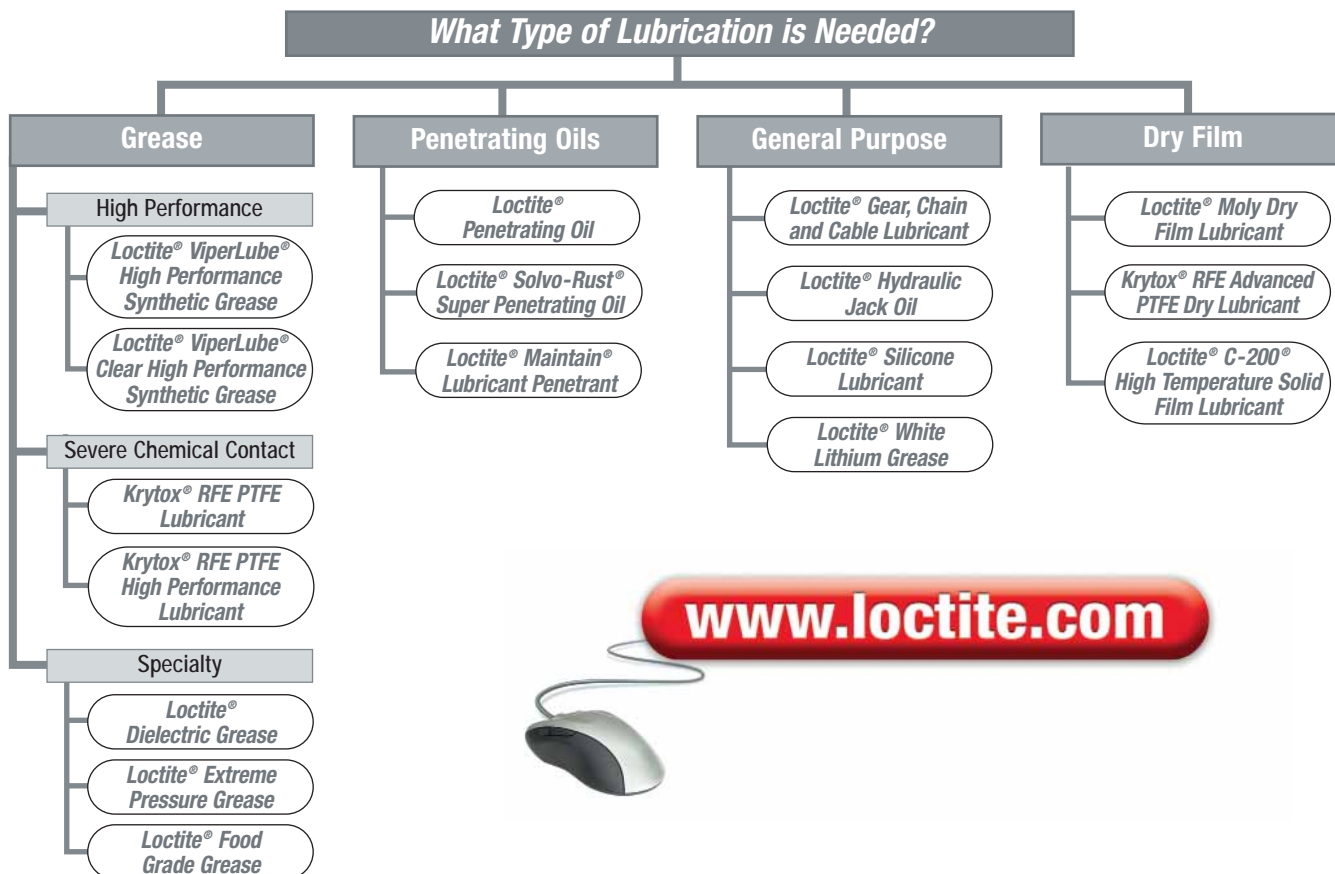
Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit [www.loctite.com](http://www.loctite.com) and select “Contact Loctite.” In Canada, please call **1-800-263-5043**.

# Anti-Seize Selector Guide



**NOTE:** Please refer to pages 66-69 for more information on these products.

# Lubricants Selector Guide



[www.loctite.com](http://www.loctite.com)

**NOTE:** Please refer to pages 70-73 for more information on these products.

# Anti-Seize



## GENERAL PURPOSE

### LOCTITE® C5-A® COPPER ANTI-SEIZE LUBRICANT

Exclusive formula suspends copper and graphite in a high quality grease. Protects metal parts from rust, corrosion, galling, and seizing at temperatures to 1800°F (982°C).



### LOCTITE® SILVER GRADE ANTI-SEIZE

Heavy duty, temperature resistant, petroleum-based lubricant compound fortified with graphite and metallic flake. Inert, will not evaporate or harden in extreme cold or heat. For use in assemblies up to 1600°F (871°C).

### LOCTITE® NICKEL ANTI-SEIZE

Copper-free. Recommended for stainless steel and other metal fittings. For preventing corrosion, seizing, and galling in harsh, chemical environments and temperatures to 2400°F (1315°C).

### LOCTITE® QUICKSTIX™ C5-A® COPPER ANTI-SEIZE



The same trusted performance characteristics as the Loctite® C5-A® Copper Anti-Seize paste in a convenient semisolid stick form. Stick package offers more portability and less mess.

### LOCTITE® QUICKSTIX™ SILVER GRADE ANTI-SEIZE



New semisolid stick offers the same performance characteristics as the Loctite® Silver Grade Anti-Seize paste in a convenient semisolid stick form. Stick package offers more portability and less mess.

## CONSIDER THIS...

### Loctite® Industrial Hand Wipes

Clean hands anywhere! Quick and easy to use – no rinsing, drying or residue. Each 9½" x 12" towel is pre-moistened with a powerful citrus-scented cleaning formula. Towels are abrasive enough to scrub off the toughest grease and grime.

**Item Numbers:** 34943 – 75 count canister and  
34944 – 130 count bucket







## Helpful Hints

- Anti-seize is often used as a gasket release agent in instances where reuse of the gasket is desirable.
- Anti-seize is often recommended for use on spark plug threads and electrical connections.

### HIGH PERFORMANCE

#### LOCTITE® HEAVY DUTY ANTI-SEIZE

Excellent lubricity. *METAL-FREE* Formulation provides outstanding lubrication to all metals including stainless steel, aluminum, and soft metals up to 2400°F (1315°C).



#### LOCTITE® QUICKSTIX™ HEAVY DUTY ANTI-SEIZE



New semisolid stick offers the same performance characteristics as the Loctite® Heavy Duty Anti-Seize paste in a convenient semisolid stick form. Stick package offers more portability and less mess.

#### LOCTITE® MARINE GRADE ANTI-SEIZE

*METAL-FREE* formulation to protect assemblies exposed directly or indirectly to fresh and salt water, Loctite® Marine Grade Anti-Seize works especially well in high humidity conditions. It has excellent lubricity, superior water-washout and water spray resistance, and prevents galvanic corrosion. Protects in temperatures from -20°F to 2400°F (-29°C to 1315°C).

#### LOCTITE® WHITE HI-TEMP ANTI-SEIZE

*METAL-FREE*, general purpose, non-metallic formulation that protects against high temperature seizing and galling of mated metal parts, up to 2000°F (1093°C). White in color, it has excellent lubricity and can be used on various metals such as copper, brass, cast iron, steel, and all alloys including stainless steel.

### SPECIALTY

#### LOCTITE® FOOD GRADE ANTI-SEIZE

*METAL-FREE* formulation prevents seizure, galling, and friction in stainless steel and other metal parts up to 750°F (400°C).



#### LOCTITE® GRAPHITE-50™ ANTI-SEIZE

*METAL-FREE*, electrically conductive, non-metallic. Temperature resistant up to 900°F (482°C). Highly electrically conductive in metal-to-metal joints.

#### LOCTITE® MOLY PASTE

*METAL-FREE*, very low friction. Lubricates press fits, protects during break-in and under high static loads up to 750°F (400°C). Allows maximum clamping from available torque.



#### LOCTITE® MOLY-50™ ANTI-SEIZE

*METAL-FREE*, general purpose, thread lubricant. Temperature resistant to 750°F (400°C). Provides excellent lubricity.

#### LOCTITE® ZINC ANTI-SEIZE

Protects aluminum and ferrous surfaces from seizure and corrosion up to 750°F (400°C).

### HIGH PURITY

#### LOCTITE® N-7000™ HIGH PURITY ANTI-SEIZE

*METAL-FREE* formulation provides high levels of purity and excellent lubricating properties. For Class 1, 2 and 3 power plant hardware. Temperature resistant to 2400°F (1315°C).



#### LOCTITE® N-5000™ HIGH PURITY ANTI-SEIZE

Nickel-based. Lubricates and protects Class 1, 2 and 3 power plant hardware. Recommended for highly corrosive environments to 2400°F (1315°C).

#### LOCTITE® HIGH PERFORMANCE N-5000™ HIGH PURITY ANTI-SEIZE

Maximum lubricating and anti-seize properties for Class 1, 2 and 3 power plant hardware. Temperature resistant to 2400°F (1315°C).

#### LOCTITE® N-1000™ HIGH PURITY ANTI-SEIZE

Certified pure. Copper-based. Suitable for critical, long-term, stainless steel applications and high-nickel, alloy bolting. Recommended for protecting Class 2 and 3 power plant hardware. Temperature resistant to 1800°F (982°C).



**1.800.LOCTITE (562.8483)**

**[www.loctite.com/distributor](http://www.loctite.com/distributor)**

Call or visit our website to locate your nearest distributor.



## Torque Guide

Proper clamp load is an essential part of any bolted assembly for trouble-free operations. Torquing either nut or bolt creates the clamp load. An anti-seize lubricant used on a bolt helps to develop greater clamp load for the same torque compared to an unlubricated bolt. An additional benefit is greater uniformity in clamp load among a series of bolts. The relationship between torque and clamp load is expressed in the following equation:  $T = KFD$



### Where:

- $T$  = Torque (in.-lb., ft.-lb., N-m)  
 $F$  = Clamp Load (lb., N)  
 $D$  = Nominal diameter of bolt (in., ft., m)  
 $K$  = Torque coefficient or nut factor, determined experimentally

**K Factors:** K factors are obtained on Grade 8, 1/2" steel bolts and grade 5 nuts by a test procedure that measures torque tension properties. Lubricant was applied to the bolt threads and both faces of the washer.

See the Properties Chart for the torque coefficient or K value for the anti-seize compounds.

Henkel Corporation believes that this data fairly represents performance to be expected. However, Henkel makes no warranty of specific performance on any individual fastener. In critical applications, it is necessary to determine K values independently.

*Note: There are two "coefficients" used to express the relationship between torque and tension: torque coefficient (also called "nut factor") is the most commonly used. A different concept is the "friction coefficient," which has value  $\frac{2}{3}$  (or 67%) of the torque coefficient.*

## Loctite® Anti-Seize Properties Chart

PRODUCT		Item Number	Package Type & Size	TEMPERATURE RESISTANCE	COLOR	K-VALUE
GENERAL PURPOSE	C5-A® Copper Anti-Seize Lubricant	51299 51277 51001 51002 51144 51147 51005 51003 51004 51006 51007 39643 51008 51009 38584 51011 51146	2 g pouch 7 g pouch 1 oz. tube 4 oz. tube 4 oz. brush-top can 8 oz. brush-top can 10 oz. brush-top can 12 oz. net wt. aerosol 13 oz. cartridge 1 lb. can 1 lb. brush-top can 1 lb. brush-top metal can 2.5 lb. can 8 lb. can 25 lb. pail 42 lb. pail 425 lb. drum	1800°F (982°C)	Copper	0.16
	QuickStix™ C5-A® Copper Anti-Seize	37229 39222	20 g stick 40 g stick			
	Silver Grade Anti-Seize	38181 80209 76732 76759 76764 80206 76775	7 g pouch 4 oz. brush-top can 8 oz. brush-top can 12 oz. net wt. aerosol 1 lb. brush-top can 1 gallon can 5 gallon pail	1600°F (871°C)	Silver	0.18
	QuickStix™ Silver Grade Anti-Seize	37230 39223	20 g stick 40 g stick			
	Nickel Anti-Seize	77124 51286 51102 77164 51152 77175	8 oz. brush-top can 12 oz. net wt. aerosol 1 lb. can 1 lb. brush-top can 8 lb. can 5 gal. pail	2400°F (1315°C)	Silver	0.13
HIGH PERFORMANCE	Heavy Duty Anti-Seize	51609 51605 51606 51607 51608	1 oz. tube 9 oz. brush-top can 1.2 lb. brush-top can 2.3 lb. can 45 lb. pail	2400°F (1315°C)	Black	0.16
	QuickStix™ Heavy Duty Anti-Seize	41205	20 g stick	2400°F (1315°C)	Black	0.16
	Marine Grade Anti-Seize	34395 34026	8 oz. brush-top can 16 oz. brush-top can	2400°F (1315°C)	Black	0.18
SPECIALTY	White Hi-Temp Anti-Seize	34517 34518	8 oz. brush-top can 16 oz. brush-top can	2000°F (1093°C)	White	0.16
	Food Grade Anti-Seize	51168 51170 51171	8 oz. brush-top can 2 lb. can 40 lb. pail	750°F (400°C)	White	0.13
	Graphite-50™ Anti-Seize	51084	1 lb. can	900°F (482°C)	Black	0.13
	Moly Paste	51050 51048 51049 51145	12 oz. net wt. aerosol 8 oz. brush-top can 1 lb. brush-top can 15 lb. can	750°F (400°C)	Black	0.11
	Moly-50™ Anti-Seize	51094	1 lb. can	750°F (400°C)	Black	0.13
HIGH PURITY	Zinc Anti-Seize	39901	1 lb. can	750°F (400°C)	Grey	0.15
	N-7000™ High Purity Anti-Seize	51272 51270 51273	8 oz. brush-top can 1 lb. brush-top can 2 lb. can	2400°F (1315°C)	Silver	0.16
	N-5000™ High Purity Anti-Seize	51346 51243 51269 51246 51245	1 oz. tube 8 oz. brush-top can 1 lb. brush-top can 2 lb. can 8 lb. can	2400°F (1315°C)	Silver	0.15
	High Performance N-5000™ High Purity Anti-Seize	51572	1 lb. brush-top can	2400°F (1315°C)	Silver	0.15
	N-1000™ High Purity Anti-Seize	51115 51116 51117	8 oz. brush-top can 1 lb. can 2 lb. can	1800°F (982°C)	Copper	0.17

 Indicates TOP CHOICE products.

# Loctite® Anti-Seize Application Chart

PRODUCT		MAXIMUM ANTI-SEIZE PROPERTIES	FOR MAXIMUM LUBRICITY	FOR LOW SPEEDS, HIGH LOADS	EXTREME HIGH TEMPERATURE RESISTANCE (TO 2000°F ~ 2400°F)	EXTREME CHEMICAL RESISTANCE	ELECTRICALLY CONDUCTIVE	FOR ALUMINUM / SOFT METALS	FOR STAINLESS STEEL	METAL-FREE FORMULATION	COPPER-FREE FORMULATION	KEY SPECIFICATIONS AND AGENCY APPROVALS
GENERAL PURPOSE	C5-A® Copper Based Anti-Seize Lubricant <input checked="" type="checkbox"/>	●					●	●	●			MIL-PRF-907F, CFIA (QuickStix™)
	Silver Grade Anti-Seize	●					●	●	●			MIL-PRF-907F, ABS, CFIA
	Nickel Anti-Seize	●			●	●	●		●		●	ABS
HIGH PERFORMANCE	Heavy Duty Anti-Seize <input checked="" type="checkbox"/>	●			●	●	●	●	●	●	●	N/A
	Marine Grade Anti-Seize	●			●				●	●	●	ABS
	White Hi-Temp Anti-Seize	●			●			●	●	●	●	N/A
SPECIALTY	Food Grade Anti-Seize <input checked="" type="checkbox"/>	○						●		●	●	NSF H1, CFIA
	Graphite-50™ Anti-Seize	○				●	●	●		●	●	N/A
	Moly Paste <input checked="" type="checkbox"/>	○	●	●					●	●	●	N/A
	Moly-50™ Anti-Seize	○	●	●					●	●	●	MIL-PRF-83483
	Zinc Anti-Seize	○					○	●	●			N/A
HIGH PURITY	N-7000™ High Purity Anti-Seize <input checked="" type="checkbox"/>	●			●	●	●		●	●		N/A
	N-5000™ High Purity Anti-Seize	●			●	●	●		●		●	N/A
	High Performance N-5000™ High Purity Anti-Seize	●	●		●	●	●		●		●	N/A
	N-1000™ High Purity Anti-Seize	●					●		●		●	N/A

● Preferred Choice

● Good Choice

○ Acceptable Choice



LOCTITE® BRAND METAL-FREE ANTI-SEIZE PRODUCTS

# Lubricants



## SYNTHETIC / HIGH PERFORMANCE

### LOCTITE® VIPERLUBE® HIGH PERFORMANCE SYNTHETIC GREASE

NLGI grade 2/severe duty GC-LB grease provides superior protection for equipment exposed to a wide range of operating temperatures and environments. Use as a lubricant and protective anti-rust film on bearings, machine parts, equipment, or as a release agent on gaskets and seals. NSF H1 rated for incidental food contact.

### LOCTITE® VIPERLUBE® CLEAR HIGH PERFORMANCE SYNTHETIC GREASE

Lasts four times longer than petroleum-based lubricants. Withstands temperatures up to 420°F (520°F intermittent). Contains PTFE for added protection against friction and wear. Nonflammable. Contains no ozone-depleting compounds. NLGI #2 grade grease. Opaque white in color.

### LOCTITE® VIPERLUBE® HIGH PERFORMANCE SYNTHETIC LUBRICANT

*Gear Oil – 90W*  
Extends equipment life and reduces oil changes and energy costs. Recommended for use on gear sets, bearings, circulating oil systems, chains and worn gear units. NSF H1 rated for incidental food contact.

### LOCTITE® VIPERLUBE® HIGH PERFORMANCE SYNTHETIC LUBRICANT

*Lightweight Oil – 10W*  
Reduces varnish and deposits, minimizing the need for replacement parts and maintenance. Recommended for use on hydraulic systems, rotary screw compressors, food processing machinery, bearings, chains, and valves. NSF H1 rated for incidental food contact.

## SPECIALTY OILS AND LUBRICANTS

### KRYTOX® RFE PFPE LUBRICANT AND HIGH PERFORMANCE LUBRICANT

This grease lubricant has excellent lubrication properties over a broad temperature range, will not cause cracking or swelling, and contains a corrosion inhibitor to protect against undue wear. Eliminates sticking and aids in disassembly. Nonflammable, chemically inert. Compatible with chlorine. Specially formulated high performance lubricant designed to provide long-lasting lubrication for all types of moving and/or sliding parts. See product description sheet for test results.

### KRYTOX® RFE ADVANCED PTFE DRY LUBRICANT

A high performance, synthetic lubricant designed to provide long-lasting lubrication for parts that require a dry, thin lubricating film. This lubricant provides excellent lubrication properties over a broad temperature range, and dries to the touch in 60 seconds. It is non-oily, non-staining, non-migrating, and will not attract dirt or dust.

### LOCTITE® GEAR, CHAIN AND CABLE LUBRICANT

Protects and prolongs the life of gears, chains, wire rope, and cable. Repels dirt, sand, and dust with minimal “throw-off” from centrifugal force. Contains no ozone-depleting compounds.

### LOCTITE® SILICONE LUBRICANT

Multipurpose lubricant stops sticking, friction, squeaking, and binding of moving parts. Non-gumming. Will not mar paint, rubber, or plastic surfaces. Waterproofs and electrically insulates. CFIA approved.





## Helpful Hints

- Dry film lubricants are an ideal choice for "unclean" environments where there is potential for dirt and other contaminants to come in contact with the product. Contaminants will not stick like they would with a standard grease.
- Loctite® Maintain® Lubricant Penetrant is a moisture displacer, a rust preventative, and an excellent alternative to WD-40.

## SPECIALTY OILS AND LUBRICANTS (continued)

### LOCTITE® MOLY DRY FILM LUBRICANT

Solid film lubricant for sliding surfaces and slow moving parts. Temperature resistant up to 750°F (400°C) as a dry film lubricant, 2400°F (1315°C) as an anti-seize. Won't squeeze out, burn off, or pick up dirt.

### LOCTITE® SOLVO-RUST® SUPER PENETRATING OIL

Frees rusted parts and keeps them lubricated and protected from rust after use. May be applied on or near moving parts. Will not harm painted surfaces. Contains no ozone-depleting compounds. CFIA approved.

### LOCTITE® C-200® HIGH TEMPERATURE SOLID FILM LUBRICANT

Solid film protection for engine parts, bearings, and servo-mechanisms. Temperature resistant up to 750°F (400°C) as a dry film lubricant, 2400°F (1315°C) as an anti-seize.

### LOCTITE® PENETRATING OIL

Penetrates, lubricates, and displaces moisture. Protects against rust and corrosion. Contains no ozone-depleting compounds.

### LOCTITE® FREEZE & RELEASE

*Fast Acting Corrosion Release*



Instantly chills seized and rusted parts (bolts, nuts, studs) down to -45°F. The exceptional shock-freeze action causes microscopic cracks in the layer of rust, allowing the lubricating ingredient to wick directly into the rust by capillary action.

## PETROLEUM-BASED GREASES

### LOCTITE® WHITE LITHIUM GREASE

General-purpose lubricating paste for metal-to-metal and metal-to-plastic applications. Provides corrosion protection. Contains no ozone-depleting compounds.

### LOCTITE® DIELECTRIC GREASE

Provides a moisture-proof barrier that lubricates and protects electrical equipment from salt, dirt, and corrosion. High dielectric strength. Good thermal, oxidation, and chemical stability.

### LOCTITE® EXTREME PRESSURE GREASE

Lubricates gears, bearings, and slides up to 450°F (232°C). NLGI #1 rated. Withstands extremes of pressure and resists water-washout. Maintains pumpability at low temperatures; will not take a hard set after cooling.

### LOCTITE® HYDRAULIC JACK OIL

Non-corrosive oil improves lubrication in all types of hydraulic units (except hydraulic brakes). Contains antioxidant, anti-rust, and anti-wear additives.

### LOCTITE® FOOD GRADE GREASE

Extreme pressure grease with temperature resistance to 450°F (232°C). NLGI #2 rated. Protects after flushouts and steam cleaning. NSF H1 rated for incidental food contact. CFIA approved.

### LOCTITE® MAINTAIN® LUBRICANT PENETRANT

*Moisture Displacer & Rust Preventer*  
Spray-on rust preventative for all metal parts. Unfreezes rusted parts; displaces and seals out moisture. For use on steel, aluminum, brass, copper, magnesium, and other metals and alloys. Contains no ozone-depleting compounds. CFIA approved.

## DISPENSING OPTIONS

**Loctite® Industrial Manual Grease Dispenser** is a handheld, lever action, manually operated grease dispenser for industrial use.

**Item Number:** 98431  
**Dimensions:** 15" H x 2.5" W x 4.5" D  
**Weight:** 3.7 lbs. (1678 g)  
**Package Types & Sizes:**  
300 ml cartridges  
and all bulk containers



**Loctite® Industrial Pneumatic Grease Dispenser** is a handheld, pneumatically operated grease dispenser for industrial use.

**Item Number:** 98432  
**Dimensions:** 15" H x 2.5" W x 7.25" D  
**Weight:** 4.5 lbs. (2063 g)  
**Package Types & Sizes:** 300 ml cartridges and all bulk containers

For spare parts and accessories, please see our **Loctite® Equipment Sourcebook, LT-3669** or visit us at [www.equipment.loctite.com](http://www.equipment.loctite.com).



**Loctite® Industrial Cordless Electric Grease Dispenser** is a handheld, electrically operated, 12-volt grease dispenser for industrial use.

**Item Number:** 98433  
**Dimensions:**  
19.5" H x 3.5" W x 8" D  
**Weight:** 7.7 lbs. (3486 g)  
**Package Types & Sizes:**  
300 ml cartridges  
and all bulk containers





## Loctite® ViperLube® Synthetic Lubricants Properties Chart

PRODUCT		Item Number	Package Type & Size	TEMPERATURE RESISTANCE	TYPE OF LUBRICANT	VISCOSITY GRADE	POUR POINT (ASTM D 97)	FOUR BALL TEST	NLGI RATING	DROP POINT	SPRAY TEST (ASTM B-111)	AGENCY APPROVALS
SYNTHETIC / HIGH PERFORMANCE	ViperLube® High Performance Synthetic Grease	36780 36781 36782 36783 36784 36786 37061 37710 39146	1 cc tube 3 oz. tube 14 oz. cartridge 400 g can 0.42 oz. tube 10.1 oz. net wt. aerosol 30 lb. pail 120 lb. drum 55 gallon drum	400°F (204°C) continuous 500°F (260°C) intermittent	Synthetic hydrocarbon (polyalphaolefin based)	240 CST	N/A	0.45 mm (ASTM D 2266)	2	500°F (260°C) (ASTM D 556)	Pass	NSF H1, CFIA
	ViperLube® Clear High Performance Synthetic Grease	39341 39342 39364	3 oz. tube 400 g cartridge 30 lb. pail	420°F (216°C) continuous 520°F (271°C) intermittent	Synthetic hydrocarbon (polyalphaolefin based)	N/A	N/A	0-60 mm (ASTM D 2266)	2	< 590°F (< 310°C) (ASTM D 2265)	N/A	NSF H1, CFIA
	ViperLube® High Performance Synthetic Lubricant Gear Oil – 90W	36787	1 gallon bottle	450°F (230°C)	Synthetic hydrocarbon (polyalphaolefin based)	220 ISO	-30°C	0.48 mm (ASTM D 4172)	N/A	N/A	Pass	NSF H1, CFIA
	ViperLube® High Performance Synthetic Lubricant Lightweight Oil – 10W	36788	1 gallon bottle	450°F (230°C)	Synthetic hydrocarbon (polyalphaolefin based)	32 ISO	-75°C	0.40 mm (ASTM D 4172)	N/A	N/A	Pass	NSF H1, CFIA

## Grease Compatibility Chart

Thickener Type	Calcium Sulfonate ViperLube®	Silica Gel ViperLube® Clear	Lithium Soap	Lithium Complex	Aluminum Complex	Calcium Complex	Barium Soap	Sodium Soap	Bentone	Polyurea
Calcium Sulfonate ViperLube®		SC	FC	FC	NC	FC	SC	NC	NC	NC
Silica Gel ViperLube® Clear	SC		FC	FC	FC	NC	FC	NC	FC	NA
Lithium Soap	FC	FC		FC	NC	FC	SC	NC	NC	SC
Lithium Complex	FC	FC	FC		NC	FC	SC	NC	NC	SC
Aluminum Complex	NC	FC	NC	NC		NC	NC	SC	NC	NC
Calcium Complex	FC	NC	FC	FC	NC		SC	NC	NC	SC
Barium Soap	SC	FC	SC	SC	NC	SC		NC	NC	NA
Sodium Soap	NC	NC	NC	NC	SC	NC	NC		NC	NC
Bentone	NC	FC	NC	NC	NC	NC	NC	NC		NC
Polyurea	NC	NA	SC	SC	NC	SC	NA	NC	NC	

FC = Fully Compatible

SC = Somewhat Compatible (Mixtures soften but remain grease-like)

NC = Not Compatible (Mixtures soften severely and do not remain grease-like)


NA = Not Available

## Krytox® RFE Lubricants Properties Chart

PRODUCT		Item Number	Package Type & Size	TEMPERATURE RESISTANCE	NONFLAMMABLE	HIGH LOAD CAPABILITY	CORROSION INHIBITORS	COMPATIBLE WITH ALL PLASTICS, METALS, AND ELASTOMERS	CHEMICALLY RESISTANT	OXYGEN COMPATIBLE*	THERMALLY STABLE	WATER / STREAM RESISTANT	NLGI GRADE
SPECIALTY OILS AND LUBRICANTS	Krytox® RFE PFPE Lubricant	29710 31361	2 oz. tube 16 oz. cartridge	-15°F to 500°F (-26°C to 260°C)	✓	✓		✓	✓	✓	✓	✓	2
	Krytox® RFE PFPE High Performance Lubricant	29711 29709	2 oz. tube 16 oz. cartridge	-15°F to 500°F (-26°C to 260°C)		✓	✓	All plastics and metals	✓	✓	✓	✓	2
	Krytox® RFE Advanced PTFE Dry Lubricant	30138	8 oz. net wt. aerosol	-15°F to 500°F (-26°C to 260°C)	Once film is dry			✓	✓		✓	Water repellent	N/A

\* Per BAM 8104-411 &amp; MSFC 106B under specific conditions. Test the proposed application thoroughly before use.

# Loctite® Lubricants Properties and Applications Chart

Loclite® Lubricants Properties and Applications Chart				FOOD PROCESSING EQUIPMENT	CLOSE FITTING PARTS	HIGH TEMPERATURE	ELECTRICALLY CONDUCTIVE	ELECTRICAL EQUIPMENT	GEAR, BEARINGS, CABLE AND CONVEYORS	HYDRAULIC UNITS (NOT BRAKES)	FOR HIGH SPEED BEARINGS	FOR LOW SPEEDS AND HIGH LOADS	CHAIN-DRIVEN EQUIPMENT	SOLID FILM	
PRODUCT		Item Number	Package Type & Size	Temperature Resistance											
SYNTHETIC/HIGH PERFORMANCE	ViperLube® High Performance Synthetic Grease	36780	1 cc tube	400°F (204°C) continuous 500°F (260°C) intermittent											
		36781	3 oz. tube												
		36782	14 oz. cartridge												
		36783	400 g can		●	●	●	○	○	●		●	●	●	
		36784	0.42 oz. tube												
		36786	10.1 oz. net wt. aerosol												
		37061	30 lb. pail												
SYNTHETIC/HIGH PERFORMANCE	ViperLube® Clear High Performance Synthetic Grease	39341	3 oz. tube	420°F (216°C) continuous 520°F (271°C) intermittent	●		●		●		●	●	●		
		39342	400 g cartridge					●		●		●	●	●	
		39364	35 lb. pail												
	ViperLube® High Performance Synthetic Lubricant Gear Oil – 90W	36787	1 gallon bottle	450°F (232°C)	●	●	○		●				○		
ViperLube® High Performance Synthetic Lubricant Lightweight Oil – 10W	36788	1 gallon bottle	450°F (232°C)	●	●			●	●			○			
SPECIALTY OILS AND LUBRICANTS	Gear, Chain and Cable Lubricant	81251	12 oz. net wt. aerosol	250°F (121°C)					●				●		
	Silicone Lubricant	51360	150 g tube	400°F (204°C)	●		○		○				○		
		81246	13 oz. net wt. aerosol												
	Moly Dry Film Lubricant	39895	12 oz. net wt. aerosol	750°F (400°C)			○	○	●				○	●	●
		39896	1.3 lb. can												
		39897	10 lb. can												
	Solvo-Rust® Super Penetrating Oil	81252	12.25 oz. net wt. aerosol	250°F (121°C)		○									
C-200® High Temperature Solid Film Lubricant <i>(For unclean environments)</i>	39893	1.3 lb. can	2400°F (1315°C)			●	○					○		●	
	39894	10 lb. can													
Penetrating Oil	80032	1 pint can	100°F (38°C)			○									
51221	12 oz. net wt. aerosol														
Freeze & Release 	996456	13.52 oz. net wt. aerosol	N/A		○										
PETROLEUM-BASED GREASES	White Lithium Grease	30530	1.5 oz. tube	380°F (193°C) (dropping point)					○			●	○		
		30543	10.75 oz. net wt. aerosol												
	Dielectric Grease	30536	0.33 oz. tube	400°F (204°C)			○	○	○						
		37535	3 oz. tube												
	Extreme Pressure Grease	51242	14.5 oz. cartridge	450°F (232°C)			○				●	●			
	Hydraulic Jack Oil	30522	1 quart can	120°F (48°C)						●					
30523	1 gallon can														
Food Grade Grease	51252	14.5 oz. cartridge	450°F (232°C)	●		○					●				
Maintain® Lubricant Penetrant	81204	16 oz. net wt. aerosol	250°F (121°C)		●			●							

● Preferred Choice

○ Good Choice

○ Acceptable Choice

# Machining Compounds

Loctite® Clover® machining compounds (abrading compounds) are abrasive pastes designed especially for the cutting, smoothing and finishing of metal surfaces. They are silicon carbide filled and are used as a supplemental process to grinding, milling, boring, and EDM machining on high or low tensile strength materials, including forged or hardened gears. These compounds produce an ultra-flat surface but not a polished one.

## ***How does grit size affect metal removal?***

Grit size directly relates to the finish left on the metal surface. A very coarse grit, such as our 54 grit, will quickly remove metal from the surface and leave a somewhat rough finish. To achieve a smoother finish, a smaller grit size should be used, such as 1,000 grit. This compound will fill the smaller metal voids and therefore leave a smoother finish.

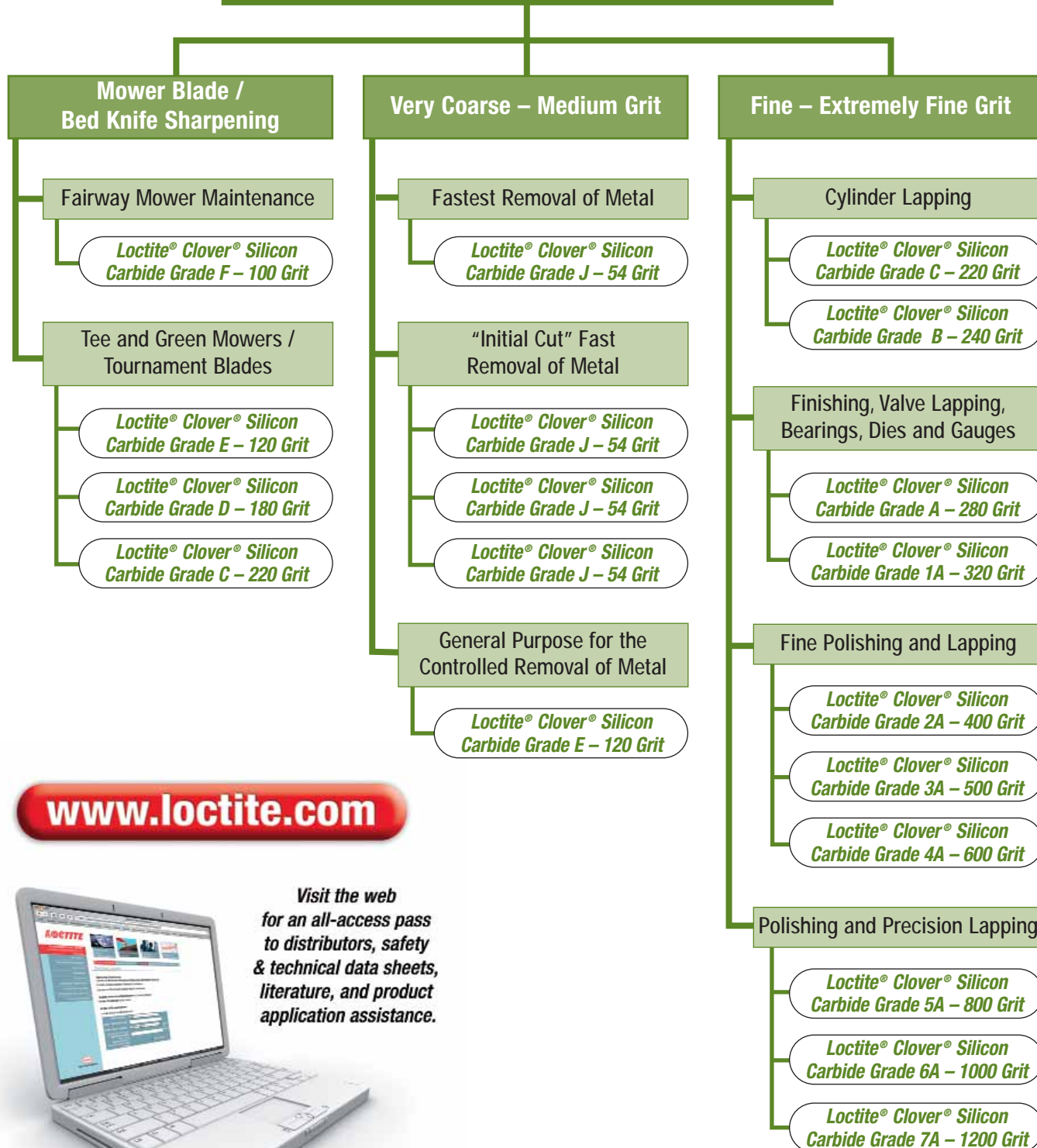
## ***Benefits***

- Premixed and ready to use for consistent performance that is unattainable from mix-your-own slurries.
- Manufactured from premium abrasive grits. Only virgin silicon carbide abrasives, carefully sized, are used.
- Water soluble. The compound clings to blades for superior honing action, but washes away easily. (*Pat Gel® Water Mix only*)
- Biodegradable. (*Pat Gel® Water Mix only*)

Loctite® Adhesives and Sealants Product Specialists are available to assist you. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **[www.loctite.com](http://www.loctite.com)** and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

# Machining Compounds Selector Guide

## What Type of Honing is Needed?



[www.loctite.com](http://www.loctite.com)

Visit the web  
for an all-access pass  
to distributors, safety  
& technical data sheets,  
literature, and product  
application assistance.



**NOTE:** Please refer to pages 76-77 for more information on these products.



# Abrading Compounds



## LOCTITE® CLOVER® SILICON CARBIDE GREASE MIX

The standard abrasive paste for fast metal removal. Produces a smooth, flat surface but not a polished one. Leaves a rust-preventing film on lapped surfaces.

## LOCTITE® CLOVER® SILICON CARBIDE PAT GEL® WATER MIX

Paste formulation for fast metal removal. Biodegradable, recommended for applications where cleanup with water is required.

## LOCTITE® CLOVER® DUPLEX PACKAGING

Loctite® Clover® Silicon Carbide Grease Mix in two convenient grit sizes (120 and 280). Item number 39598 (Kit).



### Helpful Hints

- Loctite® Clover® machining compounds can be removed using the same solvent in which it is carried.
- Loctite® Clover® grease mix products can be removed using a petroleum-based solvent, Loctite® ODC-Free Cleaner & Degreaser.
- Loctite® Clover® Silicon Carbide Pat Gel® Water Mix can be removed with water. Once Loctite® Clover® products are removed, dry the area thoroughly and apply oil or grease to the metal to prevent corrosion.

## Loctite® Clover® Grade and Grit Selector Guide

			AVERAGE PARTICLE SIZE OF ABRASIVE GRAINS	
GRADE	GRIT	Texture and Use	1/1000 inches	Microns (0.001 mm)
7A	1200	Extremely Fine: For polishing, high precision lapping	0.12	3
6A	1000		0.20	5
5A	800		0.38	9
4A	600	Very Fine: For fine polishing and lapping	0.56	14
3A	500		0.68	17
2A	400		0.90	23
1A	320	Fine: For finishing, valve lapping bearings, dies, and gauges	1.28	33
A	280		1.75	44
B	240	Medium Fine: For cylinder lapping	2.48	63
C	220		2.60	66
D	180	Medium: General purpose for controlled metal removal	3.40	86
NC	150		4.80	122
E	120	Coarse: For the initial "cut" fast removal of metal	5.60	142
F	100		6.80	173
G	80		15.00	267
J	54	Very Coarse: For fastest metal removal	18.00	463

## Loctite® Clover® Products Chart

PRODUCT	GRADE	GRIT	Item Number	Package Type & Size
Clover® Silicon Carbide Grease Mix	C	220	39723	25 lb. pail
	D	180	39712	25 lb. pail
	E	120	39711	25 lb. pail
	F	100	39715	25 lb. pail
Clover® Silicon Carbide Grease Mix	J	54	39483	1 lb. can
			39486	100 lb. drum
	G	80	39473	1 lb. can
			39476	100 lb. drum
	F	100	39463	1 lb. can
			39465	25 lb. pail
			39466	100 lb. drum
	E	120	39452	1 lb. can
			39455	100 lb. drum
	NC	150	39499	1 lb. can
	D	180	39439	1 lb. can
			39441	25 lb. pail
	C	220	39426	1 lb. can
			39428	25 lb. pail
	B	240	39413	1 lb. can
	A	280	39401	1 lb. can
			39404	100 lb. drum
	1A	320	39510	1 lb. can
			39512	25 lb. pail
	2A	400	39523	1 lb. can
	3A	500	39536	1 lb. can
	4A	600	39549	1 lb. can
			39551	25 lb. pail
	5A	800	39561	1 lb. can
	6A	1000	39574	1 lb. can
	7A	1200	39587	1 lb. can
			39589	25 lb. pail
			39590	100 lb. drum
	E/A	120/280	39598	Kit – 4 oz. Duplex can
Clover® Silicon Carbide Pat Gel® Water Mix	J	54	39488	1 lb. jar
	G	80	39478	1 lb. jar
			39479	25 lb. pail
	F	100	39468	1 lb. jar
	E	120	39457	1 lb. jar
			39458*	25 lb. pail
	NC	150	39504	1 lb. jar
	D	180	39444	1 lb. jar
	C	220	39431	1 lb. jar
	B	240	39418	1 lb. jar
			39419*	25 lb. pail
	A	280	39406	1 lb. jar
	1A	320	39515	1 lb. jar
	2A	400	39528	1 lb. jar
	3A	500	39541	1 lb. jar
			39542	25 lb. pail
	4A	600	39554	1 lb. jar
	5A	800	39566	1 lb. jar
	6A	1000	39579	1 lb. jar
	7A	1200	39592	1 lb. jar

\* Made-to-order items.

# Potting & Encapsulating

Potting and encapsulating compounds are used to provide mechanical reinforcement to housed assemblies, to fill large voids, and to protect components from the effects of exposure to chemicals, moisture, mechanical shock, and vibration. Sealing components with potting and encapsulating compounds prevents corrosion and ensures long-term integrity of the device.

## ***Variables to consider when selecting a potting or encapsulating material include:***

- Viscosity of uncured compound
- Dispensing requirements
- Device operating temperature
- Desired chemical resistance
- Desired thermal conductivity
- Desired flame retardance
- Hardness of cured product
- Overall cost

There are a variety of potting and encapsulating compounds to choose from – epoxy, hot melt, silicone, and urethane. The thermal properties of epoxy and silicone systems make them ideally suited for applications exposed to temperatures above 257°F (125°C). If a soft, flexible material is needed, particularly at low temperatures, then a urethane, silicone or hot melt material may be used.

## ***What is the best product for my application?***

The following chart will work best when selecting a potting or encapsulating compound. This chart is intended to serve as a general guideline to help you determine which categories are best suited for your application. The data presented represents typical properties for each product category; however, individual product properties may differ. It is suggested that, based on the information provided, you consider at least the two best product categories that meet your application criteria. Individual product information can then be found on the pages that follow to help you narrow your search.

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any adhesive.*

*Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **[www.loctite.com](http://www.loctite.com)** and select “Contact Loctite.” In Canada, please call **1-800-263-5043**.*

## Potting & Encapsulating Selector Guide

PERFORMANCE CONSIDERATIONS	POTTING AND ENCAPSULATING COMPOUNDS			
	Hot Melts	Polyurethanes	Epoxies	Silicones
<b>BENEFITS</b>	Fast, large gap filling	Excellent toughness / flexibility	Wide range of formulations	Excellent temperature resistance
<b>LIMITATIONS</b>	Low heat resistance	Liquid adhesive sensitive to moisture	Mixing required	Low strength
<b>TEMPERATURE RESISTANCE</b>	-65°C to +125°C	-65°C to +125°C	-65°C to +180°C	-65°C to +200°C
<b>FLUID RESISTANCE</b>				
Polar Solvents <sup>1</sup>	Good (Polyolefins, Polyamides)	Good	Very Good	Good
Non-Polar Solvents <sup>2</sup>	Good (Polyamides)	Good	Excellent	Poor
<b>HARDNESS</b>	Semi-soft	Soft	Rigid	Soft
<b>FLEXIBILITY</b>	High	High	Low	Very High
<b>Tg</b>	Low	Low	High	Very Low
PROCESS CONSIDERATIONS	POTTING AND ENCAPSULATING COMPOUNDS			
	Hot Melts	Polyurethanes	Epoxies	Silicones
<b>NUMBER OF COMPONENTS</b>	1	2	2	1
<b>CURE TEMPERATURE</b>	Room Temperature (applied at elevated temperature)	Room Temperature	Room Temperature	UV / Room Temperature
<b>GEL TIME</b>				
Average	60 seconds	1 to 3 hours	1 to 3 hours	30 seconds
Fastest	10 to 20 seconds	15 minutes	15 minutes	5 seconds
<b>FULL CURE TIME</b>	1 hour (or when cooled)	24 hours	24 hours	24 hours
<b>DEPTH OF CURE</b>	Unlimited	Unlimited	Unlimited	Shallow (<1.5")
<b>DISPENSING / CURING EQUIPMENT REQUIRED?</b>	Yes	Yes	Yes	Yes
<b>LIGHT CURE VERSIONS AVAILABLE?</b>	No	No	Yes	Yes
<i>For more information on each compound category refer to pages...</i>	84-85	80-81	80-83	84-85

<sup>1</sup> Examples of Polar Solvents: Water, Ethylene Glycol, IPA, Acetone.

<sup>2</sup> Examples of Non-Polar Solvents: Motor Oil, Gasoline, Toluene, n-Heptane, ATF.



# Epoxies & Polyurethanes

There are a variety of Loctite® potting and encapsulating compounds to choose from – epoxy, hot melt, polyurethane, and silicone. Loctite® potting and encapsulating compounds are designed to protect electrical components from the effects of exposure to chemicals, moisture, thermal shock, mechanical shock, and vibration. Sealing components with Loctite® potting and encapsulating compounds prevents corrosion and ensures long-term integrity of electrical devices.

## EPOXIES & POLYURETHANES

Loctite® Hysol® potting and encapsulating compounds are two-part epoxy and polyurethane systems formulated to offer a wide range of performance characteristics matched to specific application requirements. Any epoxy resin can be combined with any epoxy hardener to create a mixed system. The same applies to the polyurethane resins and hardeners.

LOCTITE® HYSOL® EPOXIES					
RESINS	PRODUCT	Item Number	Package Type & Size	Package Weight	Key Features
	3140™	39944 39945*	1 gallon pail 5 gallon pail	12 lbs. 65 lb.	General Purpose
	3141™	39947 39948*	1 gallon pail 5 gallon pail	12 lbs. 63 lbs.	High Temperature
	3142™	39950	1 gallon pail	16 lbs.	Thermally Conductive
	3145™	40512 40511*	1 gallon pail 5 gallon pail	13 lbs. 65 lbs.	Flame Retardant
HARDENERS	3160™	39958*	5 gallon pail	40 lbs.	Glossy Surface Finish
	3162™	39960 39962*	1 quart can 5 gallon pail	1.8 lbs. 36 lbs.	Fast Cure
	3163™	39964 39966*	1 quart can 5 gallon pail	1.7 lbs. 38 lbs.	Excellent Adhesion
	3164™	39969 39970*	1 gallon pail 5 gallon pail	7 lbs. 40 lbs.	General Purpose
	3165™	39395 39973*	1 quart can 1 gallon pail	1.7 lbs. 7 lbs.	Low Shrinkage

LOCTITE® HYSOL® POLYURETHANES					
RESINS	PRODUCT	Item Number	Package Type & Size	Package Weight	Key Features
	3173™	39984 39985 39986*	1 quart can 1 gallon pail 5 gallon pail	2.5 lbs. 10 lbs. 50 lbs.	General Purpose
	3182™	39995 39996* 39997*	1 gallon pail 5 gallon pail 55 gallon pail	12 lbs. 62 lbs. 625 lbs.	Fast Cure
HARDENERS	3183™	39998 39999*	1 gallon pail 5 gallon pail	7.5 lbs. 37 lbs.	General Purpose
	3184™	39398 39397*	1 gallon pail 5 gallon pail	12 lbs. 625 lbs.	Flame Retardant

\* Made-to-order items.

## DISPENSING OPTIONS

### Loctite® DuraPump™ Programmable Meter Mix System



### Loctite® DuraPump™ Pneumatic Meter Mix System



For more information, refer to the “Equipment” section or visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

LOCTITE® HYSOL® EPOXY KITS							
PRODUCT	Item Number	Package Type & Size	COLOR	WORKLIFE	HARDNESS (SHORE)	AGENCY APPROVALS	KEY FEATURES
E-60NC™	29324 29325 29326	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Black	60 minutes	85	CFIA	Electrically noncorrosive, low viscosity

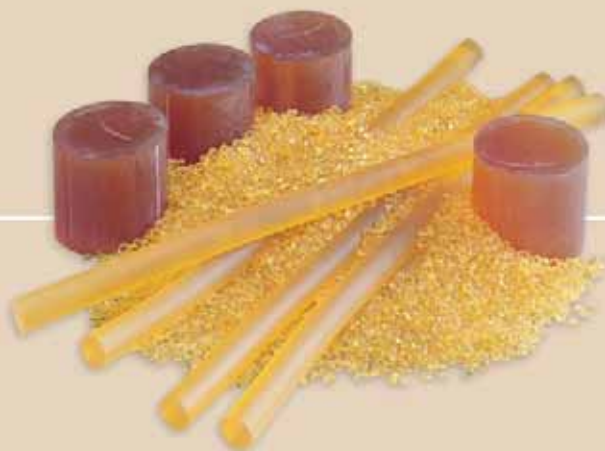
LOCTITE® HYSOL® POLYURETHANE SYSTEMS						
SYSTEM CHARACTERISTICS			3173™/3182™	3173™/3183™	3173™/3184™	
TYPICAL UNCURED PROPERTIES	VISCOSITY (cP)	Resin	75	75	75	
		Hardener	30,000	800	14,000	
		Mixed	5,500	450	2,250	
	WORKING TIME	73°F (23°C)	<7 minutes @ 300 g	20 to 40 minutes @ 105 g	150 minutes @ 300 g	
	GEL TIME	73°F (23°C)	14 minutes @ 300 g	40 to 70 minutes @ 105 g	150 minutes @ 300 g	
	CURE CYCLE	Normal 73°F (23°C)	90 minutes	24 hours	24 hours	
		Alternate 185°F (85°C)	30 minutes	1 to 3 hours	1 to 3 hours	
	MIX RATIO	By Weight (Resin:Hardener)	13 : 87	30 : 70	15 : 85	
		By Volume (Resin:Hardener)	1 : 5.2	1 : 3	1 : 4.8	
	COLOR	Resin	Dark Brown	Clear Brown	Clear Brown	
		Hardener	Black	Opaque Black	Opaque White	
		Mixed	Black	Opaque Black	Opaque White	
	SPECIFIC GRAVITY	Resin	1.23	1.23	1.23	
		Hardener	1.60	0.96	1.45	
		Mixed	1.55	1.06	1.40	
TYPICAL CURED PROPERTIES	Hardness, Shore A		75	70	80	
	Hardness, Shore 00		N/A	N/A	N/A	
	Tg (°C)		-10	-16	-15	
	CTE above Tg (m/mm°C)		128 x 10e-6	190 x 10e-6	151 x 10e-6	
TYPICAL CURED PROPERTIES	DIELECTRIC CONSTANT	0.1 kHz	4.68	5.92	4.51	
		1.0 kHz	4.02	4.36	4.29	
		10.0 kHz	3.76	3.65	3.94	
		100.0 kHz	3.63	3.31	3.56	
	DISSIPATION FACTOR	0.1 kHz	0.13	0.22	0.02	
		1.00 kHz	0.07	0.17	0.04	
		10.0 kHz	0.04	0.10	0.06	
		100.0 kHz	0.02	0.05	0.07	
	Insulation Resistance (ohms)		2.5x10e+13	1.1x10e+11	1.1x10e+12	
	Volume Resistivity (ohms/cm)		1.5x10e+15	6.83x10e+12	6.61x10e+13	
	Dielectric Strength (Volts/mil)		370	375	370	
	Flammability Rating		N/A	N/A	94V-Ø at 3/8"	
	UL File No. E106917		N/A	N/A	94V-2 at 1/4"	

SYSTEM CHARACTERISTICS			LOCTITE® 3140™ HYSOL® EPOXY SYSTEM					LOCTITE® 3141™ HYSOL® EPOXY SYSTEM				
			3140™/ 3160™	3140™/ 3162™	3140™/ 3163™	3140™/ 3164™	3140™/ 3165™	3141™/ 3160™	3141™/ 3162™	3141™/ 3163™	3141™/ 3164™	3141™/ 3165™
TYPICAL UNCURED PROPERTIES	VISCOSITY (cP)	Resin	11,000	11,000	11,000	11,000	11,000	80,000	80,000	80,000	80,000	80,000
		Hardener	180	120	450	105	55	180	120	450	105	55
		Mixed	1,700	2,000	1,500	1,500	2,000	7,000	5,000	4,000	6,000	13,000
	WORKING TIME	73°F (25°C)	80 to 100 min. @ 200 g	5 to 10 min. @ 100 g	80 to 100 min. @ 200 g	10 to 15 min. @ 400 g	1 to 1.5 hrs. @ 400 g	1.5 to 2 hrs. @ 400 g	5 min. @ 200 g	30 to 45 min. @ 200 g	10 min. @ 400 g	35 to 40 min. @ 200 g
	GEL TIME	73°F (25°C)	2.5 to 3 hrs. @ 200 g	10 to 15 min. @ 105 g	2.5 to 3 hrs. @ 200 g	25 to 35 min. @ 400 g	2 to 3 hrs. @ 400 g	2.5 to 3.5 hrs. @ 400 g	10 to 15 min. @ 200 g	60 to 80 min. @ 200 g	20 to 25 min. @ 200 g	65 to 75 min. @ 200 g
	CURE CYCLE	Normal 73°F (25°C)	24 hours	16 hours	24 hours	16 hours	24 hrs./77°F + 4 hrs./200°F	24 hours	24 hours	24 hours	24 hours	24 hrs./77°F + 4 hrs./200°F
		Alternate 150°F (60°C)	2 hours	1 hour	2 hours	2 hours	N/A	4 hours	2 hours	2 hours	2 hours	N/A
	MIX RATIO	By Weight (R:H)	100 : 20	100 : 18.1	100 : 29	100 : 29.5	100 : 9	4 : 1	100 : 19.8	100 : 30	100 : 31.5	100 : 9
		By Volume (R:H)	3.1 : 1	3.6 : 1	2 : 1	2 : 1	6.5 : 1	2.5 : 1	3 : 1	2 : 1	2 : 1	6.5 : 1
	COLOR	Resin	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
		Hardener	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Amber	Amber	Clear
		Mixed	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
	SPECIFIC GRAVITY	Resin	1.64	1.64	1.64	1.64	1.64	1.61	1.61	1.61	1.61	1.61
		Hardener	1.00	0.99	0.96	0.97	0.96	1.00	0.99	0.96	0.97	0.96
		Mixed	1.48	1.48	1.41	1.42	1.55	1.44	1.46	1.40	1.40	1.40
TYPICAL CURED PROPERTIES	Hardness, Shore D		80	80	80	70	85	85	90	80	85	85
	Tg (°C)		27	35	20	27	67	43	75	38	31	104
	CTE above Tg (mm/mm°C)		130x10e-6	125x10e-6	133x10e-6	150x10e-6	119x10e-6	160x10e-6	135x10e-6	138x10e-6	111x10e-6	115x10e-5
	CTE below Tg (mm/mm°C)		44x10e-6	37.5x10e-6	44.9x10e-6	82.6x10e-6	36.0x10e-6	60.7x10e-6	39.7x10e-6	52.6x10e-6	49.2x10e-6	35x10e-6
TYPICAL ELECTRICAL PROPERTIES	DIELECTRIC CONSTANT	0.1 kHz	4.43	4.25	4.61	4.2	4.87	4.30	3.91	3.58	4.11	4.28
		1.0 kHz	4.37	4.20	4.37	4	4.83	4.22	3.88	3.52	3.97	4.18
		10.0 kHz	4.31	4.16	4.20	3.8	4.75	4.14	3.84	3.46	3.87	4.06
		100.0 kHz	4.24	4.10	4.05	3.7	4.64	4.03	3.79	3.39	3.77	3.92
	DISSIPATION FACTOR	0.1 kHz	0.008	0.010	0.040	0.08	0.003	0.01	0.01	0.01	0.02	0.01
		1.0 kHz	0.008	0.011	0.027	0.04	0.007	0.01	0.01	0.01	0.02	0.02
		10.0 kHz	0.010	0.012	0.026	0.03	0.011	0.02	0.01	0.01	0.02	0.02
		100.0 kHz	0.014	0.013	0.023	0.03	0.014	0.02	0.01	0.02	0.02	0.02
	Insulation Resistance (ohms)		1.14x10e+13	2.67x10e+13	1.61x10e+12	7.5x10e+111	5.19x10e+13	5.72x10e+13	4.09x10e+13	1.23x10e+14	4.57x10e+13	2.15x10e+13
	Volume Resistivity (ohms/cm)		6.03x10e+14	2.53x10e+15	1.02x10e+14	1.5x10e+14	2.69x10e+15	4.03x10e+15	2.61x10e+15	7.41x10e+15	2.98x10e+15	1.37x10e+15
	Dielectric Strength (Volts/mil)		365	385	365	410	350	375	355	385	395	365
	Flammability Rating UL File No. E106917		N/A	N/A	N/A	UL 94B @ 1/16"	N/A	N/A	N/A	N/A	N/A	N/A
	Insulation System UL File No. E106917		N/A	N/A	N/A	UL 1446	N/A	N/A	N/A	N/A	N/A	N/A

SYSTEM CHARACTERISTICS			LOCTITE® 3142™ HYSOL® EPOXY SYSTEM					LOCTITE® 3145™ HYSOL® EPOXY SYSTEM				
			3142™ / 3160™	3142™ / 3162™	3142™ / 3163™	3142™ / 3164™	3142™ / 3165™	3145™ / 3160™	3145™ / 3162™	3145™ / 3163™	3145™ / 3164™	3145™ / 3165™
TYPICAL UNCURED PROPERTIES	VISCOSITY (cP)	Resin	95,000	95,000	95,000	95,000	95,000	32,760	32,760	32,760	32,760	32,760
		Hardener	180	120	450	105	55	180	120	450	105	55
		Mixed	7,500	6,000	7,000	8,000	18,000	5,560	7,150	5,315	5,790	13,355
	WORKING TIME	77°F (25°C)	1.5 to 2 hrs. @ 400 g	5 to 10 min. @ 200 g	2 hrs. @ 400 g	25 min. @ 400 g	80 min. @ 400 g	2.5 to 4 hrs. @ 200 g	15 to 30 min. @ 200 g	3 to 3.5 hrs. @ 200 g	35 to 45 min. @ 200 g	2.5 to 3 hrs. @ 400 g
	GEL TIME	77°F (25°C)	3.5 to 4 hrs. @ 400 g	5 to 30 min. @ 200 g	> 3 hrs. @ 400 g	50 min. @ 400 g	2.5 hrs. @ 400 g	6 to 8 hrs. @ 200 g	35 to 45 min. @ 200 g	6 to 7 hrs. @ 200 g	75 to 90 min. @ 200 g	5 hrs. @ 200 g
	CURE CYCLE	Normal 77°F (25°C)	24 hrs.	24 hrs.	48 hrs.	24 hrs.	24 hrs./77°F + 4 hrs./200°F	24 hrs.	24 hrs.	24 hrs.	24 hrs.	24 hrs./77°F + 2 hrs./200°F
		Alternate 150°F (66°C)	4 hrs.	2 hrs.	4 hrs.	2 hrs.	4 hrs./+200°F	2 hrs.	2 hrs.	4 hrs.	2 hrs.	4 hrs./+200°F
	MIX RATIO	By Weight (R:H)	100 : 10.7	100 : 9	100 : 10.9	100 : 14.3	100 : 4.1	100 : 15	100 : 13	100 : 15.5	100 : 20	100 : 6
		By Volume (R:H)	3.8 : 1	4.5 : 1	3.6 : 1	2.8 : 1	9.7 : 1	4 : 1	4.5 : 1	3.7 : 1	2.9 : 1	9.7 : 1
	COLOR	Resin	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
		Hardener	Clear	Clear	Amber	Amber	Clear	Clear	Clear	Clear	Clear	Clear
		Mixed	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
	SPECIFIC GRAVITY	Resin	2.40	2.40	2.40	2.40	2.40	1.67	1.67	1.67	1.67	1.67
		Hardener	1.00	0.99	0.96	0.97	0.96	1.00	0.99	0.96	0.97	0.96
		Mixed	1.54	1.54	1.53	1.50	1.62	1.51	1.54	1.49	1.49	1.58
TYPICAL CURED PROPERTIES	Hardness, Shore D		90	90	90	85	90	80	84	80	75	88
	Tg (°C)		26	42	30	29	84	28	42	38	32	53
	CTE above Tg (mm/mm°C)		104x10e-6	97.2x10e-6	96.1x10e-6	106x10e-6	87.7x10e-6	1.22x10e-6	128x10e-6	130x10e-6	122x10e-6	111x10e-6
	CTE below Tg (mm/mm°C)		29.2x10e-6	28.2x10e-6	33.5x10e-6	51.9x10e-6	26.9x10e-6	39.2x10e-6	42.6x10e-6	49.0x10e-6	59.4x10e-6	40.6x10e-6
	THERMAL CONDUCTIVITY	Watts/Meter°C	0.422	1.40	1.40	1.27	1.14	0.7935	0.8068	0.8119	0.7324	1.0341
TYPICAL ELECTRICAL PROPERTIES	DIELECTRIC CONSTANT	0.1 kHz	5.77	4.87	5.28	5.51	5.65	4.08	3.81	4.27	4.19	4.43
		1.0 kHz	5.69	4.83	5.20	5.35	5.57	4.28	3.85	4.36	4.46	4.45
		10.0 kHz	5.62	4.78	5.12	5.21	5.46	4.15	3.74	4.11	4.22	4.28
		100.0 kHz	5.52	4.72	5.02	5.06	5.34	4	3.63	3.90	3.99	4.11
	DISSIPATION FACTOR	0.1 kHz	0.00	0.01	0.01	0.02	0.01	0.027	0.028	0.033	0.036	0.045
		1.0 kHz	0.001	0.01	0.01	0.02	0.01	0.031	0.025	0.046	0.042	0.036
		10.0 kHz	0.01	0.01	0.01	0.02	0.01	0.025	0.021	0.037	0.037	0.027
		100.0 kHz	0.01	0.01	0.01	0.02	0.01	0.023	0.017	0.031	0.034	0.024
	Insulation Resistance (ohms)		4.61x10e+13	5.31x10e+13	3.65x10e+13	2.75x10e+12	4.09x10e+13	Not Tested	Not Tested	Not Tested	Not Tested	Not Tested
	Volume Resistivity (ohms/cm)		3.00x10e+15	3.47x10e+15	2.55x10e+15	1.65x10e+14	2.61x10e+15	1.10e+14	8.4e+14	2.1e+14	2.5e+13	7.3e+14
	Dielectric Strength (Volts/mil)		360	345	355	345	335	595	693	748	695	794
	Flammability Rating UL File No. E106917		N/A	N/A	N/A	N/A	N/A	N/A	UL 94V-0 @ 1/8"	N/A	N/A	UL 94V-0 @ 1/8"



# Hot Melts & Silicones



## HOT MELT ADHESIVES

In addition to structural bonding, Loctite® Hysol® hot melt adhesives are also well-suited for fast, deep potting applications requiring large gap fills in a high speed manufacturing environment.

### LOCTITE® 1942™ HYSOL® HOT MELT ADHESIVE

#### General Purpose

Medium setting, general purpose hot melt adhesive. Excellent adhesion to wood and many plastics.



### LOCTITE® 7901™ HYSOL® HOT MELT ADHESIVE

#### Polyamide

Low viscosity polyamide used extensively for potting and encapsulating.

## SILICONE POTTING COMPOUNDS

Loctite® silicones are single-component, tough, protective potting and encapsulating compounds that seal components against moisture, solvents, and environmental conditions. Loctite® Nuva-Sil® products cure in as little as 30 seconds to depths of 0.150" when exposed to UV light or visible light, while Loctite® RTV silicones cure in 24 hours at room temperature when exposed to atmospheric moisture.

### LOCTITE® 5031™ NUVA-SIL® SILICONE POTTING COMPOUND

#### High Adhesion / Visible Light

A low viscosity, self-leveling, UV or visible light curing silicone for high speed deep potting, coating and sealing applications. Provides high adhesion for difficult-to-bond substrates.

### LOCTITE® 5040™ RTV SILICONE POTTING COMPOUND

A noncorrosive, self-leveling RTV silicone for shallow potting, sealing and coating of devices, especially for military and industrial applications.


## DISPENSING OPTIONS

**Loctite® Hysol™ Bulk-34 System** is a compact and efficient bulk hot melt unit capable of manual or automatic product delivered up to 75 lbs./hr. This CE certified unit has three independent temperature controls for the tank, hosing and dispense valves that will provide an effective extrusion or spray application for a wide range of hot melt adhesives. For a complete listing of hoses, valves and other accessories to configure a complete system, please see the *Loctite® Equipment Sourcebook*, LT-3669, or visit us at [www.equipment.loctite.com](http://www.equipment.loctite.com), or call 1-800-LOCTITE (562-8483)

**Item Number:** 98135      **Voltage:** 230  
**Standard Tank Capacity:** 34 lbs. (15.4 kg)



## Loctite® Hysol® Hot Melt Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	VISCOSITY (cP) AT DISPENSE TEMPERATURE	TENSILE STRENGTH (psi)	OPEN TIME	TEMPERATURE RESISTANCE	% ELONGATION	HARDNESS (SHORE A)	AGENCY APPROVALS
<b>1942™ Hysol®</b>	83266 83267 83269 83271 83272 83274 83275 83277	5 lb. sample bag pellets 40 lb. carton pellets Maxistick™ 35 lb. carton PT™ stick 36 lb. carton Ministick™ 35 lb. carton Superstick™ 10" 25 lb. bag Superstick™ 4" 25 lb. carton Polyshot™ 35 lb. Carton	Tan	5,000	250	30 seconds	142°F	500	N/A	FDA CFR175,105
<b>3650™ Hysol®</b>	31302 31297	22 lb. pellets 44 lb. pellets	Light Beige	2,900	305	60 to 80 seconds	176°F	43	87	N/A
<b>3651™ Hysol®</b> 	<b>31303</b>	<b>26.4 lb. squares</b>	<b>Beige</b>	<b>10,000</b>	<b>334</b>	<b>80 to 100 seconds</b>	<b>266°F</b>	<b>790</b>	<b>55</b>	<b>N/A</b>
<b>7809FR™ Hysol®</b>	83388	5 lb. sample bag pellets	Amber	7,000	363	35 seconds	240°F	373	85	UL Classified for U.S.
<b>7811™ Hysol®</b>	83337 83339 83340	5 lb. sample bag pellets Polyshot™ 13 oz. sample bag Polyshot™ 25 lb. pail	Amber	6,400	400	35 seconds	266°F	1,200	N/A	N/A
<b>7901™ Hysol®</b>	83341 83342 83344	5 lb. sample bag pellets 40 lb. carton pellets Polyshot™ 25 lb. pail	Amber	750	260	35 seconds	300°F	80	84	N/A

## Loctite® Silicone Potting Compounds Properties Chart

PRODUCT	Item Number	Package Type & Size	CURE SCHEDULE (CURE / ALT. CURE)	VISCOSITY (cP)	GEL TIME	HARDNESS	AGENCY APPROVALS
<b>5031™ Nuva-Sil®</b>	40086 40087	300 ml cartridge 40 lb. pail	UV / visible light / moisture 60 seconds @ 40 mW/cm <sup>2</sup>	5,500	Seconds	34 Shore A	N/A
<b>5040™</b>	40405 40404 40407	85 g tube 300 ml cartridge 40 lb. pail	Moisture 24 hours @ 25°C	35,000	<3 hours (skin over)	30 Shore A	MIL-A-46146B
<b>5091™ Nuva-Sil®</b>	17412 18074	300 ml cartridge 40 lb. pail	UV / moisture 60 seconds @ 40 mW/cm <sup>2</sup>	5,500	Seconds	34 Shore A	UL Classified for U.S.

# Repairing, Rebuilding & Restoring

## ***Choosing a repair epoxy***

When choosing a repair epoxy, there are several factors to consider, the most important of which is substrate. Loctite® Fixmaster® repair epoxies are designed to optimize performance on various substrates. The coefficient of thermal expansion differs from one metal to the next; matching the correct product to each substrate will make a big impact on the integrity of the repair. The application and service environment are important to consider because machinability and corrosion resistance differ between the products.

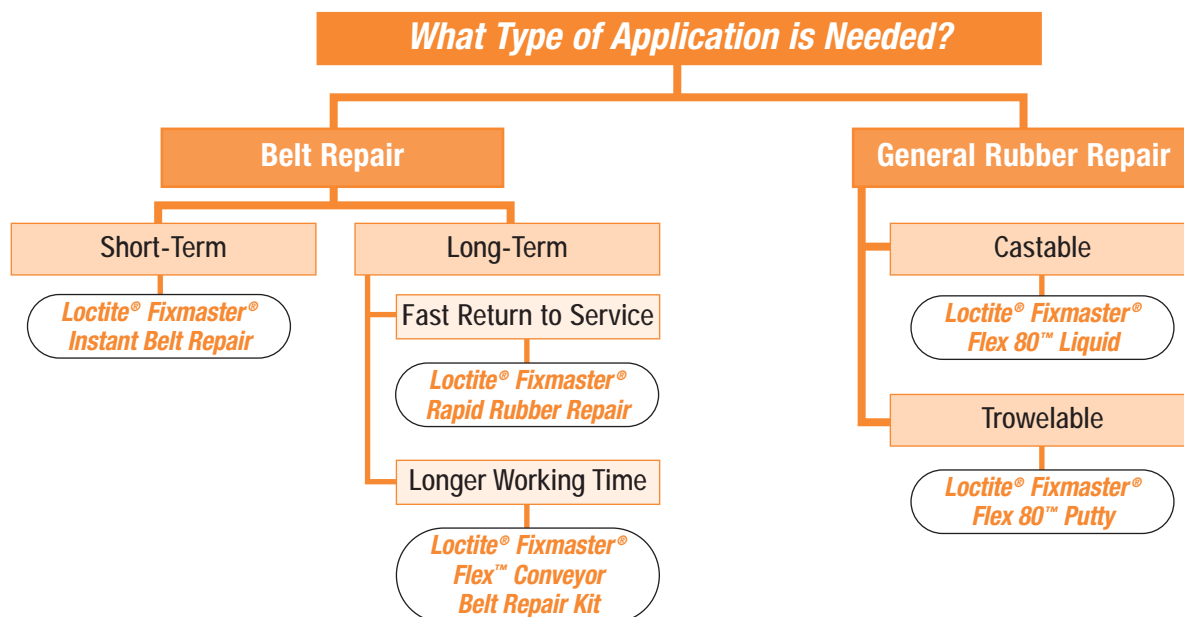
## ***What is the proper surface preparation for repair epoxies?***

A properly prepared surface is one that has been cleaned, dried, and abraded. Substrates should be free from contamination including oils, grease, dust, etc. It is also important that a surface is dry\* before working with a repair epoxy, because moisture on the surface can interfere with the curing process. The final component is to abrade the surface, which provides an increased surface area for bonding. When working with metals, the surface should be abraded to a near white metal finish, which also helps to ensure that all surface corrosion is removed.

Loctite® Adhesives and Sealants Product Specialists are available to assist you. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **[www.loctite.com](http://www.loctite.com)** and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

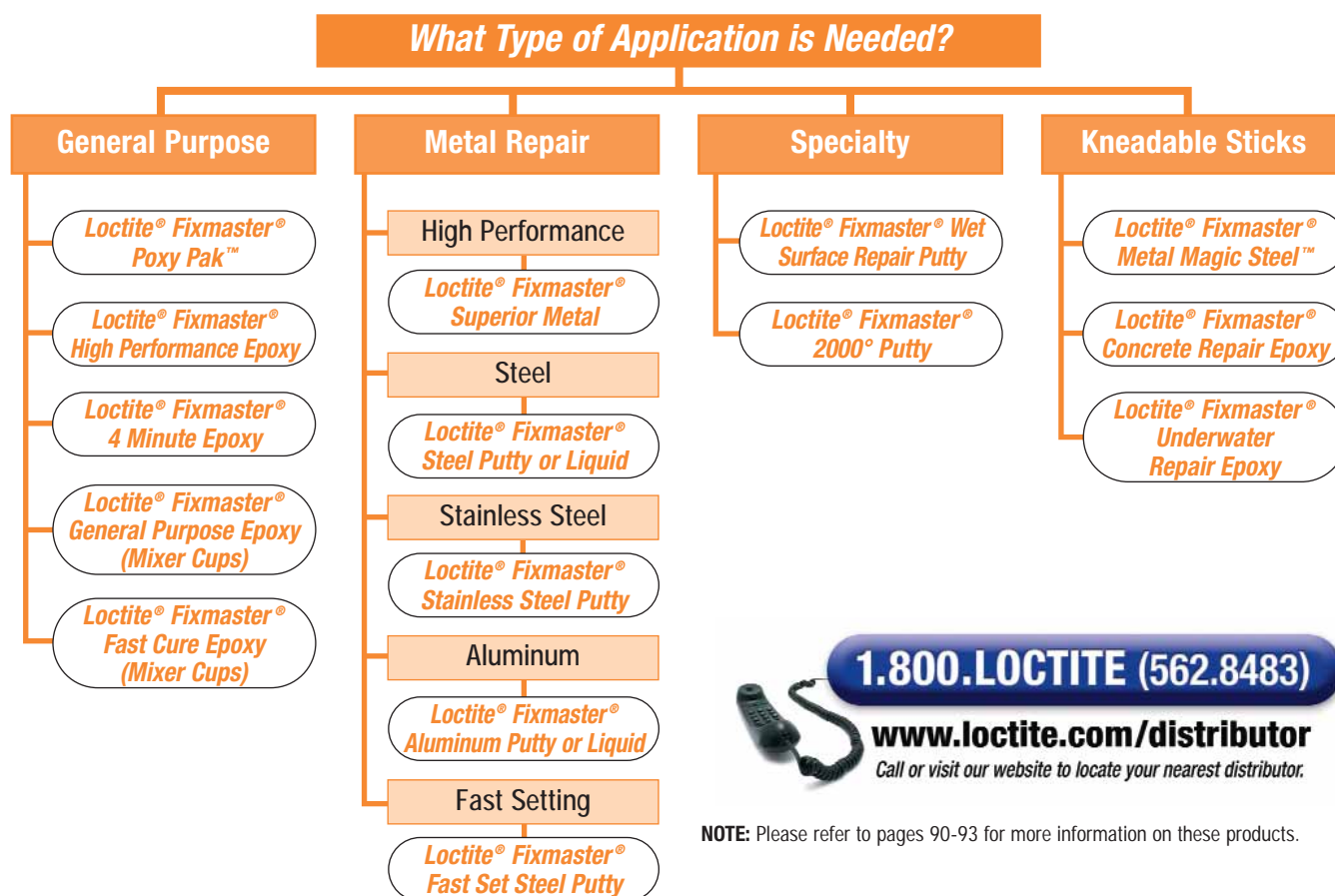
\* Loctite® Fixmaster® Wet Surface Repair Putty & Loctite® Fixmaster® Underwater Repair Epoxy have been specially formulated to cure in wet or underwater applications.

## Belt Repair & Urethanes Selector Guide



NOTE: Please refer to pages 88 and 89 for more information on these products.

## Loctite® Maintenance & Repair Epoxies Selector Guide



NOTE: Please refer to pages 90-93 for more information on these products.



# Belt Repair & Urethanes

Loctite® Fixmaster® belt repair products are urethanes designed for durable, tough, and flexible repairs of conveyor belts and other damaged rubber equipment quickly and easily. Loctite® Fixmaster® urethanes are two-component repair materials that can be troweled, cast, or brush-applied to rebuild or protect critical operating equipment. Tough rubber-like properties provide protection from impact, abrasion, and corrosion. Loctite® Fixmaster® urethanes are non-shrinking and unaffected by oil, grease, and water. Use of the recommended accessory products ensures maximum adhesion and product reliability.

## BELT REPAIR

### LOCTITE® FIXMASTER® RAPID RUBBER REPAIR

Our premium quality, belt repair product is designed to repair conveyor belts and other damaged rubber equipment quickly and easily. Repairs will have the same durability and flexibility as the belt. The 400 ml cartridge requires the use of a Loctite® Rapid Rubber Repair Dispenser. The 400 ml kit contains a 400 ml cartridge, etching agent, cleaner, brushes, and plastic trowels.

### LOCTITE® FIXMASTER® FLEX™ CONVEYOR BELT REPAIR KIT

Makes long lasting belt repairs. Recommended for applications where speed of application is not critical. Cures in 8 to 12 hours. Kit includes resin, hardener, cleaner, etching agent, brushes, and plastic trowels.

### LOCTITE® FIXMASTER® INSTANT BELT REPAIR

A single-component, heat-curing material for fast, temporary belt repairs. Requires no priming. Equipment can be operated in 30 minutes.

## GENERAL RUBBER REPAIR

### LOCTITE® FIXMASTER® FLEX 80™ PUTTY

A trowelable, two-part urethane for rebuilding and repairing rubber parts and linings, providing impact-, abrasion-, and corrosion-resistant protection.

### LOCTITE® FIXMASTER® FLEX 80™ LIQUID

A castable, two-part urethane for making molds, fixtures, expansion joints, and non-scratching holding fixtures.

## Loctite® Belt Repair Accessories

PRODUCT	Item Number	Package Type & Size	COVERAGE	COLOR
<b>Flex™ Metal Primer</b> <i>Promotes adhesion to metal parts</i>	98471	3.3 fl. oz. can	Approximately 1 can of each product for 2 lbs. of urethane	Clear
<b>Etching Agent</b> <i>Enhances bonds to rubber</i>	99626	3 fl. oz. bottle		Clear
<b>Flex™ Cleaner</b> <i>Cleans and primes surfaces</i>	39636	4 fl. oz. can	N/A	Clear

## DISPENSING OPTIONS

**Loctite® Fixmaster® Rapid Rubber Repair Dispenser** is a handheld, manually operated dispenser designed specifically for use with Loctite® Fixmaster® Rapid Rubber Repair, a two-part adhesive packaged in 400 ml cartridges.

For all available nozzles, accessories, and package sizes, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 39635





## Helpful Hints

- Loctite® Fixmaster® Instant Belt Repair is a hot melt adhesive and requires heat for application.
- Loctite® Fixmaster® Flex 80™ Liquid can be used as a flexible joint sealant where a black color is desired.

## Loctite® Fixmaster® Belt Repair & Urethane Properties Chart

PRODUCT		Item Number	Package Type & Size	COLOR	COVERAGE (IN. <sup>2</sup> AT 1/4" THICKNESS)	MAXIMUM OPERATING TEMPERATURE (°F)	ADHESIVE TENSILE STRENGTH (psi)	% ELONGATION	HARDNESS (SHORE A)	WORKING TIME (MINUTES)	FUNCTIONAL CURE (HOURS)	MIX RATIO BY VOLUME (RESIN:HARDENER)	MIX RATIO BY WEIGHT (RESIN:HARDENER)	AGENCY APPROVALS
BELT REPAIR	Fixmaster® Rapid Rubber Repair	96677 96675 96676	400 ml kit 400 ml cartridge 150 ml coaxial cartridge	Black	88 88 33	180	1,300	360	82	1	2	1:1	N/A	N/A
	Fixmaster® Flex™ Conveyor Belt Repair Kit	98693	1 lb. kit	Black	94	180	1,500	350	87	10	8	100:40	72:28	N/A
	Fixmaster® Instant Belt Repair	37719	1 lb. kit	Yellow	115	150	400	650	65	N/A	30 min.	N/A	N/A	N/A
GENERAL RUBBER REPAIR	Fixmaster® Flex 80™ Putty	97423 97422	1 lb. kit 6 lb. kit	Black	94 564	180	1,500	350	87	10	8	100:40	72:28	ABS
	Fixmaster® Flex 80™ Liquid	97413 97412	1 lb. kit 6 lb. kit	Black	27 in. <sup>3</sup> 162 in. <sup>3</sup>	180	1,800	350	87	20	8	100:13.3	77:23	N/A
BELT REPAIR ACCESSORIES	Fixmaster® Rapid Rubber Repair Dispenser	39635	Required for use with 400 ml cartridge of Loctite® Fixmaster® Rapid Rubber Repair (39635 is not included in the 96677 kit, and must be ordered separately.)											
	Fixmaster® Rapid Rubber Repair Static Mixers	39633	Packaged 6/bag – for mixing and dispensing Loctite® Fixmaster® Rapid Rubber Repair in a 400 ml cartridge.											

Properties based on mixing a 1 lb. unit at 77°F, 7 days cure.

## Loctite® Fixmaster® Belt Repair & Urethane Application Chart

PRODUCT	CASTING MOLDS, FIXTURES, PARTS	CONVEYOR BELT REPAIR (LONG-TERM)	CONVEYOR BELT REPAIR (TEMPORARY)	COATING IMPELLERS, FEEDER BOWLS	CHUTES, HOPPERS, DEFLECTION PLATES	REBUILDING RUBBER PARTS	LINING PUMPS	FORMING EXPANSION JOINTS
Fixmaster® Rapid Rubber Repair		●					●	●
Fixmaster® Flex™ Conveyor Belt Repair Kit		●						
Fixmaster® Instant Belt Repair			●					
Fixmaster® Flex 80™ Putty	●				●	●	●	
Fixmaster® Flex 80™ Liquid	●			●				●

● Preferred Choice    ● Good Choice

# Maintenance & Repair Epoxies



## EPOXY STICKS

### LOCTITE® FIXMASTER® METAL MAGIC STEEL™

Steel epoxy in stick form. Cut off a section, knead, and apply to leaking pipes or damaged equipment. Cures in 10 minutes. NSF 61 approved for potable water applications.



### LOCTITE® FIXMASTER® CONCRETE REPAIR EPOXY



Enables permanent repairs to concrete and masonry. Convenient stick contains pre-measured portions of activator and base. Once cured, it can be tapped, drilled, screwed, sawed, filed or painted, and will have an appearance and texture similar to concrete.

### LOCTITE® FIXMASTER® UNDERWATER REPAIR EPOXY

This putty-like material is ideal for plumbing, irrigation and marine applications because it is unaffected by chlorinated or salt water. Will stick to wet surfaces. Ideally suited for underwater repairs. Sets in 15 minutes.

## POURABLE METAL-FILLED EPOXIES

### LOCTITE® FIXMASTER® STEEL LIQUID

Pourable and self-leveling, steel-filled epoxy. Ideal for casting or making molds. Works well to fill hard-to-reach areas. Can be machined when cured. Sets in 25 minutes.

### LOCTITE® FIXMASTER® ALUMINUM LIQUID

Similar to Loctite® Fixmaster® Steel Liquid, but aluminum filled. Sets in 20 minutes.

## TROWELABLE METAL - FILLED EPOXIES

### LOCTITE® FIXMASTER® SUPERIOR METAL

Non-rusting, ferro-silicone-filled epoxy. Extremely high compressive strength and wear resistance. Ideal for rebuilding worn surfaces exposed to harsh environments. Can be machined, drilled and tapped in 6 to 8 hours. For final finish cuts, let the product cure for 24 hours and use carbide tooling. Spreadable putty. Sets in 20 minutes.



### LOCTITE® FIXMASTER® STEEL PUTTY

Non-slumping, two-part, steel-filled putty. Ideally suited for rebuilding steel surfaces. Can be machined when cured. Sets in 30 minutes.

### LOCTITE® FIXMASTER® ALUMINUM PUTTY

Similar to Loctite® Fixmaster® Steel Putty, but aluminum filled to better match the coefficient of thermal expansion of aluminum. Sets in 20 minutes.

### LOCTITE® FIXMASTER® STAINLESS STEEL PUTTY

Similar to Loctite® Fixmaster® Steel Putty, but stainless steel filled to better match the coefficient of thermal expansion of stainless steel. Sets in 20 minutes.

### LOCTITE® FIXMASTER® FAST SET STEEL PUTTY

Faster setting version of the Loctite® Fixmaster® Steel Putty. Sets in 3 minutes.





### GENERAL PURPOSE EPOXIES

#### LOCTITE® FIXMASTER® POXY PAK™

This fast cure, general purpose epoxy bonds virtually any material. It will also fill or seal cracks and rebuild worn surfaces. Comes in a 1 oz. syringe with a built-in plunger for easy dispensing without equipment. Working time is approximately 4 minutes.

#### LOCTITE® FIXMASTER® 4-MINUTE EPOXY

Cartridge-based, general purpose, two-part epoxy. Ideal for emergency repairs or where fast cure time is required. Sets in 5 minutes. Requires handheld dispenser (P/N 98472) and mix nozzle (P/N 98455).

#### LOCTITE® FIXMASTER® GENERAL PURPOSE EPOXY (MIXER CUPS)

Premeasured epoxy mixer cups. One-hour working time. Fills porosity and cracks. Ideally suited for applications that only require a small amount of epoxy. Adheres to metal, glass, wood, and hard plastics. Sets in 60 minutes.

#### LOCTITE® FIXMASTER® FAST CURE EPOXY (MIXER CUPS)

Faster setting version of Loctite® Fixmaster® General Purpose Epoxy. Sets in 5 to 15 minutes.

### HIGH PERFORMANCE

#### LOCTITE® FIXMASTER® HIGH PERFORMANCE EPOXY

Fiberglass-reinforced epoxy offering exceptional shock resistance and outstanding tensile strength. Ideal for making tough permanent bonds on metals, wood, glass, and hard plastics. Comes in a 50 ml cartridge, 1 oz. syringe and a 2 gallon container. The cartridge requires the handheld dispenser (P/N 98472). Cartridge comes bundled with one mix nozzle. Sets in 30 minutes.

#### LOCTITE® FIXMASTER® FAST SET STEEL EPOXY

Cartridge-based, steel-filled epoxy. Makes fast, cost-effective repairs. Easy-to-use and easy-to-apply. Ideal for metal parts that must be back in service quickly. Can be machined when cured. Requires the handheld dispenser (P/N 98472). One mix nozzle comes included with the cartridge. Sets in 3 minutes.

#### LOCTITE® FIXMASTER® WEAR RESISTANT PUTTY

Ceramic fibers give this trowelable putty excellent wear and abrasion resistant properties. Cures to a smooth, low friction surface. For surfaces exposed to wear, erosion, and cavitation.

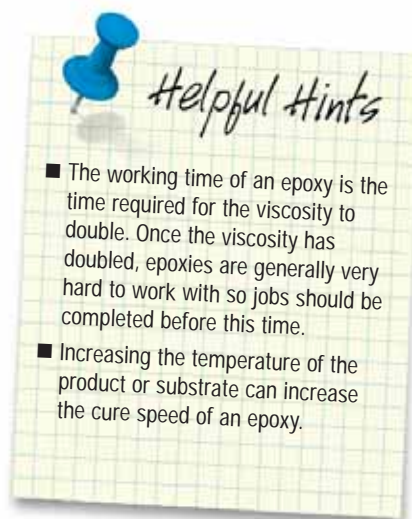
### SPECIALTY PRODUCTS

#### LOCTITE® FIXMASTER® WET SURFACE REPAIR PUTTY

Use this unique, trowelable epoxy to repair and rebuild wet, even underwater surfaces. Bonds to most metals, concrete, and some plastics.

#### LOCTITE® FIXMASTER® 2000° PUTTY

Single-component putty designed to fill and restore damaged metal and fill cracks in environments that will see 2000°F. Water-based and non-toxic. Typical applications include header, manifold and cast iron repair.



### Loctite® Fixmaster® Superior Metal 6-Step Process



STEP 1: Clean completely.



STEP 2: Gather product.



STEP 3: Prepare product.



STEP 4: Mix completely.






STEP 5: Apply.



STEP 6: Set.



# Loctite® Fixmaster® Maintenance & Repair Epoxies Properties Charts

PRODUCT		Item Number	Package Type & Size	COLOR	COVERAGE (FT. <sup>2</sup> AT 1/4" THICKNESS)	MAXIMUM TEMPERATURE† (°F)	COMPRESSIVE STRENGTH (psi)†	TENSILE SHEAR STRENGTH† (psi)	HARDNESS (SHORE D)	WORKING TIME	FUNCTIONAL CURE	MIX RATIO BY VOLUME	MIX RATIO BY WEIGHT	AGENCY APPROVALS
EPOXY STICKS	Fixmaster® Metal Magic Steel™* 	98853	4 oz. stick	Grey	7 in. <sup>2</sup>	250	12,000	2,500	80	3 minutes	10 minutes	N/A	N/A	NSF 61
	Fixmaster® Concrete Repair Epoxy <sup>§</sup> 	39366	4 oz. stick	Grey	7 in. <sup>2</sup>	250	12,000	600	80	4 to 7 minutes	10 minutes	N/A	N/A	N/A
	Fixmaster® Underwater Repair Epoxy <sup>§</sup>	82093	4 oz. stick	White	7 in. <sup>2</sup>	300	12,000	900	70	15 minutes	30 minutes	N/A	N/A	CFIA
POURABLE	Fixmaster® Steel Liquid*	97483 97484	1 lb. kit 4 lb. kit	Grey	13 in. <sup>3</sup> 52 in. <sup>3</sup>	225	13,500	6,000	86	25 minutes	6 hours	4:1	9.5:1	ABS, CFIA, NEHC, NAVSEA
	Fixmaster® Aluminum Liquid*	97453	1 lb. kit	Aluminum	17 in. <sup>3</sup>	200	17,000	6,000	85	20 minutes	6 hours	5:1	9:1	ABS, CFIA, NEHC, NAVSEA
TROWELABLE	Fixmaster® Superior Metal* 	97473 40900	1 lb. kit 4 kg kit	Dark Grey	0.25 2.2	250	18,000	5,500	90	20 minutes	6 hours	4:1	7.25:1	CFIA
	Fixmaster® Steel Putty*	99913 99914 99912	1 lb. kit 4 lb. kit 25 lb. kit	Grey	0.3 1.2 7.5	225	11,100	4,900	85	30 minutes	6 hours	2.5:1	6.25:1	ABS, CFIA, NEHC, NAVSEA
	Fixmaster® Aluminum Putty*	97463	1 lb. kit	Aluminum	0.5	200	11,300	4,000	87	20 minutes	6 hours	4:1	6.3:1	ABS, CFIA, NEHC, NAVSEA
	Fixmaster® Stainless Steel Putty*	97443	1 lb. kit	Grey	0.25	225	12,000	4,600	85	20 minutes	6 hours	4:1	9:1	ABS, CFIA, NEHC, NAVSEA
	Fixmaster® Fast Set Steel Putty*	39917	1 lb. kit	Grey	0.4	200	10,800	4,600	80	3 minutes	10 minutes	1:1	1.8:1	ABS, CFIA, NEHC, NAVSEA

PRODUCT		Item Number	Package Type & Size	COLOR (CURED)	TEMPERATURE RESISTANCE (°F)	TENSILE SHEAR STRENGTH (psi)	WORKLIFE	FIXTURE TIME ‡	FULL CURE (HOURS)	AGENCY APPROVALS
GENERAL PURPOSE	Fixmaster® Poxypak™ <sup>§</sup>	81120	1 oz. syringe	Clear	300	2,300	1 minutes	5 to 8 minutes	1	ABS, CFIA, NEHC, NAVSEA
	Fixmaster® 4-Minute Epoxy <sup>§</sup>	97434	50 ml cartridge	Translucent	160	2,000	3 to 4 minutes	10 minutes	1	N/A
	Fixmaster® General Purpose Epoxy <sup>§</sup> (Mixer Cups)	21427	10 – 0.12 fl. oz. cups	Translucent	180	2,000	60 minutes	1.5 hours	24	CFIA
	Fixmaster® Fast Cure Epoxy (Mixer Cups) <sup>§</sup>	21425 21426 39088	10 – 0.12 fl. oz. cups 10 – 1 oz. cups 4 – 0.12 fl. oz. cups	Grey	180	2,000	5 minutes	10 minutes	12	CFIA
HIGH PERFORMANCE	Fixmaster® High Performance Epoxy <sup>§</sup>	99393 99394 99392	1 oz. syringe 50 ml cartridge 2 gallon kit	Tan	180	3,800	30 minutes	8 hours	24	CFIA
	Fixmaster® Fast Set Steel Epoxy*	96604	50 ml cartridge	Grey	200	2,600	3 minutes	6 to 8 minutes	7	CFIA
	Fixmaster® Wear Resistant Putty*	98742 98743	1 lb. kit 3 lb. kit	Grey	225	4,900	30 minutes	1 hour	6	ABS, CFIA, NEHC, NAVSEA
SPECIALTY PRODUCTS	Fixmaster® Wet Surface Repair Putty*	96583	1 lb. kit	Grey	150	3,500	30 minutes	1 hour	18	ABS, NEHC, NAVSEA
	Fixmaster® 2000° Putty*	95724	8 oz. can	Grey	2000	675	30 minutes	1 hour	7	N/A
APPLICATORS	Manual Cartridge Applicator	98472	Required for use with Loctite® Fixmaster® 50 ml cartridges. (98455 is also required and must be ordered separately.) For more information on spare parts, nozzles and accessories, please visit <a href="http://www.equipment.com">www.equipment.com</a> .							
	Static Mix Nozzles	98455	Packaged 10/bag – for mixing and dispensing Loctite® Fixmaster® 50 ml cartridges For more information on spare parts, nozzles and accessories, please visit <a href="http://www.equipment.com">www.equipment.com</a> .							

\* Properties are based on mixing one lb. mass at 77°F, 7 days cure.

§ Properties based on ultimate cure. Epoxy properties based on mixing 20 g mass at 77°F.




† Ultimate cure.

‡ Time to reach handling strength.



Indicates TOP CHOICE products.

## Loctite® Fixmaster® Maintenance & Repair Epoxies Application Chart

PRODUCT		EMERGENCY METAL REPAIRS	CORROSION PROTECTION	REPAIRING PIPES AND TANKS	REBUILDING SHAFTS, KEYWAYS AND BEARINGS	REPAIRING THREADED PARTS	RESTORING TUBE SHEETS	PUMP REPAIR	REPAIRING ENGINE BLOCKS	FIXTURES AND PROTOTYPES	REBUILDING IMPELLERS AND VALVES	REPAIRING ALUMINUM PARTS	REPAIRING STAINLESS STEEL PARTS	FORMING MOLDS AND FIXTURES	WET SURFACE REPAIRS
EPOXY STICKS	Fixmaster® Metal Magic Steel™ 	●		○						●				●	○
	Fixmaster® Concrete Repair Epoxy 	○								○					○
	Fixmaster® Underwater Repair Epoxy	○		○											●
POURABLE	Fixmaster® Steel Liquid			●		●				○				●	
	Fixmaster® Aluminum Liquid									●		●	○	●	
TROWELABLE	Fixmaster® Superior Metal 		●		●	●	●	●	●		●				
	Fixmaster® Steel Putty			●					●		○			●	
	Fixmaster® Aluminum Putty		○								●	●	○		
	Fixmaster® Stainless Steel Putty		○								●	○	●		
	Fixmaster® Fast Set Steel Putty	●		●					○						

## Loctite® Fixmaster® Maintenance & Repair Epoxies Bonding Characteristics

PRODUCT		GAP FILLING	FAST CURE TIME	FERROUS METAL REPAIR	TOUGHENED FORMULATION	SHOCK RESISTANT	WATER RESISTANT	PLASTIC BONDING	RUBBER BONDING	METAL BONDING	SANDABLE FINISH	PRINTABLE FINISH
GENERAL PURPOSE	Fixmaster® Poxy Pak™		●					○		○	●	●
	Fixmaster® 4-Minute Epoxy	●	●	○		○	○	○		○	●	●
	Fixmaster® General Purpose Epoxy (Mixer Cups)	○						○	○	○	●	○
	Fixmaster® Fast Cure Epoxy (Mixer Cups)	○	○					○	○	○	●	○
HIGH PERFORMANCE	Fixmaster® High Performance Epoxy	●		○	●	●	●	○	○	●	●	●
	Fixmaster® Fast Set Steel Epoxy	○	●	●						○	●	○
	Fixmaster® Wear Resistant Putty	●			●	●	○					○
SPECIALTY PRODUCTS	Fixmaster® Wet Surface Repair Putty	●					●					○
	Fixmaster® 2000® Putty	●		●							○	○

● Preferred Choice    ○ Good Choice    ○ Acceptable Choice

# Retaining

## ***Choosing a retaining compound***

Retaining compounds are typically used to join non-threaded cylindrical assemblies made of some sort of metal. Metals can be designated as active or inactive. Active metals (carbon steel, copper, or bronze) will typically corrode faster than inactive metals (stainless steel, plated parts, or anodized aluminum). When working with inactive metals, it is generally recommended that a primer be used to increase the cure speed of the retaining compound.

New Loctite® retaining compounds have historically been formulated as liquids due to their reactivity to ensure they remain stable and ready to use. Recent breakthroughs have led to the development of a stable, semisolid stick formulation. This has opened the door to applications where the liquids were considered too messy or inconvenient. This new semisolid formulation allows direct contact of the compound to the part. This ensures not only that the product is placed exactly where it is needed, but also that it stays there as the cylindrical assembly is positioned and assembled.

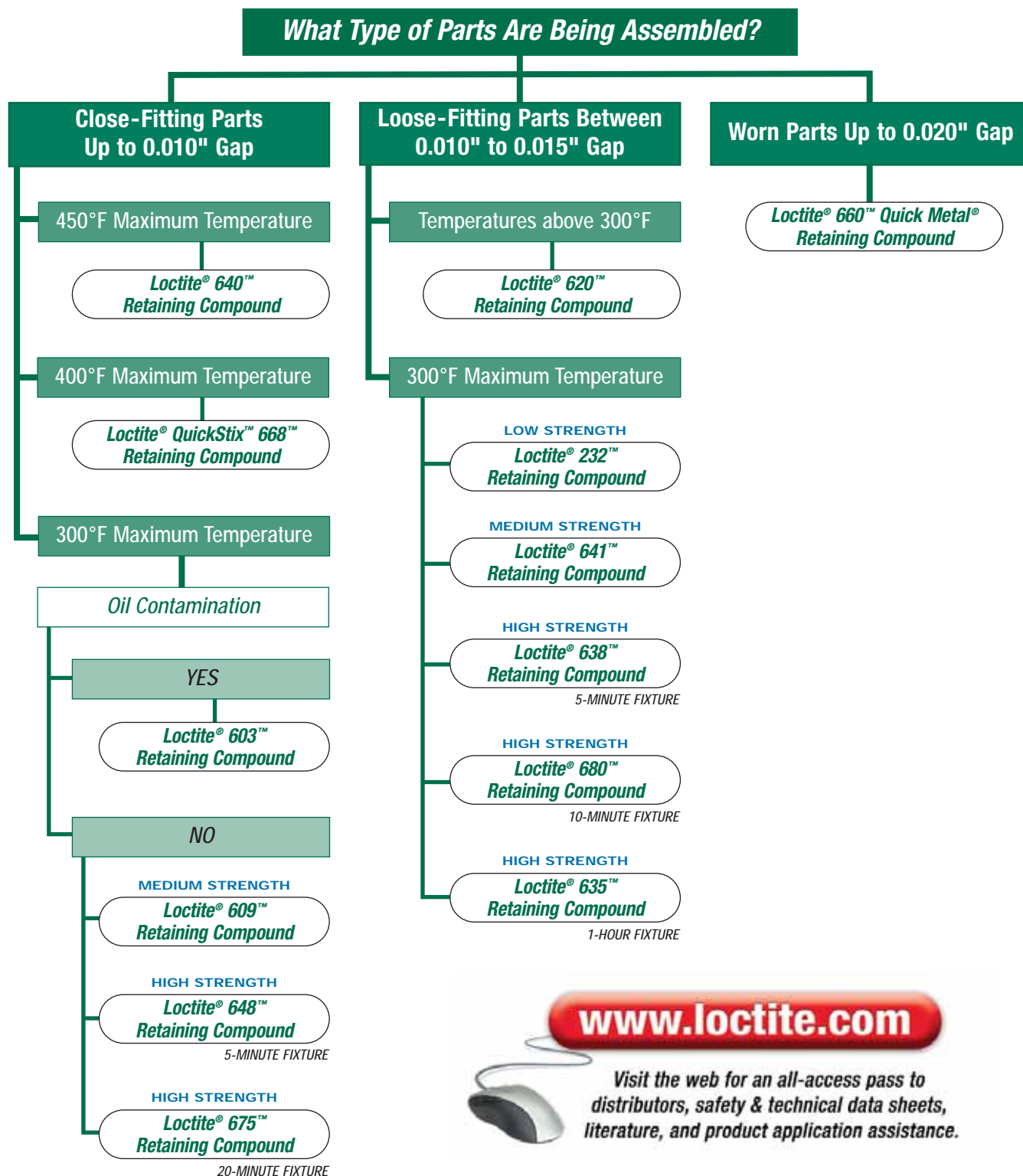
## ***The following are key factors to consider when choosing a retaining compound.***

- 1. Gap Size Between Parts** – Typically, low viscosity retaining compounds (125 to 2000 cps) are used for gaps up to 0.010". For gaps greater than 0.010", retaining compounds with higher viscosities (>2000 cps) should be used.
- 2. Temperature Resistance** – Most Loctite® retaining compounds are made to withstand temperatures up to 300°F. For those applications that require resistance greater than 300°F, Henkel offers a line of high temperature resistant Loctite® retaining compounds that can withstand temperatures up to 450°F.
- 3. Bond Strength** – In applications that require a permanent bond, a high strength retaining compound is recommended. If at some point in the future, parts will need to be taken apart for service, it is better to use a low or medium strength product.
- 4. Cure Speed** – Many production applications require retaining compounds with fast cure speed in order to maximize production rate. On the other hand, some applications require a slower cure so that adjustments can be made after the parts have been assembled. Our range of Loctite® retaining compounds offers varying rates of cure enabling you to choose the one that best matches your application.

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any retaining compounds.*

Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **[www.loctite.com](http://www.loctite.com)** and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

## Retaining Compounds Selector Guide



**NOTE:** Please refer to pages 96-98 for more information on these products.

**www.loctite.com**



Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.



# Retaining

Henkel Corporation has applied its pioneered anaerobic technology to develop retaining compounds that increase the shear strength of cylindrical, non-threaded assemblies. Marketed under the brand name Loctite®, these compounds have gained wide acceptance as a standard method for assembling press- and slip-fitted parts. Loctite® retaining compounds fill the “inner space” between components and cure to form a strong precision assembly. Formulated in a variety of viscosities, gap fills, flexibility, and strength characteristics, Loctite® retaining compounds can be applied with automated process equipment or dispensed manually.



## CLOSE-FITTING PARTS

### LOCTITE® 232™ RETAINING COMPOUND

#### *Heavy Press Fit / Medium Strength*

A medium viscosity, medium strength retaining compound with slow cure and lubricity for highly torqued threaded assemblies and heavy press fits.

### LOCTITE® 603™ RETAINING COMPOUND

#### *Press Fit / Oil Tolerant*

A retaining compound tolerant of oil and other contamination. Seals and secures cylindrical assemblies up to 0.005" diametral clearance. Fixtures in 10 minutes. Prevents fretting and corrosion of metal assemblies.

### LOCTITE® 609™ RETAINING COMPOUND

#### *Press Fit / General Purpose*

A low viscosity retaining compound that bonds rigid metal assemblies. Ideal for gap distances up to 0.005" diametral. Fixtures in 10 minutes and provides a shear strength of 3,000 psi after 24 hours. Easily joins dissimilar metals. Withstands temperatures to 300°F.



### LOCTITE® 648™ RETAINING COMPOUND

#### *Press Fit / High Strength / Rapid Cure*

A retaining compound recommended for continuous working temperatures up to 300°F. Fills gaps up to 0.006" diametral clearance. Fixtures in 5 minutes.

## GENERAL PURPOSE

### LOCTITE® QUICKSTIX™ 668™ RETAINING COMPOUND



A high temperature retaining compound in a revolutionary semisolid formula. Patented, no-mess package offers added convenience and portability. Ideal for gaps up to 0.005" on the diameter. Withstands temperatures to 400°F (204°C).

## HIGH TEMPERATURE

### LOCTITE® 620™ RETAINING COMPOUND

#### *Slip Fit / High Temperature*

A high temperature (450°F), high viscosity liquid retaining compound. Provides a shear strength of over 3,800 psi on steel. Locks and secures metal cylindrical assemblies up to 0.015" diametral clearance. Prevents metal fretting and corrosion. Seals against leakage.



[www.loctite.com](http://www.loctite.com)



Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.

## LOOSE-FITTING PARTS

### LOCTITE® 635™ RETAINING COMPOUND

*Slip Fit / High Strength / Slow Cure*

A high viscosity, high strength retaining compound with slow cure speed to permit readjustment of parts during assembly.

### LOCTITE® 638™ RETAINING COMPOUND

*Slip Fit / Maximum Strength*

A maximum strength retaining compound for use where high dynamic force or cyclic loading is expected. Locks cylindrical assemblies up to 0.010" diametral clearance. Fixtures in 5 minutes.



### LOCTITE® 680™ RETAINING COMPOUND

*Slip Fit / High Strength*

A high strength, high viscosity room temperature curing adhesive used to join fitted cylindrical parts. It fixtures in 10 minutes and provides a shear strength of 4,000 psi after 24 hours. Capable of filling diametral gaps up to 0.015" (0.27 mm). Loctite® 680™ allows relaxed machining tolerances and replaces clamp rings, set screws, and snap rings.

## MEDIUM STRENGTH

### LOCTITE® 641™ RETAINING COMPOUND

*Press & Slip Fit / Controlled Strength*

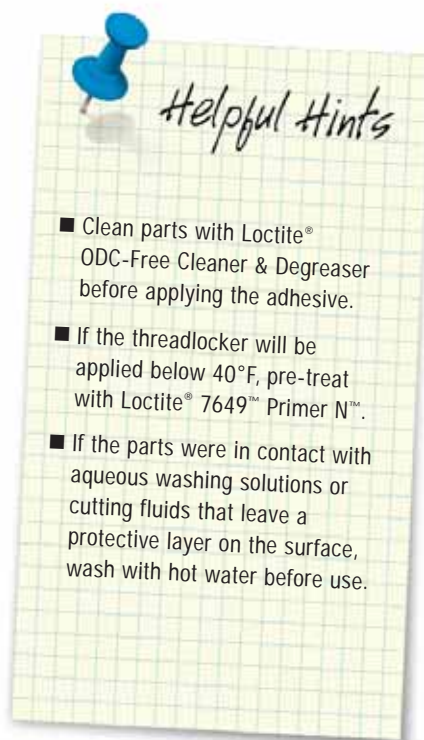
A controlled strength retaining compound that is ideal for cylindrical parts that require disassembly. Recommended for maximum diametral clearance of 0.008". Fixtures in 20 minutes.

## MACHINERY REPAIR











### LOCTITE® 660™ QUICK METAL® RETAINING COMPOUND

*Press Fit Repair*

A creamy, non-running gel that is applied onto cylindrical parts to fill surface imperfections and repair worn areas. It contains no metal, but once assembled hardens to a strength that often doubles that of a press fit. Use Loctite® 660™ to salvage worn metallic parts, or to keep machinery running until new parts arrive. Use to 300°F (149°C).



## Loctite® Retaining Compounds Properties Chart

Properties Chart													
PRODUCT		Item Number	Package Type & Size	TYPICAL USE	COLOR	MAXIMUM GAP FILL (DIAMETER)	VISCOSITY (cP)	SHEAR STRENGTH STEEL/STEEL* (psi)	TEMPERATURE RANGE	CURE SPEED*	RECOMMENDED PRIMER	SPECIFIC GRAVITY	AGENCY APPROVALS
CLOSE-FITTING PARTS	232™	18607 27863	1 liter bottle 250 ml bottle	Medium strength for heavy press fits	Brown	0.015"	5,000	1,350 psi* (2 hr. heat cure)	-65°F to 300°F	Fixture – > 1 hour Full – 24 hours	7088™, N™ or T™	1.02	N/A
	603™ 	21440 21441 21442	10 ml bottle 50 ml bottle 250 ml bottle	For close-fitting parts with light contamination	Green	0.005"	125	3,770	-65°F to 300°F	Fixture – 10 minutes Full – 24 hours	7088™, N™ or T™	1.10	N/A
	609™ 	60905 60921 60931 60941 60943	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	1st generation to augment press fits	Green	0.005"	125	2,300 (min.)	-65°F to 300°F	Fixture – 10 minutes Full – 24 hours	7088™, N™ or T™	1.10	MIL-R-46082B for existing designs, ASTM D-5363**, CFIA
	648™ 	21443 21444 21445	10 ml bottle 50 ml bottle 250 ml bottle	Fast fixturing for close-fitting parts, high strength for stainless steel	Green	0.006"	500	3,900	-65°F to 350°F	Fixture – 5 minutes Full – 24 hours	7088™, N™ or T™	1.13	N/A
	675™	67541	250 ml bottle	1st generation for close-fitting parts	Green	0.005"	125	3,000	-65°F to 300°F	Fixture – 20 minutes Full – 24 hours	7088™, N™ or T™	1.09	MIL-R-46082B for existing designs, ASTM D-5363**
GENERAL PURPOSE	QuickStix™ 668™ 	39147 39148 39149	9 g stick 19 g stick 39 g stick	General purpose, high temperature	Green Stick	0.005"	Semisolid	3,800	-65°F to 400°F	Fixture – 30 minutes Full – 24 hours	7088™, N™ or T™	1.1228	N/A
HIGH TEMPERATURE	620™  	62005 62015 62040 62070 62085	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	For high temperature applications	Green	0.015"	8,500	3,800	-65°F to 450°F	Fixture – 30 minutes Full – 24 hours	7088™, N™ or T™	1.16	CFIA, ABS
	640™	64031 64041	50 ml bottle 250 ml bottle	For high temperature applications	Green	0.007"	600	3,000	-65°F to 400°F	Fixture – 1 hour Full – 24 hours	7088™, N™ or T™	1.12	MIL-R-46082B for existing designs, ASTM D-5363**
LOOSE-FITTING PARTS	635™	63531 63541	50 ml bottle 250 ml bottle	1st generation high strength for slip fits	Green	0.010"	2,000	4,500	-65°F to 300°F	Fixture – 1 hour Full – 24 hours	7088™, N™ or T™	1.05	MIL-R-46082B for existing designs, ASTM D-5363**
	638™  	21447 21448 21449	10 ml bottle 50 ml bottle 250 ml bottle	High strength for loose-fitting parts	Green	0.015"	2,500	4,500	-65°F to 300°F	Fixture – 5 minutes Full – 24 hours	7088™, N™ or T™	1.09	CFIA
	680™	68005 68015 68035 68060 68090	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength for slip-fitted parts	Green	0.015"	1,250	2,800	-65°F to 300°F	Fixture – 10 minutes Full – 24 hours	7088™, N™ or T™	1.11	NSF / ANSI 61, ABS
MEDIUM STRENGTH	641™ 	28802 21458	10 ml bottle 50 ml bottle	Medium strength for easier disassembly	Yellow	0.008"	525 / 1,950 Thixotropic	1,700	-65°F to 300°F	Fixture – 20 minutes Full – 24 hours	7088™, N™ or T™	1.07	CFIA
MACHINERY REPAIR	660™ Quick Metal® 	66010 66040 30287	6 ml tube 50 ml tube 250 ml tube	For repair of worn machinery parts	Silver	0.020"	250,000 / 1,500,000 Thixotropic	3,335	-65°F to 300°F	Fixture – 20 minutes Full – 24 hours	7088™, N™ or T™	1.13	CFIA

\* Varies with substrates.

\*\* For new designs.



Indicates worldwide availability.



Indicates TOP CHOICE products.

## DISPENSING OPTIONS



**Loctite® 50 ml and 250 ml Hand Pumps** are portable, precision, bottle-top applicators that thread directly onto any 50 ml or 250 ml anaerobic bottle. They are designed to dispense at any angle from 0.01 to 0.04 ml with viscosities up to 30,000 cP, without leaks or product waste.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

**Item Numbers:** 97001 (250 ml bottles), 98414 (50 ml bottles)



**Loctite® Bond-A-Matic® 3000 Dispenser** is a reliable, low cost pneumatic dispenser that arrives ready to dispense Loctite® retaining compounds. This system comes complete with 2 liter pressure reservoir and Loctite® Vari-Drop™ applicator. The pressure regulator can be chosen to best suit your application. The reservoir will accommodate 50 ml, 250 ml, and 1 liter package sizes.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

**Item Numbers:** 982719 and 982722

**Weight:** 18 lbs.

**Package Types and Size:** 250 ml and 1 lb. bottles



**Loctite® Integrated Semiautomatic Controller** combines a controller and reservoir into a single unit. Combined with the digital timing feature, this unit will provide precise dispensing control with any Loctite® automatic dispense valve or pneumatic handheld applicator, see valves below. Units can be equipped with low level sensing as shown in the chart below.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).



Item Numbers	97010	97020	97007	97017
Pressure Regulation	0 to 15 psi		0 to 100 psi	
Used to Dispense	Retaining Compounds			
Package Types and Sizes	250 ml and 1 L bottles			
Viscosity Range	Low to Medium		Medium to High	
Low Level Sensing	No	Yes	No	Yes

**Loctite® Dispense Valves**, when combined with Loctite® Controller, offer the best automated dispensing solution.

The CA dispense valve, 98013, offers excellent performance when dispensing anaerobics. It is suitable for low to medium viscosity applications. The stationary valve, 97113, can be used in medium viscosity applications or if a suck-back feature is required.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

**Item Numbers:** 98013 and 97113



[www.equipment.loctite.com](http://www.equipment.loctite.com)

See our **Loctite® Equipment Sourcebook, LT-3669**, or visit on the web for information about distributors, safety & technical data sheets, literature, and product application assistance.





# Surface Preparation

Henkel has a complete line of Loctite® surface preparation accelerators, activators and primers, as well as a complete line of general-purpose Loctite® branded cleaners and degreasers, and specialized products to ensure the maximum performance of Loctite® adhesives and sealants.

Loctite® accelerators are used to increase the cure speed and gap-filling capabilities of cyanoacrylate adhesives. Activators are specially engineered curing agents for structural adhesives. Loctite® primers are used to ensure cure on inactive surfaces and speed the cure of machinery adhesives.

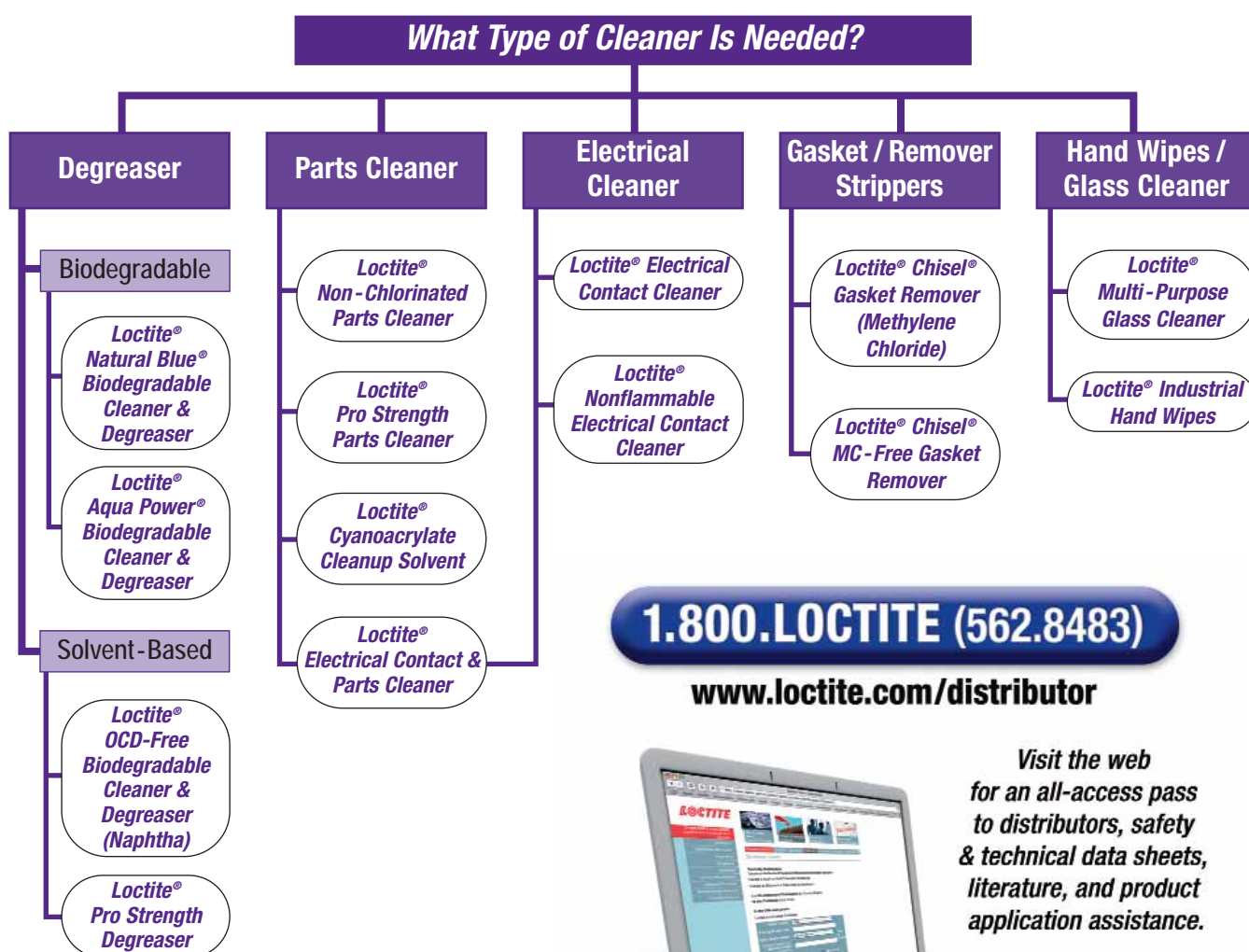
Loctite® cleaners and degreasers are highly effective and are available in both aqueous and solvent-based formulations. When choosing a cleaner or degreaser, the major factors to consider are dry time, residue, odor, and substrate compatibility. Residue is a particularly important concern because if there is any secondary processing of the part, e.g., painting or bonding, a residue could interfere with that process. Substrate compatibility is a common concern when dealing with plastics and solvent-based cleaners. The following chart will help you to select the appropriate cleaner for your application.

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying a certain type of surface preparation product.*

Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **[www.loctite.com](http://www.loctite.com)** and select "Contact Loctite." In Canada, please call **1-800-263-5043**.



## Surface Preparation Selector Guide



**NOTE:** Please refer to pages 104-107 for more information on these products.

# Accelerators, Activators & Primers



Henkel Corporation offers a complete line of Loctite® surface preparation products to ensure the maximum performance of Loctite® adhesives and sealants. Accelerators are used to increase the cure speed and gap-filling capabilities of cyanoacrylate adhesives. Activators are specially engineered curing agents for structural adhesives. Primers are used to ensure cure on inactive surfaces and speed the cure of machinery adhesives. All Loctite® surface preparation products are available in ozone-safe (non-chlorofluorocarbons), solvent-based and solventless formulations.



## ACCELERATORS

### LOCTITE® 7113™ ACCELERATOR

This accelerator features long on-part life. Use with Loctite® cyanoacrylate adhesives.

### LOCTITE® 7452™ TAK PAK® ACCELERATOR

This accelerator, with aggressive cleaning properties, promotes the cure speed of all Loctite® cyanoacrylate adhesives.

## ACTIVATORS

### LOCTITE® 7075™ ACTIVATOR

An acetone-based activator that promotes the proper cure of Loctite® 324™ and 325™ Speedbonder™ Structural Adhesives.

### LOCTITE® 7380™ DEPEND® ACTIVATOR

This solvent-free activator allows immediate mating of parts. Use with most Loctite® acrylic adhesives.

### LOCTITE® 7387™ DEPEND® ACTIVATOR

This activator promotes the cure of most Loctite® acrylic adhesives. This is a flammable product.

## PRIMERS

### LOCTITE® 770™ PRISM® PRIMER

An adhesion promoter formulated for use with polyolefins and other low surface energy plastic materials. Use with Loctite® cyanoacrylate adhesives. Fast dry time and long on-part life.

### LOCTITE® 7088™ QUICKSTIX™ PRIMER NEW

Semi-Solid, solventless primer. Very long on part life and speeds the cure of anaerobic products. Eliminates potential spills. Works well with structural bonders.

### LOCTITE® 7471™ PRIMER T™

A solvent-based primer that speeds the cure of all Loctite® anaerobic adhesives and ensures proper cure on inactive metals.













### LOCTITE® 7649™ PRIMER N™

A solvent-based primer that features very long on-part life. Use to speed the cure of all Loctite® anaerobic products and ensure proper cure on inactive metals. Ideal for cure conditions below room temperature.

### LOCTITE® 7951™ PRISM® PRIMER

A nonflammable and noncombustible adhesion promoter formulated for use with polyolefins and other low surface energy plastic materials. Use with Loctite® cyanoacrylate adhesives. Fast dry time and long on-part life.

# Loctite® Accelerators, Activators & Primers Properties Chart

	PRODUCT	Item Number	Package Type & Size	COLOR	VISCOSITY (cP)	BASE	ON-PART LIFE	DRY TIME	APPLICATION	AGENCY APPROVALS
ACCELERATORS	<b>712™ Tak Pak®</b> 	20352 18636 18390	1.75 fl. oz. bottle 0.7 fl. oz. metered mist 1 gallon can	Clear / Amber	1	Isopropanol	1 min.	< 30 seconds	All cyanoacrylates	MIL-46050C for existing designs, CFIA
	<b>7109™ Tak Pak® II</b>	22440 23034	1.75 fl. oz. bottle 1 qt. bottle	Clear / Amber	3	Perfluorocarbon	1 min.	< 5 seconds	All cyanoacrylates	N/A
	<b>7113™</b> 	19605 19606	1.75 fl. oz. bottle 1 gallon can	Clear	0.4	Heptane	24 hrs.	1 minute	All cyanoacrylates	N/A
	<b>7452™ Tak Pak®</b> 	18490 18580 18637 18575 18576	1.75 fl. oz. brush-cap bottle 1.75 fl. oz. spray-cap bottle 0.7 fl. oz. metered mist 1 quart can 1 gallon can	Clear / Amber	0.4	Acetone	1 min.	< 30 seconds	All cyanoacrylates	MIL-46050C for existing designs
ACTIVATORS	<b>7075™</b> 	21349 22671	1 quart can 4.5 oz. net wt. aerosol can	Amber	2	Acetone	2 hrs.	3 minutes	324™ or 325™	N/A
	<b>7380™ Depend®</b> 	19822 19824 19907	1 liter can 1.75 fl. oz. bottle 1 gallon	Light Brown	43	Monomer	2 hrs.	None	Structurals	N/A
	<b>7387™ Depend®</b> 	18861 18862 21088	1.75 fl. oz. bottle 1 quart can 4.5 oz. net wt. aerosol can	Light Brown	1.5	Heptane / Isopropanol	2 hrs.	None	Structurals	N/A
	<b>25062</b>	25062	1 liter bottle	Thin Green / Fluorescent	1.03	Methacrylate	1 hr.	None	Anaerobics on dichromate surfaces	N/A
PRIMERS	<b>770™ Prism®</b> 	18396 18397	1.75 fl. oz. bottle 16 fl. oz. can	Colorless	1.25	Heptane	8 hrs.	30 seconds	All cyanoacrylates	CFIA
	<b>793™ Prism®</b> 	18650 20246	1.75 fl. oz. bottle 16 fl. oz. bottle	Clear / Light Amber	3	Propylene-based Glycol Ether / Water	< 2 hrs.	< 10 minutes	Anaerobics	N/A
	<b>7088™ QuickStix™ Primer</b> 	1069258	17 g stick	Teal	Semi-solid	No solvent	30 days	None	Anaerobics	N/A
	<b>7090™</b> 	19368 12695	1 fl. oz. bottle 1 liter bottle	Light Amber	3	No solvent	1 hr.	< 10 minutes	Anaerobics	N/A
	<b>7471™ Primer T™</b> 	19267 22477 19268	1.75 fl. oz. bottle 4.5 oz. net wt. aerosol can 1 gallon can	Amber	2	Acetone / Isopropanol	7 days	30 to 70 seconds	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs
	<b>7649™ Primer N™</b> 	19269 38402 21347 21348 19266	1.75 fl. oz. glass bottle 1.75 fl. oz. aluminum bottle 25 g net wt. aerosol can 4.5 oz. net wt. aerosol can 1 gallon can	Clear / Green	2	Acetone	30 days	30 to 70 seconds	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs, NSF/ANSI 61, NSF P1, CFIA
	<b>7951™ Prism®</b>	27858	1.75 fl. oz. bottle	Colorless, Slightly Hazy	1	Perfluorocarbon and Chlorobenzotrifluoride	8 hr.	< 30 seconds	All cyanoacrylates	N/A



Indicates worldwide availability.

## Helpful Hints

Use a primer when both surfaces are considered inactive. It is necessary to apply the primer to one surface, in most cases, unless gaps are excessive.

Inactive Metals (Primers Recommended)			Active Metals (Primers Optional)	
Plated Parts	Zinc	Magnetite Steel	Iron	Bronze
Anodized Aluminum (Alodine, Irridite)	Pure Aluminum	Iconel	Plain Steel	Nickel
Titanium	Cadmium	Silver	Copper	Manganese
Stainless Steel	Magnesium	Gold	Brass	Monel
Galvanized Steel	Natural or Chemical Black Oxide			Kovar

Loctite® Anaerobic Machinery Adhesives cure in the absence of air and presence of metal ions. When assembling inactive metal parts, which are low in metal ions, the use of Loctite® Primers are recommended to ensure proper performance of Loctite® Anaerobic Machinery Adhesives.



# Cleaners & Degreasers



## DEGREASERS

### LOCTITE® NATURAL BLUE® BIODEGRADABLE CLEANER & DEGREASER

All purpose, industrial strength, concentrated cleaner and degreaser. Can be economically diluted with water. Natural Blue® is formulated for wipe down, pressure spraying, and immersion cleaning processes – at room temperature or heated. Pine-scented, nonflammable, and non-toxic. Contains no ozone-depleting chemicals (ODCs). CFIA approved.



### LOCTITE® NATURAL BLUE® BIODEGRADABLE CLEANER & DEGREASER

#### *Fragrance-Free*

Same product as Loctite® Natural Blue® Biodegradable Cleaner & Degreaser but without the fragrance. It can be used in all departments of a food processing plant. Contains no ozone-depleting chemicals (ODCs). CFIA approved.

### LOCTITE® AQUA POWER® BIODEGRADABLE CLEANER & DEGREASER

Penetrates, dissolves and removes dirt and oil. Fast drying and residue-free. Environmentally-friendly product is biodegradable, has low toxicity, contains no ozone-depleting chemicals (ODCs), and is non-corrosive/non-caustic.

### LOCTITE® ODC-FREE CLEANER & DEGREASER (NAPHTHA)

A non-aqueous, hydrocarbon-based solvent designed for cleaning and degreasing surfaces to be bonded with adhesives, as well as for general purpose industrial cleaning. Safe on aluminum, rubber and most plastics, and will not cause flash rusting on water sensitive parts. Dries residue-free. Contains no ozone-depleting compounds. (Formerly referenced as 7070.) NSF K1 approved.

### LOCTITE® PRO STRENGTH DEGREASER

Quickly dissolves and removes grease, oil, and dirt from iron, steel, aluminum, magnesium, copper, rubber, plastic, and concrete. Rinses off with water.



### Helpful Hints

- The Loctite® line of cleaners and degreasers include both aqueous and solvent-based products, all of which are free of Class I ozone-depleting chemicals (ODCs).
- Loctite® MC-Free Chisel® Gasket Remover is the best product for removing silicones.

## ELECTRICAL CLEANERS

### LOCTITE® ELECTRICAL CONTACT & PARTS CLEANER

Fast-evaporating cleaner removes grease, oil, and other contaminants from electrical parts and mechanical equipment. Contains no CFCs or HCFCs and is safe on most plastics. Non-conductive and non-corrosive.

### LOCTITE® ELECTRICAL CONTACT CLEANER

*Nonflammable*

Removes grease, oil, and other contaminants from electrical parts to prevent contact failure. Dries residue-free in seconds. Non-conductive, non-corrosive, nonflammable. Contains no CFCs or Class I ozone-depleting chemicals (ODCs). Contains HCFC-141b. May attack some sensitive plastics.

## PAINT STRIPPER

### LOCTITE® CHISEL® PAINT STRIPPER (METHYLENE CHLORIDE)

Removes gaskets from any type of assembly in 10 to 15 minutes. Prepares metal parts for new gaskets, eliminating scraping and sanding. Works on wood; non-corrosive on aluminum. Not for use on plastics, linoleum, or synthetic fibers. CFIA approved.



## GLASS CLEANER / HAND WIPES

### LOCTITE® MULTI-PURPOSE GLASS CLEANER

Fast-acting, professional strength cleaner removes tough grease and dirt from glass, chrome, aluminum, stainless steel, and enamel finishes. Orange-scented formula will not run or streak. Contains no ozone-depleting chemicals (ODCs).

### LOCTITE® INDUSTRIAL HAND WIPES

Pre-moistened with a powerful citrus-scented cleaning formula that is abrasive enough to scrub off the toughest grease and grime. Quick and easy-to-use, these 9.5" x 12" towels eliminate rinsing and drying and leave no residue behind. Perfect for industrial and commercial environments in the painting, printing, maintenance, transportation, and construction industries.



## PARTS CLEANERS

### LOCTITE® NON-CHLORINATED PARTS CLEANER

Penetrates, dissolves, and removes dirt and oil from metal parts. Leaves no residue. Does not contain 1,1,1-trichlorethane; helps manage EPA halide limits.

### LOCTITE® PRO STRENGTH PARTS CLEANER

Aggressively penetrates, dissolves, and removes oil and grease from parts. Dries quickly with no residue. Contains no ozone-depleting chemicals (ODCs).



### LOCTITE® 768™ X-NMS CLEANUP SOLVENT

Quickly and safely dissolves cured cyanoacrylate-based adhesives.

## STRIPPER / VARNISH REMOVERS

### LOCTITE® PRO STRENGTH VARNISH REMOVER

Super jet spray quickly cuts and removes grease, gum, and varnish from chokes, baffle plates, and carburetor linkage. Improves performance and fuel efficiency.

### LOCTITE® INDUSTRIAL STRENGTH PAINT STRIPPER

Quickly strips and removes paint. Eliminates sanding and scraping. Works in 10 to 15 minutes at temperatures from -40°F to 100°F. Contains no ozone-depleting chemicals (ODCs).









Loctite® Cleaners &amp; Degreasers Properties Chart

PRODUCT		Item Number	Package Type & Size	DRYING TIME	RESIDUE / RINSABILITY	ODOR
DEGREASERS	Natural Blue® Biodegradable Cleaner & Degreaser	82244 82249 82251 82253 82254 82255	4 fl. oz. bottle 24 fl. oz. spray bottle 1 gallon bottle 5 gallon pail 15 gallon pail 55 gallon drum	Equivalent to the evaporation rate of water. Wiping or blowers will accelerate dry time.	Rinses residue-free with water	Pine Scent
	Natural Blue® Biodegradable Cleaner & Degreaser (Fragrance-Free)	23811 20279	1 gallon bottle 55 gallon drum	Equivalent to the evaporation rate of water. Wiping or blowers will accelerate dry time.	Rinses residue-free with water	Fragrance-Free
	Aqua Power® Biodegradable Cleaner & Degreaser	30565	17 oz. net wt. aerosol	5 to 15 minutes	No rinse and no residue	Mild Citrus
	ODC-Free Cleaner & Degreaser	22355 20162 20260	15 oz. net wt. aerosol 16 fl. oz. pump spray 1 gallon can	Equivalent to the evaporation rate of water. Wiping or blowers will accelerate dry time.	No rinse and no residue	Mild Citrus
	Pro Strength Degreaser	30521	15 oz. net wt. aerosol	Leave on surface for 10 minutes.	Rinses clean	Mild Solvent
ELECTRICAL CLEANERS	Electrical Contact & Parts Cleaner	25791	11 oz. net wt. aerosol	<30 seconds	No rinse and no residue	Mild Solvent
	Electrical Contact Cleaner (Nonflammable)	24379	15 oz. net wt. aerosol	<30 seconds	No rinse and no residue	Mild Solvent
PAINT STRIPPER	Chisel® Paint Stripper (Methylene Chloride)	79040	18 oz. net wt. aerosol	Leave on surface for 5 to 10 minutes. Wipe/scrape clean.	Waxy residue	Solvent
GLASS CLEANER / HAND WIPES	Multipurpose Glass Cleaner	30546	18.75 oz. net wt. aerosol	Wipes dry	No residue, wipes clean	Orange Scent
	Industrial Hand Wipes	34943 34944	75 count canister 130 count bucket	1 to 5 minutes	No rinse and no residue	Mild Citrus
PARTS CLEANERS	Non-Chlorinated Parts Cleaner	30545	14.75 oz. net wt. aerosol	5 to 15 minutes	No rinse and no residue	Mild Solvent
	Pro Strength Parts Cleaner	30548	19 oz. net wt. aerosol	5 to 15 minutes	No rinse and no residue	Mild Solvent
	768™ X-NMS Cleanup Solvent	76820 76871	1.75 fl. oz. bottle 1 gallon can	<30 seconds	No rinse and no residue	Solvent
STRIPPER / VARNISH REMOVERS	Pro Strength Varnish Remover	30529	12 oz. net wt. aerosol	5 minutes	No rinse and no residue	Aromatic
	Industrial Strength Paint Stripper	81716	18 oz. net wt. aerosol	10 minutes	Rinses residue-free with water	Acrid

 Indicates TOP CHOICE products.

## Loctite® Cleaners Application Chart

PRODUCT		Function	Application
DEGREASERS	<b>Natural Blue® Biodegradable Cleaner &amp; Degreaser</b> 	Removes grease, grime, oil, soot, cutting fluids, mildew, stains, light carbon, animal fat, polishing compounds, and ink.	Cleans engine parts, ovens, exhaust hoods, drilling rigs. Can be diluted for general wipe down cleaning. Formulated for pressure spraying and immersion cleaning processes, at room temperature or heated.
	<b>Natural Blue® Biodegradable Cleaner &amp; Degreaser (Fragrance-Free)</b>	Removes grease, grime, oil, soot, cutting fluids, mildew, stains, light carbon, animal fat, polishing compounds, and ink, without added fragrance.	Exhaust hoods, machinery, tanks, motors, concrete floors, asphalt, walls, floors, carpets, valves, equipment, vehicles, compressors, exterior siding, engines, bearings.
	<b>Aqua Power® Biodegradable Cleaner &amp; Degreaser</b>	Biodegradable cleaner for removing oil, grease, and asphalt.	All-purpose metal parts cleaner.
	<b>ODC-Free Cleaner &amp; Degreaser</b>	Removes grease, oil, lubrication fluids, metal cuttings and filings from parts, equipment, and machinery.	Use as a spray or in immersion cleaning processes, at room temperature or heated. Recommended as a final pre-assembly cleaning treatment for all surfaces bonded with adhesives.
	<b>Pro Strength Degreaser</b>	Self-emulsifying degreaser that quickly cuts and removes grease, oil, and dirt, as well as inhibiting rust and corrosion.	Cleaning and degreasing industrial and farm equipment, lawn mowers, garage floors, tools.
ELECTRICAL CLEANERS	<b>Electrical Contact &amp; Parts Cleaner</b>	Removes grease, dirt, oil, flux, and surface contaminants from sensitive electrical / electronic devices. Also used for equipment requiring non-conductive, low residue degreasing agents.	Switches, relays, motor controls, pc boards, connectors, tape heads, sensors, control panels, electrically driven equipment, general parts degreasing.
	<b>Electrical Contact Cleaner (Nonflammable)</b>	Removes grease, dirt, oil, flux, and surface contaminants from sensitive electrical / electronic devices. Also used for equipment requiring non-conductive, low residue degreasing agents. Contains HCFC-141b. Nonflammable.	Switches, relays, motor controls, pc boards, connectors, tape heads, sensors, control panels, electrically driven equipment.
PAINT STRIPPER	<b>Chisel® Paint Stripper (Methylene Chloride)</b> 	Removes pre-cut conventional gasket cements as well as formed-in-place chemical gaskets.	Removes silicones, baked-on gaskets, gaskets from aluminum, small difficult-to-reach components, weatherstrip adhesive, dried oil, grease, paint, varnish.
GLASS CLEANER / HAND WIPES	<b>Multipurpose Glass Cleaner</b>	Deodorizes and cleans window film.	Glass, chrome, aluminum, stainless steel and enamel finishes, plastics.
	<b>Industrial Hand Wipes</b> 	Removes grease, grime, oil, soot, paints, and ink.	Removes grease, grime, oil, soot, paints, and ink from surfaces. Removes grease and grime from hands.
PARTS CLEANERS	<b>Non-Chlorinated Parts Cleaner</b>	Cleaner for removing oil, grease, and asphalt with no chlorinated solvent run-off.	All-purpose metal parts cleaner. Ideal for aluminum surfaces.
	<b>Pro Strength Parts Cleaner</b> 	Removes oil, grease, brake fluids, oxidized oils (gum), and asphalt. Penetrates through dirt and corrosion and flushes them away.	All-purpose metal parts cleaner.
	<b>768™ X-NMS Cleanup Solvent</b>	Dissolves cured cyanoacrylate-based adhesives.	Disassembly of parts and cleanup of dispensing equipment.
STRIPPER / VARNISH REMOVERS	<b>Pro Strength Varnish Remover</b>	Dissolves and cleans residue deposited during normal operation of gasoline engine powered equipment.	Carburetors, chokes, linkages, heat risers, PCV valves, metal parts, industrial equipment.
	<b>Industrial Strength Paint Stripper</b>	Removes paint, varnish, and glues from metal, wood, and plaster.	Cleaning paint spills, removing various types of paint, contact cements, glues, floor lines, decals, and labels.



# Threadlocking

In the last fifty years, the introduction of liquid anaerobic threadlockers has dramatically increased the reliability of threaded fasteners. In fact, since their introduction, liquid anaerobic products have become one of the most reliable ways to ensure that a threaded assembly will remain locked and leak-proof for the service life of the assembly.

When used to assemble threaded fasteners, Loctite® threadlockers are vastly superior to mechanical locking devices. Applied drop-wise to the threads of a fastener, the anaerobic liquid cures to a hard thermoset plastic that locks the threads together, preventing unwanted movement or loosening, leaks, and corrosion. To further enhance their performance, unique anaerobic formulations have been developed for applications with high temperatures, oil contamination, and less reactive surfaces.

Loctite® threadlockers have historically been formulated as liquids due to their reactivity, and to ensure they remain stable and ready to use. Recent breakthroughs have led to the development of stable, semisolid stick formulations. This has opened the door to applications where the liquids were considered too messy or inconvenient. These new semisolid formulations allow direct contact of the anaerobic product to the part. This ensures not only that the product is placed exactly where it is needed, but also that it stays there as the threaded part is positioned and assembled.

## Threadlockers

Threaded fasteners continually receive various types of differential stress. Stresses, such as vibration and shock, thermal expansion and contraction, and micro-movement of the fastened parts, can all reduce clamping force and ultimately cause machine failure. Many mechanical devices, such as spring washers, wire retainers and locking bolts, were developed to prevent uncontrolled loosening of fasteners. These locking methods add substantial cost to the fastener assembly, yet cannot reliably prevent loosening due to their uneven side or sliding motion. They also do not seal or prevent corrosion within the fastener assembly and must be sized appropriately for the specific fastener.

Threadlockers are available in low strength formulations for easy removal, medium strength grades that are removable using common hand tools, and high strength grades that offer strong holding abilities. However, no threadlocker is completely permanent; standard hand tools remove even the highest-strength threadlockers following direct exposure to heat (450°F to 500°F) for about five minutes.

Contrary to common belief, any bolt previously locked with threadlocking adhesive is reusable simply by removing the old adhesive, applying new threadlocking material and reassembling.

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any threadlocker.*

Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit [www.loctite.com](http://www.loctite.com) and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

# Choosing the right threadlocker for the application

## How do I decide which threadlocker to use?

Loctite® threadlockers are available in many grades to satisfy a wide range of applications. To make grade selection easy, the grades are color-coded to help you identify one threadlocker from the other.

**LOW STRENGTH** – Purple color, removable with hand tools, good for adjustment screws, calibration screws, meters and gauges, and for fasteners up to 1/4" in diameter.

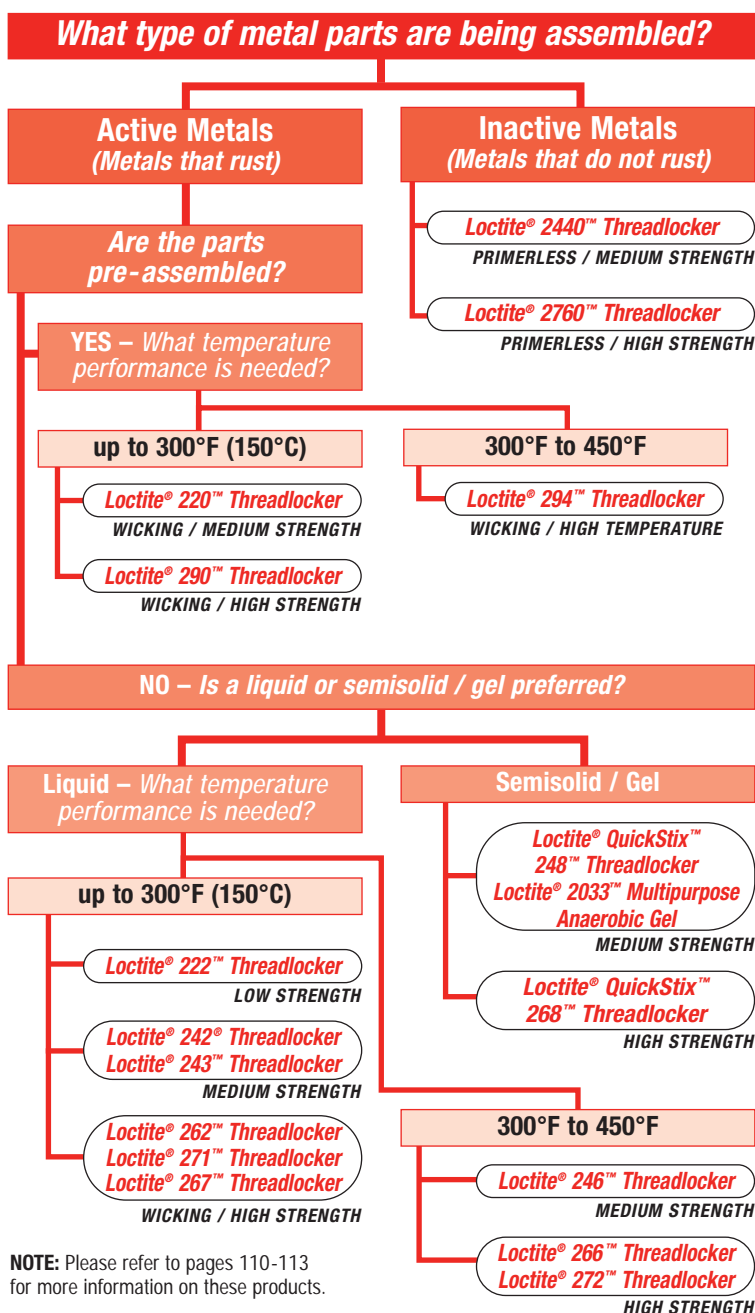
**MEDIUM STRENGTH** – Blue color, removable with hand tools, good for machine tools and presses, pumps and compressors, mounting bolts, gearboxes, and for fasteners up to 3/4" in diameter.

**HIGH STRENGTH** – Red color, for permanent assemblies, heavy equipment, suspension bolts, motor and pump mounts, bearing cap bolts and studs, and for fasteners up to 1" and larger in diameter.

**WICKING** – Green color, removable with heat and hand tools, for pre-assembled fasteners, instrumentation screws, electrical connectors, carburetors and fasteners up to 1/2" in diameter.

**NON-LIQUIDS** – Loctite® 2033™ is a gel formulation and the products Loctite® QuickStix™ 248™ and Loctite® QuickStix™ 268™ are medium and high strength semisolid threadlocker sticks.

## Threadlocking Selector Guide



**NOTE:** Please refer to pages 110-113 for more information on these products.

### Is there a threadlocker for high temperature applications?

Yes, Henkel has threadlockers for applications below 300°F and between 300°F to 450°F. One example is Loctite® 246™, a medium strength product for temperatures up to 450°F. Other high temperature products can be found in the Properties Chart.

### Are there products that work well on oily parts?

There are several Loctite® products with oil-cutting capabilities. These include Loctite® 243™, 246™, 266™ and 294™ threadlockers. Use the Properties Chart to choose the one that is right for your application.

### What do I do when I have a blind hole application?

The application method for blind hole assemblies requires that the product be applied to both parts. If the product is applied to the fastener only, air pressure will force the liquid threadlocker to escape as you torque down.

### Do you have a product for inactive metals?

Loctite® 2440™ (medium strength) and 2760™ (high strength) threadlockers are the latest and best technology, enabling the assembly of inactive metals without the need to use a primer. These products are ideal for use on metals such as stainless steel, zinc, magnesium, black oxide, cadmium, anodized aluminum, passivated titanium, and others.

### How much time is needed for the adhesive to cure?

Most anaerobic adhesives attain full cure in around 24 hours but will fixture in less time. For cure speed of the various products, refer to the Properties Chart or to the Technical Data Sheets (TDS).

### Can I use threadlockers on plastic threads?

For plastic fasteners, only use the Loctite® 425™ Assure™ Instant Adhesive, a surface curing threadlocker.

### When should I use a primer?

Primers help speed the curing process for faster return to service. For this reason, they can be used in any application but are most often used on less active metal surfaces. Alternatively, the use of Loctite® 2440™ and 2760™ primerless products provides a fast cure on inactive surfaces.

# Threadlocking

- Prevents loosening from shock and vibration
- Single component – clean and easy to apply
- Can be used on various sizes of fasteners – reduces inventory costs
- Seals threads
- Stops rust and corrosion

Invented by Loctite Corporation, now Henkel Corporation, as a revolutionary method to lock and seal threaded fasteners, Loctite® liquid threadlockers have found wide acceptance in a range of applications – from delicate electronic components to heavy construction equipment. Loctite® threadlockers are available in varying viscosities and strengths for virtually any application, including exposure to extreme environments. Patented, revolutionary QuickStix™ semisolid formulas offer added convenience and portability.

## LOW STRENGTH

### LOCTITE® 222MS™ THREADLOCKER

*Low Strength / Small Screw / Purple*

Ideal for fastener diameters of 1/4" (6 mm) and smaller, long engagement length fasteners, and components requiring occasional adjustment. Apply to threaded parts before assembly. Controlled lubricity for accurate clamp loads. Parts can be disassembled with hand tools. Approved for use in or around food processing areas.



## REMOVABLE STRENGTH

### LOCTITE® 242® THREADLOCKER

*Medium Strength*

Removable strength, general purpose threadlocking adhesive well suited for fasteners between 1/4" to 3/4" diameter (6 to 20 mm). Applied to threaded components before assembly, Loctite® 242® Threadlocker has controlled lubricity for accurate clamp loads. Parts can be separated using hand tools. Approved for use in or around food processing areas.

### LOCTITE® 243™ THREADLOCKER

*Medium Strength / Oil Resistant*

A general purpose, medium strength threadlocker with improved oil tolerance. Suitable for 1/4" to 3/4" diameter (6 to 20 mm) fasteners.

### LOCTITE® 246™ THREADLOCKER

*Medium Strength / High Temperature*

This threadlocker resists oil and mild surface contamination at continuous temperatures to 450°F. Suitable for 1/4" to 3/4" diameter (6 to 20 mm) fasteners.

### LOCTITE® QUICKSTIX™ 248™ THREADLOCKER – MEDIUM STRENGTH

*Semisolid / Blue*

New, patented semisolid stick formula offers added convenience and portability. Like Loctite® 242®, this threadlocker stick is well suited for 1/4" to 3/4" (6 to 20 mm) fasteners and is removable with hand tools. The semisolid formula also means it won't spill or leak.

### LOCTITE® 2033™ THREADLOCKER

A medium strength gel threadlocker for use on standard or large thread applications. It is easy to use, ergonomic, with multi-dispense options. The gel consistency is ideal for overhead or preapplied applications where product drip is a concern.

### LOCTITE® 2432™ THREADLOCKER

*Low Halogen / Low Sulfur*

This medium strength threadlocker was specially developed for use on sensitive metals, like titanium, used in the nuclear industry. Parts can be separated using hand tools.

### Loctite® 2440™ Threadlocker

*Primerless / Medium Strength*

This threadlocker is particularly fast curing, eliminating the need for primers. Performs well on all substrates. It develops usable strength within one hour. Parts can be separated using hand tools.







## DISPENSING OPTIONS

**Loctite® 50 ml and 250 ml Hand Pumps** are portable, precision, bottle-top applicators that thread directly onto any 50 ml or 250 ml anaerobic bottle. They are designed to dispense at any angle in drop sizes from 0.01 to 0.04 ml with viscosities up to 30,000 cP, without leaks or product waste. For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

**Item Numbers:** 97001 (250 ml bottles),  
98414 (50 ml bottles)



## HIGH STRENGTH

### LOCTITE® 262™ THREADLOCKER

*Medium to High Strength*

A permanent, high strength product that is applied to fasteners up to 3/4" (20 mm) in diameter before assembly. High lubrication for easy assembly. Excellent for preventing rust and corrosion in extreme chemical / environmental conditions. Localized heat and hand tools are required to separate parts. Solvents will not weaken the adhesive bond. Approved for use in or around food processing areas.

### LOCTITE® 266™ THREADLOCKER

*High Strength / High Temperature*

Fast fixturing threadlocker resists oil and mild surface contamination at temperatures to 450°F. Locks fasteners up to 3/4" (20 mm) in diameter.

### LOCTITE® QUICKSTIX™ 268™ THREADLOCKER – HIGH STRENGTH

*Semisolid / Red*

Revolutionary semisolid stick formula is high strength and best suited for fasteners up to 3/4" (20 mm). Semisolid formula offers added convenience and portability. Localized heat and hand tools are required to separate parts.

### LOCTITE® 271™ THREADLOCKER

*High Strength*

A high strength, low viscosity threadlocker for fasteners up to 1" (25 mm) in diameter.

### LOCTITE® 272™ THREADLOCKER

*High Strength / High Temperature*

Withstands temperatures to 450°F. Provides a fast cure on most surfaces, including "as received" fasteners. Recommended for bolts up to 1 1/2" (36 mm) in diameter. Heat and hand tools are required for disassembly.

### LOCTITE® 277™ THREADLOCKER

*High Strength*

Locks fasteners up to 1 1/2" (36 mm). Protects threads from rust and corrosion. Removable with heat and hand tools.

### LOCTITE® 2760™ THREADLOCKER

*Primerless / High Strength*

This threadlocker is particularly fast curing, eliminating the need for primers. It develops usable strength within one hour. Particularly suitable for heavy duty applications where resistance to heavy shock, vibration and stress levels is required.



## Helpful Hints

- Clean parts with Loctite® ODC-Free Cleaner & Degreaser before applying the adhesive.
- If the threadlocker will be applied below 40°F, pre-treat with Loctite® 7649™ Primer N™.
- 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.

Inactive Metals (Primers Recommended)			Active Metals (Primers Optional)	
Plated Parts	Zinc	Magnetite Steel	Iron	Bronze
Anodized Aluminum	Pure Aluminum	Iconel	Plain Steel	Nickel
(Alodine, Iridite)	Cadmium	Silver	Copper	Manganese
Titanium	Magnesium	Gold	Brass	Monel
Stainless Steel	Natural or Chemical			Kovar
Galvanized Steel	Black Oxide			

Loctite® Anaerobic Machinery Adhesives cure in the absence of air and presence of metal ions. When assembling inactive metal parts, which are low in metal ions, the use of Loctite® Primers are recommended to ensure proper performance of Loctite® Anaerobic Machinery Adhesives.



## WICKING

### LOCTITE® 220™ THREADLOCKER

*Medium Strength / Blue*

A low viscosity threadlocking adhesive that allows the product to wick along the threads of preassembled fasteners. Perfect for fasteners up to ¼" diameter (6 mm).

### LOCTITE® 290™ THREADLOCKER

*Medium Strength / Green*

A low viscosity, medium strength threadlocker for pre-assembled bolts up to ½" (12 mm) to secure them in place. Penetrates threads by capillary action. Seals porosities in welds and metal parts. Secures set screws and other assemblies after settings are completed. Seals welds and porous metal parts. Protects threads from rust and corrosion. Localized heating and hand tools are needed for disassembly.



### LOCTITE® 294™ THREADLOCKER

*Wicking Grade / High Temperature*

Ideally suited for pre-assembled fasteners. Performs well on oily fasteners.

## PLASTIC

### LOCTITE® 425™ ASSURE™

**INSTANT ADHESIVE**

*Surface Curing Threadlocker*

Low strength, fast curing threadlocker for plastic fasteners. Can be used as a tamper-proofing agent for the head of screws. Can be applied before or after assembly.

## PRIMERS

### LOCTITE® 7649™ PRIMER N™

Decreases the setup time of Loctite® threadlockers and increases breakaway torque on most fastener surfaces. Allows application of threadlockers in cold weather. Contains no ozone-depleting compounds.

### LOCTITE® 7088™ QUICKSTIX™ PRIMER

Semi-Solid, solventless primer. Very long on part life and speeds the cure of anaerobic products. Eliminates potential spills. Works well with structural bonders.

**NEW**

See Page 102 for more primers

**1.800.LOCTITE (562.8483)**

**www.loctite.com/distributor**

Call or visit our website to locate your nearest distributor.

#### LOW STRENGTH THREADLOCKERS



- ◆ Removable with hand tools
- ◆ Adjustment screws
- ◆ Calibration screws
- ◆ Meters and gauges
- ◆ Up to ¼" diameters

#### MEDIUM STRENGTH THREADLOCKERS



- ◆ Removable with hand tools
- ◆ Machine tools and presses
- ◆ Pumps and compressors
- ◆ Mounting bolts
- ◆ Gearboxes
- ◆ Up to ¾" diameters

#### HIGH STRENGTH THREADLOCKERS



- ◆ Permanent assembly
- ◆ Heavy equipment
- ◆ Suspension bolts
- ◆ Motor and pump mounts
- ◆ Bearing cap bolts and studs
- ◆ Up to 1" and larger diameters

#### WICKING THREADLOCKERS



- ◆ Removable with heat and hand tools
- ◆ Pre-assembled fasteners
- ◆ Instrumentation screws
- ◆ Electrical connectors
- ◆ Carburetors
- ◆ Up to ½" diameters

## DISPENSING OPTIONS

Loctite® Integrated Semiautomatic Dispenser systems combine a controller and reservoir into a single unit for valve dispensing of all Loctite® threadlockers. When used with Loctite® dispense valves, the integrated semiautomatic dispenser provides the best automatic dispensing solution. These reservoirs are large enough to accept up to 2 kg bottles, and units can be equipped with low level sensing.

	With Low-Level	Without Low-Level
0 – 15 psi	97020	97010
1 – 100 psi	97017	97007

For all dispense valve options, refer to the "Equipment" section or visit [www.equipment.loctite.com](http://www.equipment.loctite.com).



Loctite® Dispense Valves, when combined with Loctite® Controller, offer the best automated dispensing solution. The CA dispense valve, 98013, offers excellent performance when dispensing anaerobics. It is suitable for low to medium viscosity application. The stationary valve, 97113, can be used in medium viscosity applications or if a suck-back feature is required.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).



Item Number: 97113



Item Number: 98013

# Loctite® Liquid Threadlockers

## Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	TYPICAL USE	VISCOSITY (cP) <sup>†</sup>	TORQUE IN./LBS. (M10 STEEL NUTS & BOLTS) BREAK/PREVAL	TEMPERATURE RANGE	CURE SPEED (STEEL AT 25°C)	OIL TOLERANT	RECOMMENDED PRIMER	SPECIFIC GRAVITY	AGENCY APPROVALS
LOW STRENGTH	222™	21463 21464 50 ml bottle	Purple	Small screws under ¼"	1,200 / 5,000 Thixotropic	53 / 30	-65°F to 300°F	Fixture – 10 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.05	N/A
	222MS™	22205 22221 22231 22241 0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle	Purple	Easy removal, small screws under ¼"	1,200 / 5,000 Thixotropic	53 / 30	-65°F to 300°F	Fixture – 10 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.05	MIL-S-46163A for existing designs, ASTM D-5363**, NSF P1, CFIA
REMOVABLE STRENGTH	242°	24205 24221 24231 24241 24243 0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Blue	Removable grade, up to ¼" to ¾" bolts	1,200 / 5,000 Thixotropic	110 / 43	-65°F to 300°F	Fixture – 10 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.07	MIL-S-46163A for existing designs, ASTM D-5363**, NSF/ANSI 61, CFIA
	243™	23977 24077 24078 24079 21433 0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Blue	For ¼" to ¾" bolts with light oil contamination	2,250 / 12,000 Thixotropic	180 / 62	-65°F to 300°F	Fixture – 5 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.08	NSF/ANSI 61, CFIA
	246™	29513 29514 29515 10 ml bottle 50 ml bottle 250 ml bottle	Blue	High temperature, medium strength	2,600	170 / 48*	-65°F to 450°F	Fixture – 20 min. Full – 24 hrs.	Yes	7088™, N™ or T™	1.15	N/A
	QuickStix™ 248™	37684 37087 9 g stick 19 g stick	Blue	¼" to ¾" (6 mm to 20 mm)	Semisolid	110 / 43	-65°F to 300°F	Fixture – 10 min. (3 min. w/primer) Full – 24 hrs.	N/A	7088™, N™ or T™	1.10	NSF/ANSI 61, CFIA
	2033™	1029050 39 ml bottle	Blue-Green	For threads ¼" to 1" (6 mm to 25.4 mm)	Gel	142 / 62	-65°F to 300°F	Fixture – 20 min. (5 min. w/primer) Full – 24 hrs.	N/A	7088™, N™ or T™	1.09	N/A
	2432™	25523 50 ml bottle	Blue	Low halogen, low sulfur, medium strength	300	150 / 53	-65°F to 300°F	Fixture – 30 min. Full – 24 hrs.	N/A	N/A	1.08	N/A
	2440™	33946 33947 33948 10 ml bottle 50 ml bottle 250 ml bottle	Blue	Primerless, medium strength	1,800 / 6,800 Thixotropic	215 / 53*	-65°F to 300°F	Fixture – 3 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.10	N/A
HIGH STRENGTH	262™	26205 26221 26231 26241 26243 0.5 ml capsule 10 ml tube 50 ml bottle 250 ml bottle 1 liter bottle	Red	High strength locking, up to ¾" bolts	1,800 / 5,000 Thixotropic	189 / 275	-65°F to 300°F	Fixture – 5 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.05	MIL-S-46163A for existing designs, ASTM D-5363**, NSF P1, ABS, CFIA
	266™	26772 26773 26774 10 ml bottle 50 ml bottle 250 ml bottle	Red-Orange	High strength, high temperature	3,750 to 9,000	270 / 75	-65°F to 450°F	Fixture – 10 min. Full – 24 hrs.	Yes	7088™, N™ or T™	1.19	CFIA
	QuickStix™ 268™	37685 37686 9 g stick 19 g stick	Red	Up to ¾" (Up to 20 mm)	Semisolid	202 / 34	-65°F to 300°F	Fixture – 20 min. (5 min. w/primer) Full – 24 hrs.	N/A	7088™ or N™	1.06	CFIA
	271™	27105 27121 27131 27141 27143 0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Red	High strength for fasteners up to 1" diameter	500	250 / 275	-65°F to 300°F	Fixture – 10 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.10	MIL-S-46163A for existing designs, ASTM D-5363**, UL Classified for U.S., CFIA
	272™	27240 27270 27285 50 ml bottle 250 ml bottle 1 liter bottle	Red	High temperature applications	9,500	200 / 220	-65°F to 450°F	Fixture – 30 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.11	CFIA
	277™	21434 27731 27741 27743 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Red	High strength for large bolts	7,000	275 / 275	-65°F to 300°F	Fixture – 60 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.12	MIL-S-46163A for existing designs, ASTM D-5363**
	2760™	32526 32525 32527 32528 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Red	Primerless, high strength	2,900 / 10,000 Thixotropic	325 / 320*	-65°F to 300°F	Fixture – 4 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.15	CFIA
WICKING	220™	37388 39186 22041 10 ml bottle 50 ml bottle 250 ml bottle	Blue	Wicking grade for small, pre-assembled fasteners under ¼"	20	85 / 170	-65°F to 300°F	Fixture – 6 min. Full – 24 hrs.	No	7088™, N™ or T™	1.08	MIL-S-46163A for existing designs, ASTM D-5363**, CFIA
	290™	29005 29021 29031 29041 29043 0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Green	Wicking grade for pre-assembled parts	12	85 / 250	-65°F to 300°F	Fixture – 6 min. Full – 24 hrs.	N/A	7088™, N™ or T™	1.08	MIL-S-46163A for existing designs, ASTM D-5363**, NSF/ANSI 61, NSF P1, CFIA
	294™	27934 27935 27936 27937 0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle	Green	High temperature, wicking grade	34	289 / 237	-65°F to 450°F	Fixture – 6 min. Full – 24 hrs.	Yes	7088™, N™ or T™	1.13	N/A
PLASTIC	425™ Assure™	42540 42561 20 g bottle 1 lb. bottle	Blue	For small metal and plastic fasteners and tamper-proofing	80	4 / 2	-65°F to 180°F	Fixture – 1.5 min. Full – 24 hrs.	N/A	N/A	1.10	N/A
GEL	Tight®	51604 51642 50 ml tube 250 ml tube	Blue	⅛" to 1 ½" (3.175 mm to 38.1 mm)	Gel	90 / 40	-65°F to 300°F	Fixture – 20 min. (5 min. w/primer) Full – 24 hrs.	N/A	7088™ or N™	1.15	N/A
PRIMERS	7088™ QuickStix™ Primer	1069258 17 g stick		7649™ Primer N™	19269 38402 21347 21348 19266	1.75 fl. oz. glass bottle 1.75 fl. oz. aluminum bottle 25 g net wt. aerosol 4.5 oz. net wt. aerosol 1 gallon can				MIL-S-46163A for existing designs, ASTM D-5363 †, NSF/ANSI 61, NSF P1, CFIA		

\* Breakloose value. † Brookfield RVT spindle 3.20 RPM/25 RPM. \*\* For new designs.  Indicates worldwide availability.  Indicates TOP CHOICE products.

# Thread Sealing

## ***Choosing a thread sealant***

When choosing a thread sealant, there are several factors that need to be considered. The single most important question is substrate. Are you dealing with plastic threads, metal threads, or a combination of both? Plastic threads usually require a different sealant than metal threads. In some instances, the environment becomes a factor. If the application requires the sealant to be in contact with harsh chemicals, then a chemically resistant sealant should be chosen. In other cases, the type of thread comes into play. For example, if the fitting to be sealed has large coarse threads, then a sealant with more gap fill should be chosen. Similarly, a low viscosity sealant would be better suited for fine threads. When choosing a sealant, it is important to consider all of the factors. The following chart will help guide you through your choices.

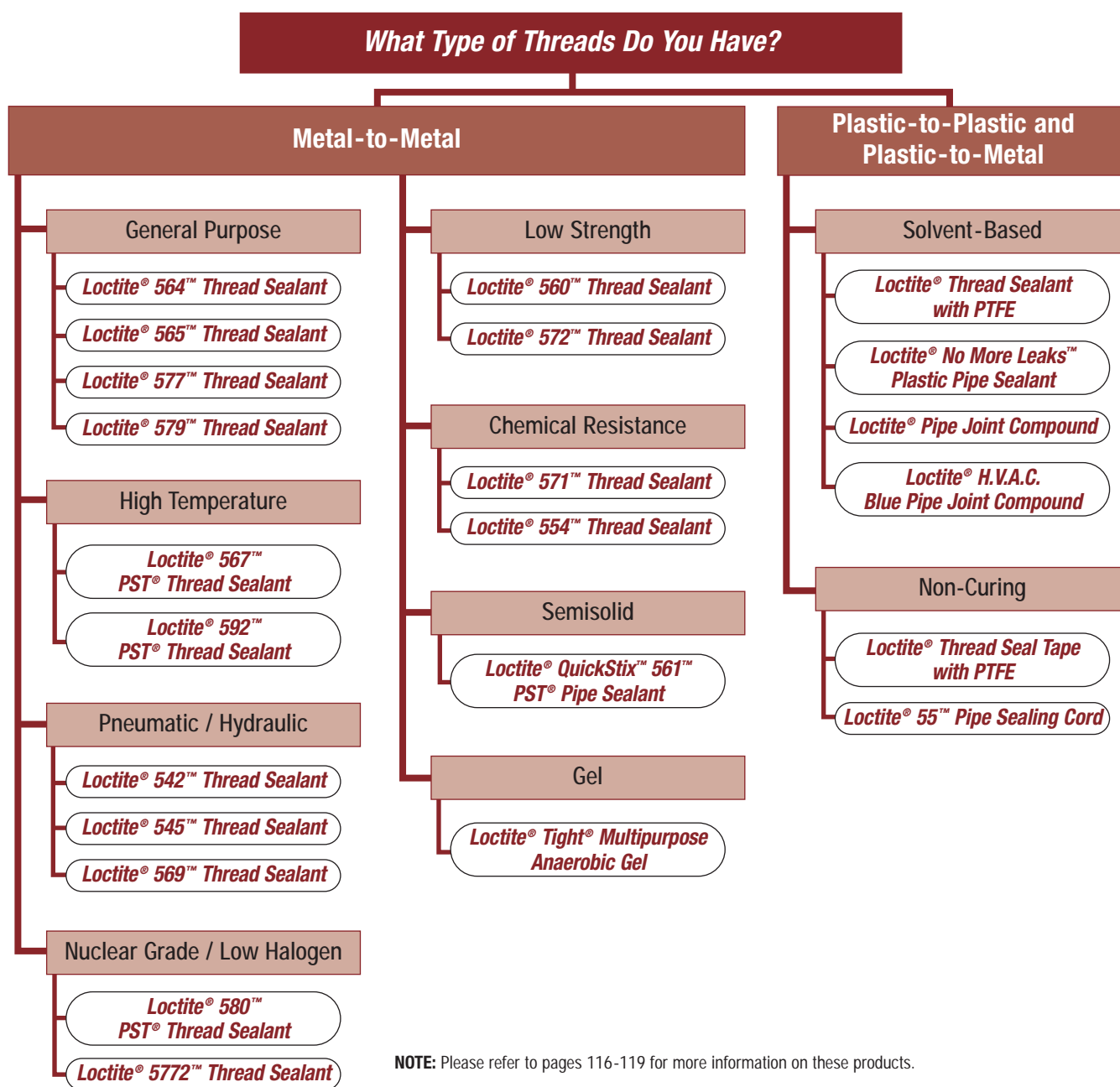
## ***Why use a solvent-based sealant on plastic fittings?***

Anaerobic sealants work when they harden in the absence of air and the presence of a metal surface. On the other hand, solvent-based sealants harden when the solvent evaporates. In the case of plastic fittings, you must rely on a solvent-based sealant since there are no metal surfaces to cure the adhesive. Similarly, in those cases when joining metal to plastic fittings, solvent-based sealants are recommended. Because only half of the substrate is metal, anaerobic sealants may produce inconsistent cure.

*This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any thread sealant.*

*Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit [www.loctite.com](http://www.loctite.com) and select "Contact Loctite." In Canada, please call **1-800-263-5043**.*

# Thread Sealing Selector Guide





# Thread Sealing

- Prevents leaks
- Single component – quick and easy to apply
- Can be used on any size pipe fitting
- Prevents corrosion and galling in threads

Loctite® liquid thread sealants seal and secure metal pipes and fittings, filling the space between threaded metal parts, and hardening to prevent leakage. Designed for low and high pressure applications, liquid thread sealants seal instantly for low pressure testing. When fully cured, they seal to the burst strength of most piping systems. The new innovative semi-solid stick formula offers added convenience and portability for general maintenance and hard-to-reach applications.

## GENERAL PURPOSE

### LOCTITE® 564™ THREAD SEALANT

#### General Purpose

Cures rapidly to provide immediate low pressure sealing. Its lower strength allows easy disassembly, and is recommended even on larger (>2" [50 mm]) diameter pipes. Protects mated threaded areas from rust and corrosion.

### LOCTITE® 565™ PST® THREAD SEALANT

#### Controlled Strength

Formulated specifically for metal tapered pipe thread fittings, this product cures rapidly to provide immediate low pressure sealing. Controlled lubricity prevents galling and protects from rust and corrosion. Can be used on fittings up to 2" (50 mm) in diameter.



### LOCTITE® 577™ THREAD SEALANT

#### Coarse Threads

Medium strength, general purpose sealant for use on coarse, threaded components.

### LOCTITE® 579™ THREAD SEALANT

#### Instant Seal

A general purpose pipe sealant that cures into a resistant plastic. Excellent solvent resistance. Withstands temperatures to 300°F. Sealing is effective on threaded joints up to 2" in diameter.

## HIGH TEMPERATURE

### LOCTITE® 567™ PST® THREAD SEALANT

#### High Temperature

This product has excellent solvent resistance, allows easy assembly, prevents galling, and can withstand temperatures up to 400°F. Excellent for high pressure applications: locks and seals tapered metal, pipe threads and fittings. Ideal for stainless steel, aluminum, galvanized metal, and other inert metals. Disassembles with hand tools.



### LOCTITE® 592™ PST® THREAD SEALANT

#### Slow Cure

Locks and seals threaded fittings. Parts may be repositioned up to 24 hours after application.

## HYDRAULIC SEALANT

### LOCTITE® 542™ THREAD SEALANT

#### Fine Threads

A liquid sealant recommended for sealing the fine threads of hydraulic and pneumatic connectors.

### LOCTITE® 545™ THREAD SEALANT

#### Hydraulic / Pneumatic Fittings

Contains no fillers or particles that could contaminate system fluids, foul valves, or clog fine filters and screens. Suitable for fittings up to 2" (50 mm) in diameter. Excellent solvent resistance.



## HYDRAULIC SEALANT (continued)

### LOCTITE® 569™ THREAD SEALANT

#### Hydraulic Fittings

Low viscosity original hydraulic sealant. Designed for sealing fine threaded hydraulic fittings. Contains no fillers and has good chemical resistance.

## NUCLEAR GRADE / LOW HALOGEN

### LOCTITE® 580™ PST® THREAD SEALANT

#### Low Sulfur

For threaded fittings in fossil fuel, solar and hydro plant piping systems.

### LOCTITE® 5772™ THREAD SEALANT

#### Low Sulfur

A medium strength thread sealant with fast curing properties. Specially developed for use on sensitive metals, like titanium, used in the nuclear industry. Parts can be separated using hand tools.

## LOW STRENGTH

### LOCTITE® 560™ THREAD SEALANT

#### Low Strength

Designed for sealing of metal pipes and fittings. This product seals instantly for low pressure testing. It can be easily removed on large pipe assemblies.

### LOCTITE® 572™ THREAD SEALANT

#### Low Strength

Low strength sealant with moderate fixture speed for use on coarse threads.

## CHEMICAL RESISTANCE

### LOCTITE® 554™ THREAD SEALANT

#### Refrigerant Sealant

Excellent solvent resistance on threaded fittings and pipes up to 3" in diameter. Recommended for refrigeration systems and service with aggressive chemicals.

### LOCTITE® 571™ THREAD SEALANT

#### Chemical Resistance

Medium strength thread sealant designed for locking and sealing against corrosive products. Shows excellent strength after long exposures to many chemicals.

## SEMISOLID STICK

### LOCTITE® QUICKSTIX™ 561™ PST® PIPE SEALANT



New, patented, semisolid stick formula offers added convenience and portability. Like Loctite® 565™ PST®, this product has immediate low pressure sealing, eases disassembly, and will not contaminate or clog lines. The semisolid formula also means it won't spill or leak, making it great for overhead applications or carrying in a pocket or toolbox.

## GEL

### LOCTITE® TIGHT® MULTIPURPOSE ANAEROBIC GEL

This product seals, locks, and retains. It seals against most liquids and gases, and works well on coarse threads, large gaps, and all overhead applications.

## SOLVENT-BASED

### LOCTITE® THREAD SEALANT WITH PTFE

A general purpose sealant with the added lubricity of PTFE for metal pipes. Won't shred like tape and allows easy disassembly. Resists common shop fluids.

### LOCTITE® PIPE JOINT COMPOUND

Economical, general purpose pipe thread sealant that will not shred like tape and allows easy disassembly. Resists common shop fluids.

### LOCTITE® NO MORE LEAKS™ PLASTIC PIPE SEALANT

Seals plastic pipes and allows easy disassembly. Specially formulated without the added lubricity of PTFE to avoid typical cracks when plastic joints are over tightened.

### LOCTITE® H.V.A.C. BLUE PIPE JOINT COMPOUND

Tough, pliable sealant specially formulated for heating, air conditioning, and refrigeration applications. Sets up quickly for immediate assembly and to keep joints tight in areas of high vibration and thermal cycling. Seals oils, refrigerants, butane, propane, natural gas, and more. Easy cleanup.

## NON-CURING

### LOCTITE® THREAD SEAL TAPE WITH PTFE

Tape (½" x 520") with plastic spool and shell. Can be used in applications with temperatures up to 500°F. Oxygen service compatible.

### LOCTITE® 55™ PIPE SEALING CORD

A general purpose threaded pipe and fitting sealant. A non-curing, coated multifilament cord that seals out air and other common gases and fluids. Recommended for sealing metal and plastic tapered pipe fittings up to 4" NPT. Allows for post assembly adjustments.

## PRIMER

### LOCTITE® 7088™ QUICKSTIX™ PRIMER



Semi-Solid, solventless primer. Very long on part life and speeds the cure of anaerobic products. Eliminates potential spills. Works well with structural bonders.

See Page 102 for more primers



# Loctite® Liquid Thread Sealants Properties Chart

	PRODUCT	Item Number	Package Type & Size	TYPICAL USE	COLOR AND APPEARANCE	VISCOSITY (cP)	TEMPERATURE RANGE	PRESSURE RESISTANCE (psi)	RECOMMENDED PRIMER	AGENCY APPROVALS
GENERAL PURPOSE	564™	28754 28755	50 ml tube 250 ml tube	General purpose, low strength for large diameter pipe	White	90,500	-65°F to 300°F	10,000	7088™, N™ or T™	CSA International, ULC Classified for Canada, NSF/ANSI 61, CFIA
	565™ PST®	56507 56531 56541 56571 56543 56566	6 ml tube 50 ml tube 250 ml tube 300 ml cartridge 1 liter bottle 10 liter bottle	Controlled strength	White	300,000	-65°F to 300°F	10,000	7088™, N™ or T™	CSA International, ULC Classified for U.S., ULC Classified for Canada, NSF/ANSI 61, CFIA
	577™	21456 21457	50 ml tube 250 ml tube	Medium strength, coarse threads	Yellow	24,000/80,000 Thixotropic	-65°F to 300°F	10,000	7088™, N™ or T™	N/A
	579™	57941	250 ml tube	Low strength, instant seal	Silver / Brown	20,000	-65°F to 300°F	10,000	7088™, N™ or T™	N/A
HIGH TEMPERATURE	567™ PST®	56707 56747 56765 33241 56790	6 ml tube 50 ml tube 250 ml tube 350 ml brush can 1 liter bottle	For stainless steel and all other metal fittings	White	540,000	-65°F to 400°F	10,000	7088™, N™ or T™	CSA International, ULC Classified for U.S., ULC Classified for Canada, ABS, CFIA, NSF/ANSI 61
	592™ PST®	59214 59231 59241 59243	6 ml tube 50 ml tube 250 ml tube 1 liter bottle	Medium strength	White	350,000	-65°F to 400°F	10,000	NF™	UL Classified for U.S., ULC Classified for Canada, CFIA
HYDRAULIC & PNEUMATIC	542™	21453 37795	50 ml bottle 250 ml bottle	Fine threads	Brown	525 / 1,850 Thixotropic	-65°F to 300°F	10,000	7088™, N™ or T™	N/A
	545™	54505 32429 54531 54541	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle	Pneumatic hydraulic sealant, no fillers	Purple	14,000	-65°F to 300°F	10,000	7088™, N™ or T™	ABS, CFIA
	569™	56931 56941 56943	50 ml bottle 250 ml bottle 1 liter bottle	Original hydraulic sealant	Brown	400	-65°F to 300°F	10,000	7088™, N™ or T™	CFIA
NUCLEAR GRADE/ LOW HALOGEN	580™ PST®	58031	50 ml tube	Low halogen, low sulfur, PTFE-free	White	600,000	-65°F to 300°F	10,000	N/A	N/A
	5772™	25524	50 ml bottle	Low halogen, low sulfur, medium strength, fast cure	Yellow	7,500	-65°F to 300°F	10,000	N/A	N/A
LOW STRENGTH	560™	11782 11505	250 ml bottle 1 liter bottle	Large diameter, slow cure, low strength	Off-White	200,000 / 800,000	-65°F to 300°F	10,000	7088™, N™ or T™	N/A
	572™	21454	50 ml tube	Coarse threads	White	17,000/50,000 Thixotropic	-65°F to 300°F	10,000	7088™, N™ or T™	N/A
CHEMICAL RESISTANCE	554™	25882 55441	10 ml bottle 250 ml bottle	Refrigerant sealant, high strength	Red	2,500	-65°F to 300°F	10,000	7088™, N™ or T™	CFIA
	571™	57141	250 ml bottle	High strength, excellent solvent resistance	Brown	2,000	-65°F to 300°F	10,000	7088™, N™ or T™	Mil-S-22473E for existing designs, ASTM D-5363 for new designs
SEMSOLID STICK	QuickStix™ 561™ PST®	37127	19 g stick	General purpose, portable, overhead	White Paste	Semisolid paste	-65°F to 300°F	10,000	7088™, N™ or T™	UL Classified for U.S., ULC Classified for Canada, CSA International, CFIA, NSF/ANSI 61
GEL	Tight®	51604 51642	50 ml tube 250 ml tube	General purpose, vertical	Green Gel	Gel	-65°F to 300°F	1,000	7088™, N™ or T™	N/A
SOLVENT-BASED	Thread Sealant with PTFE	30534 30561	0.25 pt. brush can 1 pt. brush can	General purpose, metal pipes, added lubricity	White Paste	50,000 to 60,000	-65°F to 300°F	5,000	N/A	CFIA
	Pipe Joint Compound	30556 30557	0.25 pt. brush can 1 pt. brush can	General purpose, non-shredding, chemical resistant	Black Paste	35,000 to 45,000	-65°F to 400°F	5,000	N/A	N/A
	No More Leaks™	80725 80724 80726	2 fl. oz. tube 7 fl. oz. tube 1 pt. brush can	Plastic pipes, easy disassembly	White Paste	90,000 to 110,000	-65°F to 400°F	5,000	N/A	CFIA
	H.V.A.C. Blue Pipe Joint Compound	82480 82481	0.25 pt. brush can 1 pt. brush can	Heating, air conditioning, refrigeration	Blue Paste	20,000 to 30,000	-65°F to 400°F	5,000	N/A	CFIA
NON-CURING	Thread Seal Tape with PTFE	39904	½" x 520" x 0.003"	General purpose, oxygen service compatible	White Tape	N/A	Up to 500°F	Pressure Rating for Pipe	N/A	Conforms to MIL-T-27730
	55™ Pipe Sealing Cord	39036 35082	1,968 inches 5,700 inches	Metal and plastic compatible, allows post adjustment	White Coated Cord	N/A	Up to 300°F	10,000	N/A	UL Classified for U.S., CSA International, NSF/ANSI 61



Indicates worldwide availability.



Indicates TOP CHOICE products.



## Loctite® Dispensing Equipment

Henkel has a complete line of off-the-shelf equipment systems for dispensing Loctite® thread sealants. These manual and semiautomatic equipment systems are designed to reduce waste and operator contact.

**Loctite® Dial-A-Seal® Applicator** is a touch-actuated, all-pneumatic applicator for dispensing thread sealants onto threaded pipe fittings. The system has a quick turn turret that is equipped with cavities for  $\frac{1}{16}$ ,  $\frac{1}{8}$ ,  $\frac{1}{4}$ ,  $\frac{3}{8}$ ,  $\frac{1}{2}$ ,  $\frac{3}{4}$  and 1" male pipe threads. This applicator accepts 50 ml or 250 ml tubes or 1 liter wide-mouth bottles.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

**Item Number:** 998400



**Loctite® 50 ml and 250 ml Hand Pumps** are portable, precise, bottle-top applicators that thread directly onto any 50 ml or 250 ml anaerobic bottle. They are designed to dispense at any angle, in drop sizes from 0.01 to 0.04 ml, and with viscosities up to 30,000 cP. There are no leaks or product waste.

For available spare parts, accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

**Item Numbers:** 97001 (250 ml bottles)  
98414 (50 ml bottles)



## Loctite® Dispense Tips

Henkel offers a comprehensive line of Loctite® tapered polyethylene and flexible polypropylene dispense tips. All tips are designed to stay intact during the toughest applications and provide reliable and consistent dispensing shot after shot.

For available accessories and dispense tips, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

**Loctite® Cartridge Dispense Tip,  $\frac{1}{4}$ " Male NPT**

**Item Number:** 98128



**$\frac{3}{4}$ " x  $\frac{3}{8}$ " NPT Dispense Nozzle** is designed for dispensing thread sealants in wide bands on pipe threads and fittings.

**Item Number:** 98610



## Finding the right thread sealant for the application

### 1. What are the benefits of using thread sealants?

Thread sealants provide tight seals between joints, can withstand immense pressures, allow for easier assembly and disassembly, prevent corrosion, and prevent parts from "welding" to one another.

### 2. Which sealants have potable water approvals?

The following Loctite® thread sealants all have a NSF 61 potable water approval rating: Loctite® QuickStix™ 561™ PST®, 55™ Pipe Sealing Cord, 564™, 565™ PST®, and 567™ PST®.

### 3. What is galling?

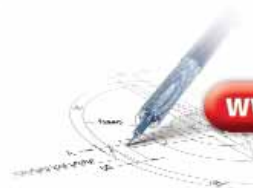
Galling occurs when metals weld together due to lack of or ineffective lubrication during assembly. Without proper lubrication, mating surfaces wear against each other and result in "welding" or seizure. Sealants containing PTFE increase lubricity, reduce galling, and enable easier assembly and disassembly.

### 4. Are there any thread sealants available that are compatible with systems in oxygen rich environments?

Loctite® Thread Seal Tape with PTFE is the only thread sealing product that is compatible with systems in oxygen rich environments.

### 5. Why is the "squeeze out" material around the joint not cured?

In order for anaerobic material to cure, there has to be two mating metal surfaces. Any excess material that squeezes from the assembly can simply be wiped away.



[www.equipment.loctite.com](http://www.equipment.loctite.com)



# Toolboxes & Specialty Kits



## SPECIALTY REPAIR

### LOCTITE® FORM-A-THREAD® STRIPPED THREAD REPAIR KIT

Permanently repairs stripped threads and fasteners in five minutes (up to SAE Grade 5 English and 8.8 metric). Allows up to 1,538 in. lbs. torque (on 1" bolt) and 300°F. Resists most shop fluids.

### LOCTITE® O-RING MAKING KIT

**NEW**

Makes replacement, high performance o-rings in less than a minute. This compact kit contains three-foot lengths of common diameters of Buna N cord, Loctite® 404™ Quick Set™ Instant Adhesive, o-ring fixture, blade, a waterproofing solution, and a cleanup solution.

*Available in Metric and Standard.*

*Cut and splice tool and standard size cord stock is available.*

### LOCTITE® PIPE REPAIR KIT

Urethane impregnated fiberglass tape, activated by water, for reliable, temporary repairs of metal, plastic, and composite pipes. Includes Loctite® Fixmaster® Metal Magic Steel™ epoxy stick, urethane impregnated fiberglass tape, and gloves. Cures in 30 minutes.

## GENERAL MAINTENANCE

### LOCTITE® MAINTENANCE TACKLEBOX

Designed to fit in a mechanics tool chest, this kit contains 11 great Loctite® products and a Loctite® "Do-it-Right" Users Guide.

### LOCTITE® QUICK SERVICE TOOLKIT

The "original" Loctite® kit containing 8 of the most common Loctite® products.

### LOCTITE® TOOLBOX

**NEW**

Containing 16 of the latest and best Loctite® technologies to solve the most common mechanical failures, this kit has everything a professional needs to increase reliability at the base component level.

### LOCTITE® MANUFACTURING RELIABILITY TOOLBOX

Contains 13 Loctite® products and is used during Loctite® Manufacturing Reliability Training.

### LOCTITE® RELIABILITY TACKLEBOX

**NEW**

An alternative to the Loctite® Manufacturing Reliability Toolbox, this kit contains 14 Loctite® products for use during Manufacturing Reliability Training.

## DISPENSING OPTIONS




### Loctite® Precision O-Ring Cut and Splice Tool

is a patent pending, digital, industrial grade tool that provides precise measuring, cutting and bonding of both standard and metric o-ring cord stock. For use with Loctite® Precision O-Ring Kit, Item Number 8900513.

**Item Number:** 98613 **Weight:** 2.8 lbs.



# Loctite® Toolboxes & Specialty Kits Ordering Chart

PRODUCT		Item Number	Kit Contents and Container	MAXIMUM TEMPERATURE RESISTANCE	ADHESIVE APPEARANCE	AGENCY APPROVALS
SPECIALTY REPAIR	Form-A-Thread® Stripped Thread Repair Kit	28654	12.9 ml kit	300°F	Grey (Mixed)	CFIA
	Loctite® O-Ring Making Kit 	Standard 00112  Metric 40488	1 oz. waterproofing solution, part number 74126 1 oz. cleanup solvent, part number 75326 1/3 oz. 404™ Quick Set™ instant adhesive Fixture and cutting blade [STANDARD] Cord - 3/32", 1/8", 3/16", 1/4" 98613 Precision O-ring Cut & Splice Tool 8900591 O-ring Stock, Buna N, 1/4" x 5 feet 8900589 O-ring Stock, Buna N, 1/8" x 5 feet 8900588 O-ring Stock, Buna N, 3/32" x 5 feet 8900590 O-ring Stock, Buna N, 3/16" x 5 feet [METRIC] Cord 1.6 mm, 2.4 mm, 3.0 mm, 5.7 mm, 8.4 mm	N/A	Clear	CFIA
	Pipe Repair Kit	96321 96322	2" x 6' tape 4" x 12' tape	250°F	Yellow	CFIA
GENERAL MAINTENANCE	Loctite® Maintenance Tacklebox	33486	242™ Threadlocker, Medium Strength, 50 ml QuickStix™ 248™ Threadlocker, Medium Strength, 9 g 262™ Threadlocker, High Strength, 50 ml QuickStix™ 268™ Threadlocker, High Strength, 9 g 609™ Retaining Compound, 10 ml 660™ Quick Metal® Retaining Compound, 50 ml QuickStix™ 561™ PST® Pipe Sealant, 19 g 518™ Gasket Eliminator® Flange Sealant, 50 ml 598™ Black High Performance Silicone, 70 ml 7649™ Primer N™, 25 g net wt. aerosol can QuickTite® Instant Adhesive Gel, 0.14 oz. net wt. bottle	N/A	N/A	N/A
	Loctite® Quick Service Toolkit 	00101	242™ Threadlocker, Medium Strength, 10 ml 262™ Threadlocker, High Strength, 10 ml 7649™ Primer N™, 4.5 oz. aerosol 454™ Prism® Instant Adhesive Gel, 3 g 660™ Quick Metal® Retaining Compound, 6 ml 565™ PST® Thread Sealant, 50 ml 587™ Blue RTV Silicone Gasket Maker, 70 ml 518™ Gasket Eliminator® Flange Sealant, 50 ml	N/A	N/A	N/A
	Loctite® Toolbox	38956	220™ Threadlocker, Low Strength / Wicking, 10 ml 222MS™ Threadlocker, Low Strength / Small Screw, 10 ml QuickStix™ 248™ Threadlocker, Medium Strength, 9 g QuickStix™ 268™ Threadlocker, High Strength, 9 g 2440™ Threadlocker, Primerless Medium Strength, 10 ml 2760™ Threadlocker, Primerless High Strength, 10 ml 518™ Gasket Eliminator® Flange Sealant, 50 ml 545™ Thread Sealant, Hydraulic / Pneumatic, 10 ml QuickStix™ 561™ PST® Pipe Sealant, 19 g 565™ PST® Thread Sealant, 50 ml 587™ Blue, High Performance RTV Silicone, 70 ml 641™ Retaining Compound, Low Strength, 10 ml 660™ Quick Metal® Retaining Compound, 50 ml QuickStix™ C5-A® Copper Anti-Seize, 20 g 7649™ Primer N™, 1.75 oz. net wt. aerosol can QuickTite® Instant Adhesive Gel, 0.14 oz. net wt. bottle	N/A	N/A	N/A
	Loctite® Manufacturing Reliability Toolbox 	31362	222MS™ Threadlocker, Low Strength / Small Screw, 10 ml 242™ Threadlocker, Medium Strength, 50 ml QuickStix™ 248™ Threadlocker, Medium Strength, 9 g 262™ Threadlocker, High Strength, 50 ml 290™ Threadlocker, Wicking Grade, 50 ml 518™ Gasket Eliminator® Flange Sealant, 50 ml 545™ Thread Sealant, Hydraulic / Pneumatic, 10 ml 565™ PST® Thread Sealant, 50 ml 609™ Retaining Compound, 10 ml 660™ Quick Metal® Retaining Compound, 50 ml 7649™ Primer N™, 1.75 oz. net wt. aerosol can Instant Gasket, 7 oz. net wt. can QuickTite® Instant Adhesive Gel, 0.14 oz. net wt. bottle	N/A	N/A	N/A
	Loctite® Reliability Tacklebox	39062	220™ Threadlocker, Low Strength / Wicking, 10 ml 222MS™ Threadlocker, Low Strength / Small Screw, 10 ml 243™ Threadlocker, Medium Strength / Oil Resistant, 50 ml QuickStix™ 248™ Threadlocker, Medium Strength, 19 g QuickStix™ 268™ Threadlocker, High Strength, 19 g 515™ Gasket Eliminator® Flange Sealant, 50 ml QuickStix™ 561™ PST® Pipe Sealant, 19 g 567™ PST® Thread Sealant, High Temperature, 50 ml 609™ Retaining Compound, 50 ml 660™ Quick Metal® Retaining Compound, 50 ml 7649™ Primer N™, 1.75 oz. net wt. aerosol can Instant Gasket, 7 oz. net wt. can QuickStix™ Silver Grade Anti-Seize, 20 g QuickTite® Instant Adhesive Gel, 0.14 oz. net wt. bottle	N/A	N/A	N/A

# Medical Application Solutions

Loctite® adhesives have been specified by medical device manufacturers all over the world for over two decades. Our experience, products and engineering services are second to none, with the world's most diversified and comprehensive line of adhesives, dispensing equipment, and curing systems available anywhere. We offer nearly fifty products for medical device assemblies requiring biocompatibility, and hundreds of other products for applications not requiring toxicity testing.

**Loctite® medical device adhesives offer many benefits, including:**

- ✓ Comprehensive ISO 10993 Biocompatibility Testing
- ✓ Ability to Bond Dissimilar and Difficult Substrates
- ✓ Even Stress Distribution
- ✓ Excellent Gap Filling Capability
- ✓ Rapid Fixture and Overall Cure Times
- ✓ Structural Bonds
- ✓ Increased Throughput

Our medical device adhesives cover almost every adhesive chemistry conceivable, providing you with a wide range of choices and assembly solutions. We know one product won't fit every design, and that's why we continue to create and add new products, new chemistries, and even new technologies. No matter what the application, chances are we have the right adhesive for the job. Our products are available in viscosities ranging from water-thin liquids to thixotropic gels and are compatible with common sterilization methods such as ethylene oxide, gamma radiation, electron beam, liquid sterilization, autoclave, and peroxide plasma.

**Getting started – selecting a medical device adhesive**

The following chart has been designed to help you select a medical device adhesive. This chart is intended to serve as a general guideline to help you determine which adhesive categories are best suited for your application. The data presented represents typical properties for each adhesive category; however, individual product properties may differ. Individual product information can be found on the pages that follow to help you narrow your search.

This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any adhesive.

Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit [www.loctite.com](http://www.loctite.com) and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

**Henkel's Medical Device Training Programs**

Henkel offers training programs that provide additional support to device manufacturers. Training support continues after the seminar with links to a network of informational sources including adhesive design guides, research data, and technical reports.

For more information on Henkel's Advanced Medical Device Adhesive Workshops and our On-Site Seminar Program, visit us on the web or call **1-800-LOCTITE** (562-8483).



[www.loctite.com/medical](http://www.loctite.com/medical)

Henkel offers the most comprehensive line of Loctite® adhesives and sealants available to the medical device industry. These ISO-10993 compliant products are designed specifically for the assembly of medical devices where toxicity testing and sterilization resistance are required.

## Medical Applications Solutions Selector Guide

PERFORMANCE CONSIDERATIONS	ADHESIVE CATEGORY				
	Cyanoacrylates	Epoxies	Light Cure Adhesives	Silicones	Urethanes
<b>BENEFITS</b>	Wide range of bonding applications	Wide range of formulations	Rapid cure / adhesion to plastics	Excellent temperature resistance	Excellent toughness / flexibility
<b>LIMITATIONS</b>	Low solvent resistance	Mixing required	Light cure system required	Low cohesive strength	Sensitive to moisture
<b>TEMPERATURE RESISTANCE</b>					
Typical for the Category	-65°F to +180°F	-65°F to +300°F	-65°F to +300°F	-65°F to +350°F	-65°F to +250°F
Highest Rated Product	+250°F	+300°F	+300°F	+350°F	+250°F
<b>ENVIRONMENTAL RESISTANCE</b>					
Polar Solvents (ex. H <sub>2</sub> O, Ethylene Glycol IPA, Acetone)	Poor <sup>1</sup>	Very Good	Good	Good	Good
Non-Polar Solvents (ex. Motor Oil, Toluene, Gasoline, ATF)	Good	Excellent	Very Good	Poor to Fair	Good
<b>ADHESION TO SUBSTRATES</b>					
Metals	Very Good	Excellent	Good	Good	Good
Plastics <sup>2</sup>	Excellent	Fair	Excellent	Good	Very Good
Glass	Poor	Excellent	Excellent	Good	Good
Rubber	Very Good	Fair	Fair	Fair	Good
<b>OVERLAPPING SHEAR STRENGTH</b>	High	High	High	Low	Medium
<b>PEEL STRENGTH</b>	Low <sup>3</sup>	Medium	Medium	Medium	Medium
<b>TENSILE STRENGTH</b>	High	High	High	Low	Medium
<b>ELONGATION / FLEXIBILITY</b>	Low	Low	Medium	Very High	High
<b>HARDNESS</b>	Rigid	Rigid	Semi-Rigid	Soft	Soft
PROCESS CONSIDERATIONS	ADHESIVE CATEGORY				
	Cyanoacrylates	Epoxies	Light Cure Adhesives	Silicones	Urethanes
<b>NUMBER OF COMPONENTS</b>	1	1 and 2	1	1	2
<b>CURE TEMPERATURES</b>	Room Temperature	Heat or Room Temperature	UV / Visible	UV / Visible	Room Temperature
<b>FIXTURE TIME</b>					
Average	60 seconds	5 hours	30 seconds	10 minutes	5 hours
Fastest	5 seconds	15 to 20 minutes	5 seconds	60 seconds	5 hours
<b>FULL CURE TIME</b>	24 hours	½ to 24 hours	30 to 60 seconds	24 hours	24 hours
<b>GAP FILL</b>					
Ideal (in inches)	0.001 to 0.003	0.004 to 0.006	0.002 to 0.010	0.004 to 0.006	0.004 to 0.006
Maximum (in inches)	0.010	0.5	0.25	0.25	0.5
<b>DISPENSING / MIXING EQUIPMENT REQUIRED</b>	No	Yes (2 parts)	No	No	Yes
<b>LIGHT CURE VERSIONS AVAILABLE?</b>	Yes	No	Yes	Yes	No
<i>For more information on each adhesive category, refer to pages...</i>	126-127	128-129	124-125	128-129	128-129

<sup>1</sup> Cyanoacrylates have very good moisture resistance on plastics.

<sup>2</sup> Uncured liquid adhesives may cause stress cracking of certain thermoplastics, e.g., polycarbonate, acrylic, and polysulfone. Special products and process techniques are available. Consult the Loctite® Design Guide to Bonding Plastics (LT-2197) or contact 1-800-LOCTITE (562-8483) for more information.

<sup>3</sup> Exception: Toughened cyanoacrylates have HIGH peel strength.



# Acrylic Adhesives



## ACRYLICS

### LOCTITE® 3201™/3211™

#### LIGHT CURE ADHESIVES

##### Polycarbonate / Thermoplastics

High viscosity, UV / visible adhesives that form very flexible joints with minimal stress cracking. Ideal for bonding polycarbonate and other thermoplastics.

### LOCTITE® 3301™/3311™/3321™

#### LIGHT CURE ADHESIVES

##### Plastic / Metal

Low viscosity, slightly flexible, UV / visible adhesives. Excellent for bonding thermoplastics and plasticized PVC.

### LOCTITE® 3341™ LIGHT CURE ADHESIVE

#### Plasticized Substrates

A rapid cure, UV / visible, fluorescing adhesive that bonds highly plasticized PVC and other difficult-to-bond substrates.

### LOCTITE® 3345™ LIGHT CURE ADHESIVE

#### Glass / Metal

A medium viscosity, UV adhesive with superior steam sterilization resistance. Excellent for bonding glass, metal, and select plastics.

### LOCTITE® 3381™ LIGHT CURE ADHESIVE

#### Flexible / Plastics

A highly resilient, extremely flexible, thermal cycling resistant UV adhesive that bonds most plastics.

### LOCTITE® 3554™/3555™/3556™ INDIGO™ VISIBLE LIGHT CURE ADHESIVES

Low, medium and high viscosity adhesives that cure in the visible spectrum offering properties and performance similar to most UV / visible adhesives. Visible light adhesives cure with unique systems that minimize venting or specialized safety equipment. Benefits include lower initial investment and reduced maintenance costs.



### LOCTITE® 3921™/3922™/3924™/ 3926™ LIGHT CURE ADHESIVES

#### Plastic / Metal

Fluorescing, UV / visible adhesives offering superior sterilization resistance. Ideal for bonding a wide variety of plastic and metal components where environmental resistance is required.



### LOCTITE® 3941™/3942™/3943™ LIGHT CURE ADHESIVES

#### High Performance / Various Substrates

Fluorescing, UV / visible acrylic adhesives. Ideal for applications where high strength on a variety of substrates and rapid surface cure are required.



### LOCTITE® 3971™/3972™ LIGHT CURE ADHESIVES

#### Plasticized Substrates

Rapid curing, UV / visible, fluorescing adhesives that bond highly plasticized materials, including PVC and polyurethane.



## CURING OPTIONS

Loctite® 7700-HD Item Number: 98601

Loctite® 7703-HD Item Number: 883979

Long life LED technology, highest LED output in the market.

For more information, refer to the "Equipment" section or visit [www.equipment.loctite.com](http://www.equipment.loctite.com).



## CURING AND DISPENSING OPTIONS

Loctite® CureJet™ 405 LED Item Number: 976420

Loctite® CureJet™ Indigo™ LED Item Number: 976418

Our highest powered LED spot curing systems.

Innovative design offers significantly wider cure area and curing intensity capability than our single point LED devices.



## Loctite® Digital Syringe Dispensing System

A semiautomatic dispensing system designed to dispense adhesives and fluids. Digital timing control for increased precision over typical pressure-time systems. Adjustable pressure regulator controls a pulse of air providing a controlled dispensed amount of adhesive. Can be operated in manual, incremental, or timed (automatic) dispense mode.



Item Number: 883976 For additional accessories please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

## Loctite® Medical Device Acrylic Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	APPEARANCE / CLARITY / COLOR	CURE TYPE	KEY SUBSTRATES	VISCOSITY (cP) BROOKFIELD (25°C)	TEMPERATURE RANGE	ISO 10993 COMPLIANT
ACRYLIC VISIBLE WITH FLUORESCENCE	3554™ Indigo™ 	1072199 1 liter bottle	Clear / Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	300	-65°F to 300°F	✓
	3555™ Indigo™ 	1072221 1 liter bottle	Clear / Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	3,000	-65°F to 300°F	✓
	3556™ Indigo™ 	1072223 1 liter bottle	Clear / Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	5,000	-65°F to 300°F	✓
ACRYLIC UV/VISIBLE WITH FLUORESCENCE	3341™	23792 1 liter bottle	Clear / Straw / Fluorescent	Ultraviolet, visible	Thermoplastics, polyvinylchloride	450	-65°F to 300°F	✓
	3911™	36536 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic	100	-65°F to 300°F	✓
	3912™	36539 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic	6,300	-65°F to 300°F	✓
	3921™ 	36484 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	150	-65°F to 300°F	✓
	3922™ 	32083 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	300	-65°F to 300°F	✓
	3924™ 	36488 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	1,100	-65°F to 300°F	✓
	3926™ 	36492 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	4,500	-65°F to 300°F	✓
	3933™	32084 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	3,250	-65°F to 300°F	✓
	3936™	32304 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	10,000	-65°F to 300°F	✓
	3941™ 	36437 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, thermoset plastic	480	-65°F to 300°F	✓
	3942™ 	36483 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, thermoset plastic	1,200	-65°F to 300°F	✓
	3943™ 	36480 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, thermoset plastic	6,000	-65°F to 300°F	✓
	3944™	38210 1 liter bottle	Fluorescent / Pale Yellow	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	5,000	-65°F to 300°F	✓
	3971™ 	36792 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Metal, thermoplastic, polyvinylchloride, polyurethane	320	-65°F to 300°F	✓
	3972™ 	36294 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet, visible	Metal, thermoplastic, polyvinylchloride, polyurethane	4,500	-65°F to 300°F	✓
ACRYLIC UV/VISIBLE % FLUORESCENCE	3201™	19727 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	4,000	-65°F to 300°F	✓
	3211™	19730 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	10,000 Thixotropic	-65°F to 300°F	✓
	3301™	19733 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	150	-65°F to 300°F	✓
	3311™	19736 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	300	-65°F to 300°F	✓
	3321™	19739 1 liter bottle	Clear / Pale Straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	5,000	-65°F to 300°F	✓
ACRYLIC UV ONLY	3345™	33417 1 liter bottle	Clear / Pale Straw	Ultraviolet	Glass, metal	1,500	-65°F to 300°F	✓
	3381™	25785 1 liter bottle	Translucent / Colorless	Ultraviolet	Thermoplastic, thermoset plastic	5,000	-65°F to 300°F	✓
	3913™	36791 1 liter bottle	Transparent to Hazy / Fluorescent	Ultraviolet	Glass, metal, thermoplastic	8,500	-65°F to 300°F	✓

Indicates TOP CHOICE products.

\* Made-to-Order Item.



# Cyanoacrylates, Accelerators & Primers



## CYANOACRYLATES

### LOCTITE® 4011™ PRISM® MEDICAL DEVICE INSTANT ADHESIVE

A low viscosity, instant adhesive ideally suited for dry environments, as well as for bonding acidic surfaces.



### LOCTITE® 431™ PRISM® INSTANT ADHESIVE



A high viscosity, instant adhesive ideally suited for dry environments, as well as for bonding acidic and porous surfaces.



### LOCTITE® 435™ PRISM® INSTANT ADHESIVE



#### Surface Insensitive / Toughened

The first true *clear, surface insensitive*, elastomer-modified instant adhesive. Faster fixture times over traditional toughened adhesives with exceptional bond and peel strength on metals, plastics, and rubbers.

### LOCTITE® 4541™ PRISM® INSTANT ADHESIVE

#### Gel

Designed for the assembly of difficult-to-bond materials that require uniform stress distribution. Particularly suited for bonding porous or absorbent materials. Also formulated for faster cure speeds on dry or acidic surfaces and substrates.



### LOCTITE® 4851™/4861™ PRISM® INSTANT ADHESIVES

#### Flexible

Medium and high viscosity instant adhesives for the assembly of flexible components.

## LIGHT CURE CYANOACRYLATES

### LOCTITE® 4306™/4307™ FLASHCURE® LIGHT CURE ADHESIVES

Low or high viscosity fluorescent adhesives that achieve tack-free cures in less than 5 seconds. Surface versatile with shadow cure capability.



## PRIMERS

### LOCTITE® 7701™ PRISM® MEDICAL DEVICE PRIMER

An adhesion promoter formulated for use with polyolefins and other low surface energy plastic materials. Use with Loctite® cyanoacrylate adhesives. Fast dry time and long on-part life.



## INTRODUCING:

## the **NEW** Loctite® Bottle



Highly flexible package provides flow control and ease-of-use



New nozzle for optimal dispensing accuracy and control



Positive seal cap seals with a click

# Loctite® Medical Device Cyanoacrylate Adhesives, Accelerators & Primers Properties Chart

PRODUCT	Item Number	Package Type & Size	APPEARANCE / CLARITY / COLOR	CURE TYPE	KEY SUBSTRATES	VISCOSITY (cP) BROOKFIELD (25°C)	TEMPERATURE RANGE	ISO 10993 COMPLIANT
CYANOACRYLATES	431™ Prism® (SI) 	41254 3 g tube 41255 20 g bottle 41256 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	1,000	-65°F to 180°F	✓
	435™ Prism® (T) 	41005 3 g tube 40994 20 g bottle 40995 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	200	-65°F to 240°F	✓
	4011™ Prism® (SI) 	18680 20 g bottle 18681 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	100	-65°F to 180°F	✓
	4013™ Prism® (GP)	20268 20 g bottle 18013 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal	500	-65°F to 180°F	✓
	4014™ Prism® (GP)	20269 20 g bottle 18014 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal	3	-65°F to 220°F	✓
	4031™ Prism® (LO)	18682 20 g bottle 18683 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal	1,300	-65°F to 160°F	✓
	4061™ Prism® (SI)	18686 20 g bottle 18687 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	20	-65°F to 180°F	✓
	4081™ Prism® (LO)	18688 20 g bottle 18689 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal	5	-65°F to 160°F	✓
	4161™ Super Bonder® (GP)	19743 20 g bottle 19744 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal	1,500	-65°F to 180°F	✓
	4206™ Prism® (TR)	28628 20 g tube 28629* 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	375	-65°F to 250°F	✓
	4541™ Prism® (SI) 	18690 20 g tube 18691 200 g tube	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer,	Gel	-65°F to 180°F	✓
	4601™ Prism® (LO)	18692 20 g bottle 18693 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal	50	-65°F to 160°F	✓
	4851™ Prism® (FL)	37732 20 g bottle 37733 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	400	-65°F to 125°F	✓
	4861™ Prism® (FL)	37708 20 g bottle 37711 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	4,000	-65°F to 125°F	✓
	4981™ Super Bonder® (TR)	18694 20 g bottle 18695 1 lb. bottle	Clear	Humidity	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	500	-65°F to 220°F	✓
LIGHT CURE CYANOACRYLATES	4306™ Flashcure® 	37439 1 oz. bottle 37442* 1 lb. bottle	Clear / Pale Green / Fluorescent	Ultraviolet, visible, humidity	Thermoplastic, polycarbonate, elastomer, metal	20	-65°F to 180°F	✓
	4307™ Flashcure® 	37441 1 oz. bottle 37443* 1 lb. bottle	Clear / Pale Green / Fluorescent	Ultraviolet, visible, humidity	Thermoplastic, polycarbonate, elastomer, metal	900	-65°F to 180°F	✓
ACCELERATOR AND PRIMERS	713™ Prism® Accelerator	19889 1.75 fl. oz. bottle	Clear	N/A	Isopropanol-based accelerator for cyanoacrylates	1	N/A	✓
	7451™ Prism® Accelerator	19890 1.75 fl. oz. bottle	Clear	N/A	Acetone-based accelerator for cyanoacrylates	1	N/A	✓
	7701™ Prism® Primer 	19886 1.75 fl. oz. bottle 19887 16 fl. oz. can	Clear	N/A	Heptane-based adhesion promoter for low energy surface plastics	3	N/A	✓

(SI) – Surface Insensitive  
(GP) – General Purpose

(LO) – Low Odor / Low Bloom  
(FL) – Flexible

(TR) – Thermally Resistant  
(T) – Toughened

\* Made-to-Order Item

 Indicates TOP CHOICE products.

## DISPENSING OPTIONS

**Loctite® Benchtop Peristaltic Dispenser** is a reliable and effective volumetric dispenser for single-component, low viscosity fluids up to 5,000 cP, directly from the product bottle. It is great for applications that require dispensing of fluids where a precise bead or specific flow rate is necessary. This dispenser is electro-mechanically operated and does not require the use of an air source.

For additional accessories, dispense tips and spare parts, please visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 98548





# Epoxies, Silicones & Urethanes



## EPOXIES

### LOCTITE® 3981™/3982™/3984™ HYSOL® EPOXY ADHESIVES

*High Performance / Various Substrates*

Highly fluorescent, one-part, heat cure epoxy adhesives offering superior physical, environmental and performance properties.



### LOCTITE® M-21HP™ HYSOL® MEDICAL DEVICE EPOXY ADHESIVE

An off-white, toughened epoxy that provides high peel resistance and high shear strength on a wide variety of plastics and metals.

### LOCTITE® M-31CL™ HYSOL® MEDICAL DEVICE EPOXY ADHESIVE

A low viscosity epoxy that bonds glass, ceramic, metal, and many rigid plastics. Ideal for applications where optical clarity and excellent structural and mechanical properties are required.



### LOCTITE® M-121HP™ HYSOL® MEDICAL DEVICE EPOXY ADHESIVE

A high viscosity, non-sag epoxy for applications that require high impact resistance and high peel strength. Bonds dissimilar materials including aluminum, steel, and other metals, as well as a variety of plastics and ceramics.

## SILICONE ADHESIVES / SEALANTS

### LOCTITE® 5240™ NUVA-SIL® MEDICAL DEVICE SEALANT



A self-leveling, UV or visible light silicone that also features a secondary moisture cure. Makes transparent, white-tinted seals or bonds.



### LOCTITE® 5248™ NUVA-SIL® MEDICAL DEVICE SEALANT

A self-leveling, UV silicone ideal for sealing and bonding extruded and moldable silicones, glass, and metals.

## URETHANE

### LOCTITE® M-11FL™ HYSOL® MEDICAL DEVICE URETHANE ADHESIVE







A low viscosity urethane that bonds polycarbonate and a variety of other plastics, glass, and metal. When fully set, product forms an ultra-clear bond line and provides excellent peel strength.

[www.loctite.com/medical](http://www.loctite.com/medical)



Visit the web for an  
all-access pass to distributors,  
safety & technical data sheets,  
literature, and product  
application assistance.

# Loctite® Medical Device Epoxies, Silicones & Urethanes Properties Chart

PRODUCT		Item Number	Package Type & Size	APPEARANCE / CLARITY / COLOR	CURE TYPE	KEY SUBSTRATES	VISCOSITY (cP) BROOKFIELD (25°C)	TEMPERATURE RANGE	ISO 10993 COMPLIANT
EPOXIES	3981™ Hysol® 	36766 37297	30 ml syringe 1 liter bottle	Transparent Yellow	Heat cure	Thermoset plastic, metal, glass, ceramic	5,300	-65°F to 300°F	✓
	3982™ Hysol® 	36767 37298	30 ml syringe 1 liter bottle	Off-White	Heat cure	Thermoset plastic, metal, glass, ceramic	8,000	-65°F to 300°F	✓
	3984™ Hysol® 	36768 37299*	30 ml syringe 1 liter bottle	Light Grey	Heat cure	Thermoset plastic, metal, glass, ceramic	25,500	-65°F to 300°F	✓
	M-21HP™ Hysol®	30671	50 ml dual cartridge	Off-White	Room temperature	Thermoplastic, thermoset plastic, elastomer, metal, glass, ceramic	37,000	-65°F to 300°F	✓
	M-31CL™ Hysol® 	30673 30674*	50 ml dual cartridge 200 ml dual cartridge	Ultra-Clear	Room temperature	Thermoplastic, thermoset plastic, polycarbonate, metal, glass, ceramic	6,000	-65°F to 300°F	✓
	M-121HP™ Hysol®	30680	50 ml dual cartridge	Amber	Room temperature	Thermoplastic, polycarbonate, polyvinylchloride, metal, glass, ceramic	11,000	-65°F to 300°F	✓
SILICONE ADHESIVE/SEALANTS	5240™ Nuva-Sil®  	1010341 1010320 1010343	30 ml syringe 300 ml cartridge 40 lb. pail*	Translucent / White	UV / visible, humidity	Silicone, metal, glass, plastic	18,000	-65°F to 350°F	Pending
	5248™ Nuva-Sil®	19987	300 ml cartridge	Translucent / Straw	UV, humidity	Elastomer, metal, glass	50,000	-65°F to 350°F	✓
URETHANE	M-11FL™ Hysol®	30678	50 ml dual cartridge	Ultra-Clear	Room temperature	Thermoplastic, thermoset plastic, polycarbonate, elastomer, metal, glass, ceramic	3,800	-65°F to 250°F	✓

\* Made-to-Order Item

 Indicates TOP CHOICE products.

## DISPENSING OPTIONS

### Loctite® 50 ml Dual Cartridge Manual Applicator

provides a convenient, cost-effective method to apply product with minimal waste. This applicator is compatible with 1:1 and 2:1 mix ratio products.

For additional accessories, dispense tips and spare parts, visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 98472



### Loctite® Precision Digital Dispensing Syringe System

more accurately dispenses medical device adhesives and epoxies with varying viscosities from water-thin to paste-like consistencies.








For additional air-line accessories, dispense tips and spare parts, see equipment section or visit

[www.equipment.loctite.com](http://www.equipment.loctite.com).

Item Number: 97006



**Loctite® Posi-Link™ Dispense System for Dual Cartridges.** When you need high precision dispensing from your prepackaged dual cartridge adhesive, the Loctite® Posi-Link™ Dispense System is the solution. For more information, refer to the “Equipment” section or visit [www.equipment.loctite.com](http://www.equipment.loctite.com).

COMPLETE LOCTITE® POSI-LINK™ DUAL CARTRIDGE SYSTEM										
For 50 ml Dual Cartridges										
	Controller	+		Actuator	+		Nest			
For 200 / 400 ml Dual Cartridges										
	Controller	+		Actuator	+		Nest	+		Pinch Tube

(Each Item Sold Separately)

# Equipment

Since 1971, Henkel Corporation has designed, built, and integrated high quality equipment solutions. From simple handheld devices to fully automated systems, Henkel offers a complete line of standard off-the-shelf Loctite® brand dispensing and light curing equipment, which can be integrated easily into your manufacturing process.

## FACTORY REPAIRS

If you have equipment in need of repair, Henkel can restore it to original operating specification. Customers often schedule preventive repairs to coincide with annual shutdowns. Henkel can work with you to get your equipment up and running in the fastest possible time frame. Rental equipment may be available on a short-term basis to minimize downtime.

### *Benefits of Factory Repair Service include:*

- Trained technicians evaluate equipment based on original design specifications to identify critical and preventive repair recommendations
- Equipment is repaired using original factory parts
- All equipment is fully tested to original quality specifications
- All repairs carry a 30-day labor and 90-day parts warranty

## CALIBRATIONS

Henkel provides calibration services for all of its light meters. All meters are calibrated to original calibration, standards. Data is collected before and after calibration, and a calibration certificate is issued that states test results. In addition, you can sign up with Henkel for calibration reminders. All units are also inspected during calibration for any potential repairs.



## FIELD SERVICE

Henkel Technicians are available to travel to your location for repair services, preventative maintenance, training or assistance in setting up a new system. Whatever you need, Henkel can provide the service.

## SPARE PARTS

Spare parts and accessories are available through the equipment services group of Henkel. Most common spare parts can be identified on our website at [www.equipment.loctite.com](http://www.equipment.loctite.com). If you cannot find the part you are looking for, our equipment services group can help you identify that part and provide you with a quote.

## REBUILD EXCHANGE PROGRAM

The Henkel rebuild exchange program offers customers a cost-effective way of streamlining the repair of dispensing valves. The rebuild program allows customers to send in their old valve and receive a reconditioned valve in return. Customers who participate in this program typically keep a spare valve in inventory so if a valve goes down it can be replaced immediately. The valve in need of repair is then sent to Henkel, and a reconditioned valve is shipped back to the customer for future use.

### *Advantages of the Rebuild Exchange Program are:*

- Rebuilt equipment is less than half the cost of a new unit
- Rebuilt equipment is shipped in 1 to 2 business days
- Highly trained technicians use original factory parts
- All equipment is specially treated with a Henkel patented technology to prolong its useful life with reactive adhesives
- All rebuilds carry a 30-day labor and 90 day parts warranty



## DISCOUNT EQUIPMENT

Henkel is able to offer a wide range of used or discontinued equipment at discounted prices. This equipment typically has been used in our rental program or has been used for customer demonstrations or trade shows. This equipment may have cosmetic blemishes but performs to original factory specification. All equipment carries the same warranty as new equipment and is fully tested and reconditioned prior to sale.







As a full service supplier of equipment, Henkel offers a wide variety of Equipment Services to its customers.

## EQUIPMENT RENTAL

Many of the equipment products that Henkel offers are available for short-term rental. Henkel's equipment rental program allows customers the flexibility to confirm the performance of our adhesive and equipment risk free before investing in a purchase. If, during the first 30 days, you decide that you would like to purchase the rental equipment, the entire rental charge is credited toward your purchase.

### *The benefits of this program include:*

- The performance of a new manufacturing process can be confirmed before investing fully in the purchase of equipment
- Short production runs can be accommodated without having to buy equipment
- Equipment can be rented during the repair of production equipment, minimizing any downtime

## LEASE-TO-OWN PROGRAM

Henkel offers a lease-to-own program for new equipment. According to the United States Equipment Lessors Association, 80% of all companies use leasing to acquire some or all of the machinery and equipment they use to run their businesses. Henkel's lease-to-own program provides an effective way for your business to acquire almost any Henkel equipment. Leases can be customized to each company's needs. Our program can also include other services and spare parts as part of the equipment lease. Let us customize a lease program to meet your needs.

## PREVENTATIVE MAINTENANCE (PM) CONTRACTS

There are many misconceptions about preventative maintenance. One such misconception is that PM is unduly costly. This may be true for some components, but not all. Without preventative maintenance, costs for lost production time from unscheduled equipment breakdown will be incurred. Also, PM will result in savings due to an increase in effective system service life.

### *Long-term benefits of PM include:*

- Improved system reliability
- Decreased cost of replacement
- Decreased downtime
- Better spare part inventory management

Henkel can create a PM contract that fits your specific equipment and work with your maintenance staff to ensure maximum up time of your equipment.

## REQUEST EQUIPMENT SERVICES

To learn more about the services Henkel offers, you can visit our website at [www.equipment.loctite.com/service](http://www.equipment.loctite.com/service). In addition to our services, the website offers manuals and technical information on Loctite® equipment products.

### *By Internet*

To request a quote or get more information, email your request to [equipment-customerservice@loctite.com](mailto:equipment-customerservice@loctite.com).

### *By Telephone*

If you wish to speak to us regarding an equipment service, you can call **860-571-5174** to speak to an equipment services representative.

If you have a question regarding equipment set up or operation, our technical information staff is available to help. To contact them, call **1-800-LOCTITE** and choose the technical service option.

## LOCTITE® EQUIPMENT WEBSITE

To better support our wide array of equipment services, our Equipment website provides easy access to all service options and inquiries for all Loctite® Equipment you may be interested in. Technical Literature, Equipment Showroom locator, operational videos, and much more, are all at your fingertips, for quick and easy access. You can also choose to purchase directly online using a major credit card. Select from our wide array of adhesive dispensing and light curing equipment. Shipping time for most items are just 1 to 2 business days.

*Please visit the site at:*

**[www.equipment.loctite.com](http://www.equipment.loctite.com)**





# Handheld Applicators

Loctite® brand handheld applicators are ergonomically designed for the hand delivery of adhesives and fluids directly from their original package. Whether pneumatic or manual, each item is designed for the simple, clean, handheld dispensing of fluids, and to reduce waste and operator contact over other methods. Selection of a Loctite® brand handheld applicator is based on product type, package configuration, and process requirements.

PRODUCT		Item Numbers	Used to Dispense	Package Types & Sizes	Viscosity Range	Type
BOTTLE DISPENSING — The most popular handheld bottle-top dispensers for Loctite® brand threadlockers and other adhesive products.						
	Loctite® 50 ml / 250 ml Hand Pumps	98414 97001	Retaining Compounds, Threadlockers	50 ml bottle 250 ml bottle	Low to Medium	Manual
	Loctite® 1 Liter Collapsible Bottle Holder	98311	Retaining Compounds, Threadlockers	1 Liter collapsible bottle	Low to Medium	Manual
	Loctite® Soft Squeeze Bottles	98345	All Fluids in 2 fl. oz. packages	N/A	Low to Medium	Manual
		98346	All Fluids in 4 fl. oz. packages			
		98347	All Fluids in 8 fl. oz. packages			
SYRINGE DISPENSING — Simple manual dispensers for low volume syringe applications.						
	Loctite® 30 ml Manual Syringe Applicator	98026	Any fluid in a 30 ml syringe including 25 ml syringes	30 ml syringe	Low to High	Manual
	Loctite® 10 / 30 ml Syringe Manual Plungers	98192	Any fluid in a 10 ml syringe	10 ml syringe (3 pack)	Low to High	Manual
		98193	Any fluid in a 30 ml syringe	30 ml syringe (3 pack)		
TWO-PART DISPENSING — Simple and effective two-part dispensers to meet your lower precision dual cartridge application needs.						
	Loctite® 50 ml Dual Cartridge Manual Applicators	98472	Two-Component Epoxies, Urethanes, Methacrylates	1:1, 2:1 50 ml dual cartridge	Low to High	Manual
		1034026		10:1 50 ml dual cartridge		
	Loctite® 50 ml Dual Cartridge Pneumatic Applicator	97042	Two-Component Epoxies, Urethanes, Methacrylates	50 ml dual cartridge	Low to High	Pneumatic
	Loctite® Caulking Gun Conversion Kits for 50 ml Cartridges	98466	Two-Component Epoxies, Urethanes, Methacrylates	50 ml dual cartridge	Low to High	Manual
	Loctite® 200 ml / 400 ml Dual Cartridge Manual Applicators	983436	Two-Component Epoxies, Urethanes, Methacrylates	200 ml dual cartridge	High to Paste	Manual
		983438		400 ml dual cartridge		
		985246		400 ml dual cartridge		
	Loctite® 200 ml / 400 ml Dual Cartridge Pneumatic Applicators	983437	Two-Component Epoxies, Urethanes, Methacrylates	200 ml dual cartridge	High to Paste	Pneumatic
		983439		400 ml dual cartridge		
		985249		400 ml dual cartridge		
	Loctite® Universal Metal Dispenser for 200 ml / 400 ml Cartridges	985245	Two-Component Epoxies, Urethanes, Methacrylates	200 ml and 400 ml dual cartridges	High to Paste	Manual
	Loctite® Fixmaster® Rapid Rubber Repair Dispenser	39635	Loctite® Fixmaster® Rapid Rubber Repair Urethanes	400 ml Loctite® Fixmaster® Rapid Rubber Repair dual cartridge	Medium to High	Manual
CARTRIDGE DISPENSING — Manual and pneumatic applications for 300 ml cartridges.						
	Loctite® 300 ml Pneumatic Cartridge Dispenser	97002	Gel Cyanoacrylates, Anaerobic Gasketing, Light Cure / Acrylics, Silicones	300 ml cartridges 250 ml tubes	Medium to High	Pneumatic
	Loctite® 300 ml Pneumatic Cartridge Dispensing Retainer	98319A	Gel Cyanoacrylates, Anaerobic Gasketing, Light Cure / Acrylics, Silicones	300 ml cartridges	Low to Medium	Pneumatic

# Dispense Systems

Loctite® brand dispense systems available from Henkel are designed to offer the total package for fluid delivery. Whether you use a Loctite® brand adhesive product, or any other brand, these complete systems are ready for immediate operation and offer the manufacturing flexibility and reliability you're seeking. Selection of a Loctite® brand complete dispensing system is based on the product being used, package size, and process requirements.

PRODUCT		Item Number	Dispense Patterns	Used to Dispense	Package Types & Sizes	Viscosity Range	Vacuum Suck-Back
VOLUMETRIC BOTTLE DISPENSERS – Dispense adhesive directly from product bottle with no reservoirs required.							
	Loctite® Benchtop Peristaltic Dispenser	98548	Dots, Drops, Beads	Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	Any	0 to 5,000 cP	N/A
COMPLETE PRESSURE-TIME BOTTLE DISPENSE SYSTEMS – Equipped with all components needed to dispense a wide range of products in a variety of adhesive bottle sizes.							
	Loctite® Bond-A-Matic® 3000 Dispenser 0-15 psi	982719	Dots, Drops, Beads	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	250 ml bottle 1 lb. bottle 1 L bottle 2 kg bottle 200 g squeeze tube	Low	N/A
	Loctite® Bond-A-Matic® 3000 Dispenser 0-100 psi	982722			Medium to High		
	Loctite® Shot Miser™ Dispense System	98079 98085 98090	Dots, Drops, Beads	Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	250 ml bottle 1 lb. bottle	Low to Medium	N/A
SYRINGE DISPENSING SYSTEMS – Choose the Loctite® Posi-Link™ Volumetric Dispense System for the highest level of dispense precision.							
	Loctite® Posi-Link™ Dispensing System (Accessories Required)	98377	Dots, Drops, Beads	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics, Epoxies	Prepackaged 5 ml syringe 10 ml syringe 25 ml syringe	Low to Paste	Yes
	Loctite® Precision Syringe Dispensing System	97006*	Dots, Drops, Beads	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics	3 ml syringe 5 ml syringe 10 ml syringe 30 ml syringe 55 ml syringe	Low to Paste	Yes
	Loctite® Digital Syringe Dispensing System	883976	Dots, Drops, Beads	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics		Low to Paste	Yes
	Loctite® Foot Pedal Dispenser	98049* 98050*	Dots, Drops, Beads	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics		Low to Paste	98049: No 98050: Yes
THREAD SEALANT & ANAEROBIC GASKETING DELIVERY SYSTEMS – Ensure consistent application of high viscosity thread sealants and anaerobic gasketing applications.							
	Loctite® Dial-A-Seal® Applicator	998400	N/A	Pipe Sealants	50 ml tube 250 ml tube 1 L bottle	Medium to High	N/A
	Loctite® Pump-A-Bead™ II Dispenser	986000	Beads	Anaerobic Gasketing	850 ml cartridges	Medium to High	N/A
TUBE BONDING – Light Cure Acrylic Delivery System.							
	Loctite® Light Cure Acrylic Adhesive Dispensing System	98445	Beads on Tubing OD	Light Cure Acrylics	2.0 to 6.0 mm ID Tubing	Low	N/A

\* Syringe Air-Line Adapter sold separately. Visit [www.equipment.loctite.com](http://www.equipment.loctite.com) for all available accessories.






For additional information and the full line of equipment, visit [www.equipment.loctite.com](http://www.equipment.loctite.com).









# Controllers & Reservoirs

Loctite® brand controllers and reservoirs can be used as the chief components, along with a selection of Loctite® brand parts and accessories or with your own parts, to create a complete custom dispensing system designed to meet your specific needs and manufacturing goals. Selection of a Loctite® brand controller and reservoir is based on the adhesive or fluid being used, the package or container the adhesive or fluid is supplied in, and the overall requirements of the manufacturing process.



PRODUCT		Item Number	Controlled Outputs	Number of Dispense Valves	Advancing Slide	Rotospray
<b>MULTIFUNCTION CONTROLLERS</b> – <i>Select when you need more functionality than just single valve dispensing.</i>						
	Loctite® Single Channel Automatic Controller	97123	2	2 (Dependent)	97118 – 50 mm 97119 – 100 mm	97115
	Loctite® Spray Valve Controller	98521	1	1	N/A	N/A
	Loctite® Digital Multifunctional Controller	1022006	3	3 (Independent)	984691 – 50 mm	In conjunction with Positive Displacement Pump – 983330
<b>SINGLE FUNCTION CONTROLLERS</b> – <i>Select to operate a single dispense valve.</i>						
	Loctite® Digital Dispense Controller	97101	1	1	N/A	N/A
	Loctite® Shot Miser™ Valve Controller	98079	1	1	N/A	N / A

PRODUCT		Item Number	Pressure Regulation	Used to Dispense	Package Types & Sizes	Viscosity Range	Low Level Sensing
INTEGRATED RESERVOIR CONTROLLERS — <i>Space saving and economical, combined controller and reservoir for valve dispensing.</i>							
	Loctite® Integrated Semiautomatic Dispenser	97010	0 to 15 psi	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	250 ml bottle 1 lb. bottle 1 L bottle 2 kg bottle 200 g squeeze tube	Low to Medium	No
		97020					Yes
		97007	0 to 100 psi			Medium to High	No
		97017					Yes
RESERVOIRS — <i>Select your reservoir based on product viscosity and need for low level sensing.</i>							
	Loctite® Bond-A-Matic® 3000 Reservoir	982720	0 to 15 psi	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	250 ml bottle 1 lb. bottle 1 L bottle 2 kg bottle 200 g squeeze tube	Low to Medium	Yes
		982721					Yes
		982726					No
		982723	0 to 100 psi			Medium to High	Yes
		982724					Yes
		982727					No
	Loctite® 300 ml Cartridge Pusher	98022	0 to 50 psi	Gel Adhesives, Anaerobic Gasketing, Light Cure / Acrylics, Low Viscosity Silicones	300 ml cartridge 250 ml tube	Medium	Yes
	Loctite® 2.25 Gallon Pressure Reservoir	98359	0 to 60 psi	Gel Adhesives, Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	250 ml bottle 1 lb. bottle 1 L bottle 2 kg bottle 200 g squeeze tube	Low to Medium	No
	Loctite® Shot Miser™ Reservoir	98090	0 to 100 psi	Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	250 ml bottle 1 lb. bottle 200 g squeeze tube	Low to Medium	No
	Loctite® 4 Liter Gravity Feed Reservoir	982880	N/A	Retaining Compounds, Threadlockers	Direct Fill	Low to Medium	Yes

# Valves & Pumps

Loctite® brand dispensing valves and pumps are value-added, robust, dispensing valves for adhesive or fluid delivery. Each valve is uniquely designed to meet different manufacturing needs. These valves should be combined with a reservoir and/or a controller. Selection of a Loctite® brand valve or pump is based on the chemistry and viscosity of the adhesive or fluid being used and process requirements.

PRODUCT	Item Number	Type	Viscosity Range	Dispense Patterns	Used to Dispense	Stroke Adjustment	Suck-Back	
HIGH PRECISION VALVES								
	Loctite® Stationary Applicator Valve	97113	High Precision	Low to Medium	Drop, Dot, Bead	Gel Instant Adhesives, Instant Adhesives, Retaining Compounds, Threadlockers	Yes	Yes
		97114						
	Loctite® Micro Needle Valve	98084	High Precision	Low to Medium	Drop, Dot, Bead, Microdots	Light Cure / Acrylics	Yes	No
HIGH PERFORMANCE DIAPHRAGM VALVES								
	Loctite® Light Cure Dispense Valve	98009	High Performance Diaphragm	Low to Medium	Drop, Dot, Bead	Light Cure / Acrylics, Retaining Compounds, Threadlockers	Yes	No
	Loctite® Cyanoacrylate Dispense Valve	98013	High Performance Diaphragm	Low to Medium	Drop, Dot, Bead, Microdots	Instant Adhesives, Retaining Compounds, Threadlockers	Yes	No
GENERAL DUTY DIAPHRAGM VALVES								
	Loctite® Diaphragm Valve	97135	General Duty Diaphragm	0 to 2,500 cP	Drop, Dot, Bead	Light Cure / Acrylics Instant Adhesives, Retaining Compounds, Threadlockers	No	No
		97136		2,500 to 5,000 cP				
SPRAY VALVES								
	Loctite® Spray Valve	98520	Spray Valve	Low	Spray	Primers, Activators, Accelerators	Yes	No
HIGH VISCOSITY FLUID AND PASTE VALVES								
	Loctite® Poppet Valve	986300	High Viscosity Fluid and Paste Valves	Medium to High	Drop, Bead	Anaerobic Gasketing, Retaining Compounds, Threadlockers	Yes	Yes
		983914						
	Loctite® Stainless Steel Poppet Valve	982621				Paste Silicones		
PINCH TUBE VALVE								
	Loctite® Shot Miser™ Dispense Valve	98085	Pinch Tube Valve	Low to Medium	Drop, Dot, Bead	Instant Adhesives, Retaining Compounds, Threadlockers	No	No
POSITIVE DISPLACEMENT PUMP								
	Loctite® Positive Displacement Pump	983330	Positive Displacement Valve	Low to Medium	Drop	Retaining Compounds, Threadlockers, Any single-component, non-moisture-curing, low to medium viscosity fluid (<100,000 cP)	Yes	No





*Dispense Controller and Reservoir are required with these valves.*

## Loctite® Brand Valve & Pump Fluid Capability Chart



PRODUCT	Loctite® Stationary Applicator Valve	Loctite® Micro Needle Valve	Loctite® Light Cure Dispense Valve	Loctite® Cyanoacrylate Dispense Valve	Loctite® Diaphragm Valve
Item Numbers	97113 / 97114	98084	98009	98013	97135 / 97136
Accelerators			✓	✓	
Acrylics	✓	✓	✓		✓
Activators			✓	✓	
Anaerobics	✓		✓	✓	✓
Anaerobic Gasketing					
Cyanoacrylates	✓			✓	✓
Inks	✓	✓	✓	✓	✓
Lubricants	✓				
Modified Silanes					
Non-Abrasive Greases					
Oils	✓		✓	✓	✓
One-Part Epoxies	✓				
Paints	✓		✓	✓	
Primers			✓	✓	
Reagents			✓	✓	
Silicones					
Solvents			✓	✓	
UV & Light Cure Fluids	✓	✓	✓		✓
UV Anaerobics	✓		✓		✓
Water		✓	✓	✓	✓

## Loctite® Brand Valve & Pump Fluid Capability Chart



PRODUCT	Loctite® Spray Valve	Loctite® Poppet Valve	Loctite® Stainless Steel Poppet Valve	Loctite® Shot Miser™ Dispense Valve	Loctite® Positive Displacement Pump
Item Numbers	98520	986300 / 983914	982621	98085	983330
Accelerators	✓			✓	
Acrylics		✓		✓	
Activators	✓			✓	
Anaerobics		✓		✓	✓
Anaerobic Gasketing		✓			
Cyanoacrylates				✓	
Inks	✓			✓	
Lubricants	✓	✓	✓		
Modified Silanes			✓		
Non-Abrasive Greases		✓	✓		
Oils				✓	
One-Part Epoxies		✓	✓		
Paints	✓			✓	
Primers	✓			✓	
Reagents	✓			✓	
Silicones			✓		
Solvents	✓			✓	
UV & Light Cure Fluids				✓	
UV Anaerobics				✓	
Water	✓			✓	

# Handheld Valves

Loctite® brand handheld dispensing valves are used where ergonomic design for hand dispensing of fluids is desired. Designed for use with Loctite® brand controllers and reservoirs, these handheld valves utilize passive wetted components for universal compatibility with many fluids. Selection of a Loctite® brand handheld valve is based on the desired dispensing controls, the dispense principal of the delivery system, and other process requirements.

PRODUCT		Item Number	Type	Viscosity Range	Dispense Patterns	Used to Dispense	Stroke Adjustment	Actuation
<b>LOW VISCOSITY CYANOACRYLATE APPLICATOR</b>								
	<b>Loctite® LV Handheld Applicator</b>	97130	Pneumatic	Low	Drop, Dot, Bead	Instant Adhesives, Retaining Compounds, Threadlockers	Yes	Foot
<b>GENERAL PURPOSE APPLICATORS</b>								
	<b>Loctite® Manual Handheld Applicator</b>	97111	Manual	Low to Medium	Drop, Dot, Bead	Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	Yes	Finger
	<b>Loctite® Pneumatic Handheld Applicator</b>	97112	Pneumatic	Low to Medium	Drop, Dot, Bead	Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	Yes	Foot
	<b>Loctite® Pneumatic Handheld Applicator</b>	97116	Pneumatic	Low to Medium	Drop, Dot, Bead	Instant Adhesives, Light Cure / Acrylics, Retaining Compounds, Threadlockers	Yes	Finger
<b>PINCH TUBE APPLICATORS</b>								
	<b>Loctite® Vari-Drop™ Applicator</b>	97131	Pinch Tube	Low to Medium	Drop, Dot, Bead	Instant Adhesives, Retaining Compounds, Threadlockers	Yes	Finger
		97132						

[www.equipment.loctite.com](http://www.equipment.loctite.com)

Visit us on the web for  
additional information, diagrams, products  
and our full line of equipment.





*Dispense Controller and Reservoir are required with these valves.*

## Loctite® Brand Handheld Dispensing Valve Fluid Capability Chart



PRODUCT	Loctite® LV Handheld Applicator	Loctite® Manual Handheld Applicator	Loctite® Pneumatic Handheld Applicator	Loctite® Pneumatic Handheld Applicator	Loctite® Vari-Drop™ Applicator
Item Number	97130	97111	97112	97116	97131 / 97132
Accelerators	✓	✓	✓	✓	✓
Acrylics		✓	✓	✓	✓
Activators	✓	✓	✓	✓	✓
Anaerobics	✓	✓	✓	✓	✓
Cyanoacrylates	✓	✓	✓	✓	✓
Inks	✓	✓	✓	✓	✓
Oils		✓	✓	✓	✓
Paints		✓	✓	✓	✓
Primers	✓	✓	✓	✓	✓
Reagents	✓	✓	✓	✓	✓
Solvents	✓				✓
UV & Light Cure Fluids		✓	✓	✓	✓
UV Anaerobics		✓	✓	✓	✓
Water	✓				










# Two-Part Volumetric Dispensing

## Loctite® Posi-Link™ Dispense System for Dual Cartridges

When you need high precision dispensing from your prepackaged dual cartridge adhesive, the Loctite® Posi-Link™ Dispense System is the solution. This system offers dispensing accuracy well beyond any pneumatic cartridge dispenser down to 0.001 ml drop size. This system specifically excels at eliminating dispense variability due to continuously changing viscosity (curing) in the mix nozzle. It can be integrated easily into any automated process and provide process feedback to a plant PLC. Select your system based on cartridge size and adhesive ratio requirements. You can choose 50, 200 or 400 ml packages for any 1:1, 2:1 or 10:1 ratio product.



*The **END** of wetted components*

COMPLETE LOCTITE® POSI-LINK™ DUAL CARTRIDGE SYSTEM						
For 50 ml Dual Cartridges:						
	Controller	+		Actuator	+	 Nest
For 200/400 ml Dual Cartridges:						
	Controller	+		Actuator	+	 Nest +  Pinch Tube

(Each Item Sold Separately)

### LOCTITE® POSI-LINK™ CONTROLLER *Item Number: 98377*

Provides all operator interface and control signals to actuator.

#### Features:

- **Dose selection** by volume
- **Easy programming** controller, with storage capacity for 25 user-defined programs, reduces adhesive setup waste
- **Smallest footprint** on the market to conserve benchtop space
- **Automatic cartridge engagement** to ensure easy and error-free cartridge changeover
- **Adhesive level monitoring** with low level visual and digital outputs
- **Fault detection** with visual and digital outputs for clogged nozzles, loss of pressure, and system faults
- **In-cycle** visual and digital outputs
- **Foot switch, finger switch or PLC** remote start activation



### LOCTITE® POSI-LINK™ ACTUATORS *Item Numbers: See chart*

Provides adhesive dispensing by effecting incremental movements of dual pistons and displacing programmable quantities of adhesive within the cartridge regardless of viscosity changes in the mix nozzle.

PRODUCT	Item Number	Dual Cartridge Size
Loctite® Posi-Link™ 10-50 Actuator	98379*	50 ml
Loctite® Posi-Link™ 200-400 Actuator	98380	200, 400 ml

#### Features:

- **Flexible orientation** in any position
- **Easily fits** below an industrial workbench or wall mounts with brackets supplied to conserve benchtop space
- **Lightweight** remote dispense head has a "positive link" to actuator via a 7-foot tether, allowing ergonomic handheld dispensing or mounting directly on robotic arms
- **Easily attaches** to the dual cartridge nests (sold separately) to accommodate alternate cartridge barrel sizes
- **Mechanically linked** dual plungers guarantee that proper ratios are achieved
- **Positive shutoff** pinch tube available, which directly attaches to the mix nozzle to eliminate dripping



**LOCTITE® POSI-LINK™ 50 ML  
DUAL CARTRIDGE NESTS***Item Number: See chart*Connects the actuator  
to the dual cartridge.**Dual Cartridge Nest Features:**

- **No tool** cartridge changeover
- **No contact** with adhesive; disposable syringes are the only component in contact with the adhesive

**LOCTITE® POSI-LINK™ 200/400 ML  
DUAL CARTRIDGE NESTS***Item Number: See chart*Connects the actuator  
to the dual cartridge.**Loctite® Posi-Link™ Dual Cartridge Nest Selection**

1:1 / 2:1 – 50 ml Cartridge	10:1 – 50 ml Cartridge	1:1 / 2:1 – 200 ml Cartridge	1:1 / 2:1 – 400 ml Cartridge	10:1 – 400 ml Cartridge	USED WITH
<b>98641</b>	<b>98642</b>	N/A	N/A	N/A	<b>Loctite® Posi-Link™ 10-50 Actuator</b>
N/A	N/A	<b>98662</b>	<b>98663</b>	<b>98664</b>	<b>Loctite® Posi-Link™ 200-400 Actuator</b>

**Theory of Operation**

A disposable dual cartridge is effectively used as a dual metering piston/cylinder. Because the individual chambers of a dual cartridge are of a known and constant diameter, a given incremental measurement of the dual pistons will displace a known volume of adhesive within each chamber at an exact ratio. This dual cartridge system functions identically to a Loctite® Posi-Link™ Syringe System, except that it has two plungers within the dispense head. These plungers simultaneously act on two chambers within the dual cartridge.

**LOCTITE® PINCH TUBE VALVE** *Item Number: 97141***Features:**

- Valve attaches directly to the end of the square mix nozzle
- Provides positive no-drip shutoff, using disposable pinch tube elements




**FOR 50 ML DUAL CARTRIDGES:****OPTIONAL:** 97141 – Valve +

97541 – 10 pack Replacement Tube Inserts + 98671 – Solenoid Valve

**FOR 200/400 ML DUAL CARTRIDGES:****REQUIRED:** 97141 – Valve +97541 – 10 pack Replacement Tube Inserts  
(98671 – Solenoid Valve included with actuator)

Loctite® Posi-Link™ 10-50 System, Integrated Robotic Solution using a 50 ml dual cartridge, and showing wall-mounted actuator.

**TECHNICAL SPECIFICATIONS**

TECHNICAL SPECIFICATIONS			
PRODUCT			
	Loctite® Posi-Link™ Controller	Loctite® Posi-Link™ 10-50 Actuator	Loctite® Posi-Link™ 200-400 Actuator
Item Number	98377	98379	98380
Power Source	9' communication cable	100/240 VAC; 47/60 Hz	100/240 VAC; 47/60 Hz
Dimensions	5.375" H x 6" D x 6" W	34" H x 4" D x 5" W	34" H x 4" D x 5" W
Total Weight	2 lbs.	13 lbs.	20 lbs.
Dispense Head Weight <i>(Includes Nest and Pinch Tube Valve)</i>	N/A	2.0 lbs.	10.0 lbs.
Air Supply	N/A	40 to 100 psi	40 to 100 psi
Posi-Link™ Electro / Hydraulic Tether	N/A	7 feet	7 feet
Minimum Dispense Volume	N/A	0.001 ml	0.01 ml
Maximum Dispense Rate	N/A	0.4 ml / second	1.0 ml / second
Maximum Cycle Rate	N/A	1 cycle per second	1 cycle per second
Used to Dispense	N/A	All dual 50 ml cartridge 1:1 / 2:1 / 10:1 ratio adhesives	All dual 200 or 400 ml cartridge 1:1 / 2:1 / 10:1 ratio adhesives
Parts Included	(1) Loctite® Posi-Link™ Controller (1) Foot Switch	(1) Loctite® Posi-Link™ Actuator (1) 9' Controller / Actuator Signal Cord (1) 110 Power Cord (1) Air Inlet Pressure Regulator Gauge (1) Wall or Table Mounting Bracket (1) Instruction Manual	
Additional Information	For Spare Parts and Accessories, visit <a href="http://www.equipment.loctite.com">www.equipment.loctite.com</a>		

# Two-Part Volumetric Dispensing

## Loctite® Meter Mix Systems

When your Loctite® two-part adhesive application takes on a larger dimension, Henkel has the two-part volumetric dispensing solution with our high precision Loctite® Meter Mix Dispense Systems. You can choose either fixed or variable ratio units for any of our featured systems and, together with a wide selection of reservoir systems, hoses, valves and other accessories, customize your system to meet your application requirements.



PRODUCT	Loctite® DuraPump™ Programmable Meter Mix System	Loctite® DuraPump™ Pneumatic Meter Mix System	Loctite® Meter Mix 1000 Dispense System	Loctite® Meter Mix 2000 Dispense System	Loctite® Meter Mix 3000 Dispense System
MACHINE RATIO CAPABILITIES / ITEM NUMBERS					
Fixed	1041649 – 1:1 1041644 – 2:1 1041639 – 4:1 1041638 – 10:1	1041648 – 1:1 1041643 – 2:1 1041641 – 4:1 1041637 – 10:1	988900: Low Flow 988902: High Fow	988906	988908
MMA Compatible	N/A	1041647 – 1:1 1041636 – 10:1	N/A	N/A	N/A
PERFORMANCE SPECIFICATIONS					
Dispense Range	0.40 cc to 28 cc		0.51 cc to 25 cc (Fixed), 0.51 cc to 21.37 cc (Variable)		
Cycle Rate	Up to 20 per minute		Up to 30 per minute		
Mix Ratio Range by Volume	1:1 to 10.0:1		1:1 to 9.76:1 (Fixed), 1:1 to 41.56:1 (Variable)		
Maximum Product Feed Pressure	2000 psi		60 psi		
WETTED COMPONENT MAKEUP					
Abrasion Resistant Pumps	Standard	Standard	Optional	Optional	Optional
Mild Steel Pumps	Not Required	Not Required	Standard	Standard	Standard
Inert Pumps	Standard	Standard	Optional	Optional	Optional
DISPENSE VALVES					
Mix Manifold <i>(accepts mix nozzle directly)</i>	Standard	Standard	N/A	N/A	N/A
Handheld Valve with Trigger Pistol Grip	Optional	Optional	Optional	Optional	Optional
Handheld Valve with Lever Actuation	N/A	N/A	Optional	Optional	Optional
Adjustable Boom Mounted Valve	N/A	N/A	N/A	Optional	Optional
SHOT CONTROL CAPABILITIES					
Manual / Operator Controlled Shot	Standard	Standard	Standard	Standard	Standard
Mechanically Adjusted Limit Switch Shot Control	N/A	Standard	N/A	Standard	Standard
Pre-Programmed Electronic Shot Size Control	Standard	N/A	N/A	N/A	Standard
Multiple Pre-Programmed Shot Size Control	Standard	N/A	N/A	N/A	Standard
Touchscreen Machine Controls	Standard	N/A	N/A	N/A	Standard
OTHER MACHINE FEATURES					
Feed Accumulators for Bulk Package Pressure Feed	Not Required	Not Required	Optional	Optional	Optional
Maintenance Totalizer	Standard	N/A	N/A	N/A	Standard
Low / High Level Sensing Capable	Optional – Low Level Only	N/A	N/A	N/A	Standard
Supervisor Machine Lock-Out	Standard	N/A	N/A	N/A	Standard
Pneumatically Adjustable Flow Control	Standard	Standard	Standard	Standard	Standard
Auto-Purge Capable	Standard	N/A	N/A	N/A	Standard
Foot Switch Controlled	Standard	Standard	N/A	Standard	Standard

# Handheld Hot Melt Applicators

Loctite® Hysol™ handheld hot melt applicators are state-of-the-art dispensing units designed for the application of hot melt adhesives. These units combine ergonomics, user-friendly design, and reliability. Selection of a Loctite® Hysol™ hot melt applicator should be based on the type of hot melt being used, stick diameter, and process requirements.

PRODUCT		Item Number	Stick Diameter	Dispense Melt Rate	Dispense Power	Dispense Temperature	Hot Melt Chemistry
1/2 INCH SUPERSTICK™ DISPENSERS							
	Loctite® Hysol™ 050A	916282	1/2" Superstick™ Sticks	4 lbs. / hr.	Manual	195°C	EVA / Polyolefin
	Loctite® Hysol™ 050	98544		3 lbs. / hr.		195°C	EVA / Polyolefin
	Loctite® Hysol™ 050-HT	98545		4 lbs. / hr.		215°C	Polyamide
	Loctite® Hysol™ 050-GAS	916268	1/2" Superstick™ Sticks	3 lbs. / hr.	Manual	195°C	EVA / Polyolefin
	Loctite® Hysol™ 050-LITE	916281	1/2" Superstick™ Sticks	1.5 lbs. / hr..	Manual	204°C	EVA / Polyolefin
3/4 INCH MAXISTICK™ DISPENSERS							
	Loctite® Hysol™ 075	98033	3/4" Maxistick™ Sticks	9 lbs. / hr.	Manual	182°C	EVA
	Loctite® Hysol™ 075-LT	98034		5 lbs. / hr.		121°C	CoolMelt™
1 3/4 INCH SPRAYPAC® AND POLYSHOT™ DISPENSERS							
	Loctite® Hysol™ 175-AIR	98036	1 3/4" Polyshot™ Sticks	8 lbs. / hr.	Electric	195°C	EVA / Polyolefin
	Loctite® Hysol™ 175-AIR-HT	98040				215°C	
	Loctite® Hysol™ 175-SPRAY	98037	1 3/4" SprayPac® Sticks	8 lbs. / hr.	Electric	195°C	Polyamide
	Loctite® Hysol™ 175-SPRAY-HT	98041				215°C	
	Loctite® Hysol™ 175	98035	1 3/4" Polyshot™ Sticks	6.6 lbs. / hr.	Manual	195°C and 215°C**	EVA / Polyolefin and Polyamide
URETHANE DISPENSER							
	Loctite® Hysol™ Reactive Urethane Cartridge Dispenser	98011	N/A	3 lbs. / hr.	Air	121°C	Reactive Urethane
HOT MELT BENCH MOUNT AND CONTROLLER OPTIONS							
	Loctite® Hot Melt Bench Mount Kit	98042	N/A	N/A	N/A	N/A	EVA / Polyamide
	Loctite® Hot Melt Pneumatic Timer	98043					

\*\* The Loctite® Hysol™ 175 Dispenser (manual electric) is supplied with both temperature modules.

For additional information and the full line of equipment, visit [www.equipment.loctite.com](http://www.equipment.loctite.com).



# Consumables – Dispense Accessories

Henkel offers a comprehensive line of Loctite® brand dispense tips, static mix nozzles, and syringe barrel components. Our high precision stainless steel, tapered polyethylene and flexible polypropylene tips all feature a positive locking, helical thread design to ensure the tip will stay intact during the toughest applications. A wide variety of static mix nozzles are available to meet your two-part adhesive dispensing needs. High quality syringe barrels and components will ensure consistent single-component adhesive dispensing needs are met.

## High Precision Stainless Steel Dispense Tips

### 1/4" STAINLESS STEEL TIPS HELICAL THREAD



50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
830704	830703	Olive	14
98196	98197	Green	18
98198	98199	Pink	20
98200	98201	Purple	21
98624	98625	Red	25
98626	98627	Clear	27
98628	98629	Lavender	30
98114	98115	Yellow	32

### 1 1/2" STAINLESS STEEL TIPS HELICAL THREAD



50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98163	98164	White	14
98165	98166	Amber	15
98167	98168	Green	18
98169	98170	Pink	20
98171	98172	Purple	21
98173	98174	Blue	22
98175	98176	Orange	23
98177	98178	Red	25
98179	98180	Light Grey	27

### 1/2" STAINLESS STEEL TIPS HELICAL THREAD



50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98396	98397	Amber	15
98398	98399	Green	18
98400	98401	Pink	20
98424	98425	Purple	21
98402	98403	Blue	22
98611	98612	Orange	23
98404	98405	Red	25
98104	98105	Lavender	30

### 45° x 1/2" STAINLESS STEEL TIPS HELICAL THREAD



50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98236	98237	White	14
98240	98241	Amber	15
98244	98245	Green	18
98248	98249	Pink	20
98252	98253	Purple	21
98256	98257	Blue	22
98260	98261	Orange	23
98264	98265	Red	25
98268	98269	Light Grey	27

### 1" STAINLESS STEEL TIPS HELICAL THREAD



50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98216	98217	White	14
98218	98219	Amber	15
98222	98223	Green	18
98224	98225	Pink	20
98226	98227	Purple	21
98228	98229	Blue	22
98230	98231	Orange	23
98232	98233	Red	25
98234	98235	Light Grey	27

### 90° x 1/2" STAINLESS STEEL TIPS HELICAL THREAD



50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98238	98239	White	14
98242	98243	Amber	15
98246	98247	Green	18
98250	98251	Pink	20
98254	98255	Purple	21
98258	98259	Blue	22
98262	98263	Orange	23
98266	98267	Red	25
98270	98271	Light Grey	27

## Tapered Dispense Tips



### 1 1/4" POLYETHYLENE TAPERED TIPS HELICAL THREAD AND UV LIGHT BLOCK ADDITIVE

50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98385	98386	White	14
98387	98388	Grey	16
98389	98390	Green	18
98391	98392	Pink	20
98393	98394	Blue	22
98658 *	98659 *	Red	25
98660 *	98661 *	Clear	27

\* New smaller gauge sizes.

## General Purpose Dispense Tips



### 1/2" STAINLESS STEEL TIPS

50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98208	98209	Olive	14
97225	98065	Amber	15
97226	98066	Green	18
97227	98067	Pink	20
98210	98211	Purple	21
98100	98080	Blue	22
98212	98213	Orange	23
97228	98068	Red	25
98214	98215	Clear	27

## Flexible Dispense Tips



### 1 1/2" POLYPROPYLENE TIPS HELICAL THREAD

50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
97229	98069	Amber	15
97230	98070	Green	18
97231	98071	Pink	20
97232	98082	Red	25

## General Purpose Tapered Dispense Tips



### 1 1/4" POLYETHYLENE TAPERED TIPS

50 pack Item Number	1000 pack Item Number	Hub Color	Gauge
98272	98273	Tan	14
97221	98061	Grey	16
97222	98062	Green	18
97223	98063	Pink	20
97224	98064	Blue	22

## Additional Dispense Tips and Accessories



### LOCTITE® SHOWCASE NEEDLE VARIETY KIT

Item Number: 98439

This kit contains 5 each of an assortment of high precision Stainless Steel tips in various lengths and gauges. Tapered and Flexible Dispense Tips are also included. All dispense tips have helical thread Luer-Lok® hubs for reliable locking.











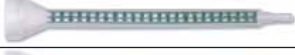











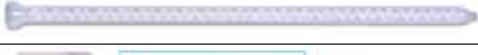








PRODUCT	Item Numbers	Description
	97238 / 98073	SS, PTFE Lined, 25 Gauge (50 / 1000 pack)
	97233	Luer-Lok® Adapter Kit, 20 Luer-Loks® and 5 adapters
	97248 / 98499	Tip caps (50 / 1000 pack)
	97261 / 98074	High Density Polyethylene, 15 Gauge, White (50 / 1000 pack)
	97262	Two each of a variety of Helical Threaded 1/2" Stainless Steel, Tapered Tip, and Polypropylene tips
	98637	Formable Dispense Tip, 21 Gauge (100 pack)
	97511	Tri-Nozzle - Helps eliminate bubbles in anaerobic gasket applications
	98652	Light blocking shield for dispense tips (10 pack)
	998390	Vari-Drop™ Applicator Brushes (10 pack)

## Cartridge Accessories









PRODUCT	Item #	Description
	98446	Roller Assembly 1" wide band
	98448	Roller Assembly 2" wide band
	98447	Replacement Rollers 1" wide (3 pack)
	98449	Replacement Rollers 2" wide (3 pack)
	98610	3/4" wide x 3/8" NPT Dispense nozzle (10 pack)
	1044246	Aero Nozzle for Silicones in aerosol cans (10 pack)
	98128	Cartridge Dispense Tip: 1/4" male Semco Thread (10 pack)
	98371	Cartridge-Needle Adapter: (Female Luer x 1/4" male Semco Thread) Luer-Lok® adapter for dispense needle attachment (5 pk)

PRODUCT	Item #	Description
	97215	Cartridge-Syringe Adapter: 1/4" Semco Thread x Female Luer used for downloading
	98181	Cartridge-Tube Fitting Adapter: 1/4" FNPT x 1/4" male Semco Thread used for connecting tube fittings to cartridges (984832 or 984833 also required and sold separately) (3 pack)
	984832	Tube Fitting: 1/4" male NPT x 1/4" feed tube (10 pack)
	984833	Tube Fitting: 1/4" male NPT x 3/8" feed tube (10 pack)
	982644	Cartridge Adapter: SS 1/4" FNPT x 1/4" female Fischbach Thread used for connecting tube fittings
	1045339	Cartridge-Needle Adapter: 1/4" MNPT Thread x Female Luer (shown with 982644 for 1/4" Fischbach) for needle attachment (5 pack)
	1044247	Cartridge-Syringe Adapter: 1/4" MNPT x Female Luer shown with 982644 for 1/4" Fischbach used for downloading (5 pack)

# Loctite® Brand Static Mix Nozzles and Accessories

PRODUCT	Item Numbers	Package Quantity	Description	
	98444 98365	10 1,000	50 ml Square Mix Nozzle, Luer / Stepped Combo Tip, 3.25" Overall Length, 5.3 mm², 16 elements, 1:1, 2:1 mix ratios.	
	98473 98632	10 1,000	50 ml Square Mix Nozzle, Luer / Stepped Combo Tip, 4.5" Overall Length, 5.3 mm², 24 elements, 1:1, 2:1, 4:1 mix ratios.	
	98622 983509	10 2,000	50 ml Mix Nozzle, 5.9" Overall Length, 0.250" ID, Slip-Luer, 20 elements, 1:1, 2:1 and 4:1 ratios. 	
	98623 98364	10 2,000	50 ml Mix Nozzle, 5.9" Overall Length, 0.250" ID, Stepped Tip Luer, 20 elements, 1:1, 2:1 and 4:1 ratios. 	
	98454	10	50 ml Mix Nozzle, Luer Tip, 6.0" Overall Length, 6.0 mm diameter, 21 elements, 1:1, 2:1, 4:1 mix ratios.	
	98455 98462	10 4,000	50 ml Mix Nozzle, Stepped Tip, 6.0" Overall Length, 6.0 mm diameter, 21 elements, 1:1, 2:1, 4:1 mix ratios.	
	98463 583804	10 1,000	50 ml Mix Nozzle, Stepped Tip, Keyed, 5.9" Overall Length, 5.4 mm diameter, 28 elements, 10:1 mix ratio.	
	1034575	10	50 ml-S Mix Nozzle, Stepped Tip, 6.2" Overall Length, 6.5 mm ID, 20 elements, 10:1-S cartridges only.	
	98373 98374	10 1,000	200 / 400 ml Square Mix Nozzle, Luer / Stepped Combo Tip, 5.0" Overall Length, 5.3 mm², 24 elements, 1:1, 2:1, 4:1 mix ratios.	
	98474 98653	10 1,000	200 / 400 ml Square Mix Nozzle, Stepped Tip, 5.1" Overall Length, 7.5 mm², 24 elements, 1:1, 2:1 mix ratios.	
	98667 98668	10 500	200 / 400 ml Square Mix Nozzle, Threaded Bell End 10.7 mm square, 187 mm Overall Length, 24 elements, 1:1, 2:1 ratios.	
	98456 1053262	10 2,000	200 / 400 ml Mix Nozzle, Stepped Tip, 7.3" Overall Length, 6.3 mm diameter, 24 elements, 1:1, 2:1 mix ratios.	
	98457 98464	10 1,500	200 / 400 ml Mix Nozzle, Stepped Tip, 8.8" Overall Length, 8 mm diameter, 24 elements, 1:1, 2:1 mix ratios.	
	98459	10	200 / 400 ml Mix Nozzle, Stepped Tip, 10.9" Overall Length, 10 mm diameter, 24 elements, 1:1, 2:1 mix ratios.	
	989516	50	200 / 400 ml Mix Nozzle, 7.4" Overall Length, 0.188" ID, Stepped Tip, 32 Elements, 1:1, 2:1 and 4:1 ratios.	
	989518	10	200 / 400 ml Mix Nozzle, 9.0" Overall Length, 0.188" ID, Stepped Tip, 48 Elements, 1:1, 2:1 and 4:1 ratios.	
	918088	10	200 / 400 ml Mix Nozzle, Luer Tip, 9.5" Overall Length, 0.25" ID, Slip Luer, 32 Elements, 1:1 and 2:1 ratios.	
	1032026 1032028	10 1,000	200 / 400 ml Mix Nozzle, 11.44" Overall Length, 8 mm diameter, 32 elements, 1:1, 2:1 mix ratios.	
	98460	10	200 / 400 ml Mix Nozzle, Stepped Tip, Keyed, 9.1" Overall Length, 8 mm diameter, 24 elements, 10:1 ratio.	
	98461 98409	10 1,000	200 / 400 ml Mix Nozzle, Stepped Tip, Keyed, 10.8" Overall Length, 10 mm diameter, 24 elements, 4:1, 10:1 mix ratios.	
	98672 98430	10 500	200 / 400 ml Mix Nozzle, Stepped Tip, 14.2" Overall Length, 9.3 mm diameter, 40 elements, 1:1, 2:1 mix ratios.	
	98458 970655	10 2,000	Luer-Lok® Adapter for 6.3 and 8 mm Stepped Tip Mix Nozzles, Allows for Dispense Needle Attachment, (10 pack). Mix Nozzles and Dispense Needles sold separately.	
	98344	10	Ribbon Tip Adapter, allows Ribbon Tip use with 10 mm. Mix Nozzles 98461, 98459 and 98409 sold separately.	
	98467	10	200 / 400 ml Snap Tip Mix Nozzle, 8.9" overall length, 8 mm diameter, 24 elements, 1:1, 2:1 mix ratios. For use with Ribbon Tips.	
	98469 98367	10 1,000	200 / 400 ml Snap Tip Mix Nozzle, 9.3" overall length, 9.3 mm diameter, 24 elements, 1:1, 2:1 mix ratios. For use with Ribbon Tips.	
	98470	See description	Snap-Tip Mix Nozzle and Ribbon Tip Sample Kit. Contains: 6 pieces each of 12, 25, and 43 mm Ribbon Tips 3 pieces each of 8 and 9.3 mm diameter Snap-Tip Mix Nozzles	
	98476 98410	10 500		12 mm Ribbon Tip. Sold Separately.
	98477 98411	10 500		25 mm Ribbon Tip. Sold Separately.
	98478 98412	10 500		43 mm Ribbon Tip. Sold Separately.

## Loctite® Brand Syringe Accessories






PRODUCT	Item Numbers	Description	Contents
	98656 98657 97208 97245	3 ml Syringe Air Line Adapter 5 ml Syringe Air Line Adapter 10 ml Syringe Air Line Adapter 30 ml and 55 ml Syringe Air Line Adapter	2 Air Line Adapters – Common to all part numbers (syringe barrel sold separately)
	97216	10 ml Syringe Starter Kit	5 Caps 5 Pistons 4 Clear Barrels 1 Black Barrel 5 Tips 1 Air Line Adapter
	97294	30 ml Syringe Starter Kit	
	98416	55 ml Syringe Starter Kit	
	97207	10 ml Clear Syringe Barrel Kit	20 Barrel Caps, 40 Pistons, 40 Barrels, 40 Barrel Tips
	97244	30 ml Clear Syringe Barrel Kit	10 Barrel Caps, 20 Pistons, 20 Barrels, 20 Barrel Tips
	98314	55 ml Clear Syringe Barrel Kit	5 Barrel Caps, 10 Pistons, 10 Barrels, 10 Barrel Tips
	97263	10 ml Black Syringe Barrel Kit for UV Adhesives	20 Barrel Caps, 40 Pistons, 40 Barrels, 40 Barrel Tips
	97264	30 ml Black Syringe Barrel Kit for UV Adhesives	10 Barrel Caps, 20 Pistons, 20 Barrels, 20 Barrel Tips
	98315	55 ml Black Syringe Barrel Kit for UV Adhesives	5 Barrel Caps, 10 Pistons, 10 Barrels, 10 Barrel Tips
	Various	Clear or Black 3, 5, 10, 30, and 55 ml Piston / Syringe Combination Packages	Visit <a href="http://www.equipment.loctite.com">www.equipment.loctite.com</a> for syringe and piston options and item numbers.
	Various	Dark Amber Syringe and Piston options	Available upon request. Please contact your Loctite® Sales Representative or contact us at <a href="http://www.equipment.loctite.com">www.equipment.loctite.com</a> .
	984650	Air Line Filter for Syringe Dispensing to prevent product back-flow	1 Filter Assembly with 2 Hose Crimps
	984625	Loctite® Vertical Syringe Stand for 10 ml and 30 ml syringe barrels (Black)	1 Stand (syringe barrel and air line adapter sold separately)
	98501	Loctite® Applicator Holder for 10 ml, 30 ml and 55 ml syringe barrels (Red)	1 Holder (syringe barrel and air line adapter sold separately)



# Light Cure Solutions

Henkel offers the widest selection of light curing equipment available from any one company on the market today. Our Loctite® brand insures you have the most innovative and dependable systems for all your light curing adhesive applications. Whether your process calls for a manual, semiautomatic or fully integrated automatic solution, you will find the Loctite® brand light curing device to meet your specific requirements. Please see the charts below that summarize our complete line.

PRODUCT		Item Number	Options / Accessories
<b>LED CURING DEVICES</b> – High powered benchtop and portable systems for visible light cure adhesives, providing effective spot curing solutions for both manual and integrated automatic systems.			
	Loctite® 7700 LED Light Source	98591	– OPTIONAL – Timer – 98443 Foot Switch – 98440 Holder – 98522 Dosimeter – 98089 Dosimeter Adapter – 98453
	Loctite® 7703 LED Light Source	98595	
	Loctite® 7700-HD LED Light Source	98601	– (1) OF THE FOLLOWING ARE REQUIRED – Timer – 960356 PLC Cable – 8900550 Foot Switch – 97201 Pistol Grip Timer – 1003327
	Loctite® 7703-HD LED Light Source	883979	
 <b>NEW</b>	Loctite® CureJet™ 405 LED	976420	Used with 976419
 <b>NEW</b>	Loctite® CureJet™ Indigo™ LED	976418	Used with 976419
 <b>NEW</b>	Loctite® LED Controller	976419	Used with 976418 and 976420. Requires cable 1008353.
<b>WAND SYSTEMS</b> – Four different spot curing systems. one visible light and three UV, each with its own range of curing intensity from 1 to 20 W/cm <sup>2</sup> . These systems are ideal for both manual and integrated automatic systems.			
	Loctite® Indigo™ 7720 Visible Light Wand System	98633	– REQUIRED – Light Guide – 98634
	Loctite® ZETA® 7735 UV Wand System	98317A 958216 (Bulb Life Monitoring)	– (1) OF THE FOLLOWING ARE REQUIRED – Light Guide 5 mm x 1,000 mm – 986377 Light Guide 5 mm x 1,500 mm – 951681 for other Light Guide options, visit <a href="http://www.equipment.loctite.com">www.equipment.loctite.com</a>  – OPTIONAL – Monitor – 891494 used only with 958216, 958228, 958239
	Loctite® ZETA® 7740 UV Wand System	98157A 958228 (Bulb Life Monitoring)	
	Loctite® ZETA® 7760 UV Wand System	98450 958239 (Bulb Life Monitoring)	





PRODUCT	Item Number	Lamp Type
<b>ENCLOSED CHAMBER AND FLOOD SYSTEMS</b> — These systems are ideal for batch processing. UV and alternate visible light bulb options are available.		
 <b>Loctite® UVALOC 1000 UV Cure Chamber</b>	805741	1000 watt Mercury Vapor
 <b>Loctite® ZETA® 7401 UV Chamber</b>	98039	400 watt Metal Halide
 <b>Loctite® ZETA® 7411-S UV Flood System</b>	98413	400 watt Metal Halide
 <b>Loctite® Indigo™ 7418 Visible Flood System</b>	971031	400 watt Visible Arc Lamp
 <b>Loctite® ZETA® 7420 Visible Light Flood System</b>	98060 (110 V)	500 watt Visible Arc Lamp
	98182 (220 V)	



For proper eye protection, use Loctite® brand ultraviolet safety glasses.

Item 97210



Item 98452

PRODUCT	Item Number	Lamp Type
<b>CURE CONVEYORS</b> — Can be used for either continuous or batch processing of assemblies.		
 <b>Loctite® ZETA® 7415 UV Benchtop Conveyor</b>	98003	300 W/in. Electrodeless (Sold Separately)
 <b>Loctite® ZETA® 7610 UV Benchtop Conveyor</b>	98588	1,800 watt Medium Pressure Mercury Arc Lamp
<b>LIGHT SOURCES</b> — Can be used with our Loctite® ZETA® UV conveyors or integrated into a custom system with added shielding, cooling and venting (not included with these products).		
 <b>Loctite® Electrodeless Lamp Assembly and Power Supply</b>	98004 (208 VAC)	300 W/in. Electrodeless
	98005 (240 VAC)	
 <b>Loctite® High Intensity Ultraviolet Sources</b>	980160	1,500 watt Medium Pressure Mercury Arc Lamp

PRODUCT	Item Number	Measurement Range
<b>LIGHT METERS</b> — UV and visible light cure systems. These meters provide precise and repeatable measurement of any Loctite® brand light cure system to ensure your process remains in control.		
 <b>Loctite® ZETA® 7011-A Dosimeter-Radiometer</b>	98086	320 to 400 nm
 <b>Loctite® ZETA® 7011-V Dosimeter-Radiometer</b>	98089	350 to 500 nm

[www.visible.loctite.com](http://www.visible.loctite.com)

Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.

# Motion Control Robot Dispense Systems

Available in both Benchtop and SCARA model types, Loctite® brand robots are designed to simplify the dispensing of adhesives and sealants onto complex surface configurations. They allow manufacturers to dispense repeatedly and reliably patterns of liquid material on a programmed basis, resulting in improved process efficiencies, minimal material waste, and reduced manufacturing costs.

## Robot Types

Benchtop robots are beam- or gantry-style robots designed to be placed on a bench. These robots carry one or more parts that are captured in a fixture that is mounted on the work surface. Motion in the X axis is achieved by moving the work surface forward and backward. The Y and Z axes are achieved by moving the tool head left and right and up and down, respectively, on the beam or gantry. When applicable, the 4th axis (R axis) is achieved by rotating the mounting shaft that protrudes from the tool head.

SCARA is an acronym for Selective Compliance Assembly Robot Arm. The robot is a multi-jointed arm that moves above the work surface. It must be mounted near the work surface by the user. The X and Y axes are achieved by changing the angles of the two arms. This creates a kidney-shaped dispensing area that is approximately 880 mm (34.6") wide and 440 mm (17.3") tall at the center. The Z axis is achieved by moving both arms up and down. On the 4-axis models, the R axis is achieved by rotating the mounting shaft that protrudes from the end of the arm.

*For detailed dimension drawings of all  
benchtop robots, please visit the web at:*

**[www.equipment.loctite.com](http://www.equipment.loctite.com)**

*Just search on the part number you are interested  
in and scroll down to the product documentation.*

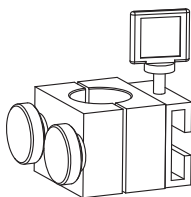


PRODUCT		Loctite® 200 Benchtop Robot Station	Loctite® 300 Benchtop Robot Station	Loctite® 400 Benchtop Robot Station	Loctite® 500 Benchtop Robot Station	Loctite® S440 SCARA-N Robot Station
Type		Benchtop	Benchtop	Benchtop	Benchtop	SCARA
Number of controllable axes		3 or 4	3 or 4	3 or 4	3 or 4	3 or 4
Range of operation	X axis	200 mm	300 mm	400 mm	510 mm	Arm 1: 260 mm ± 90°
	Y axis	200 mm	320 mm	400 mm	510 mm	Arm 2: 180 mm ± 150°
	Z axis	50 mm	100 mm	150 mm	150 mm	100 mm
	R axis	± 360°	± 360°	± 360°	± 360°	± 360°
Portable weight limitations	Work Surface	7.0 kg	11.0 kg	11.0 kg	11.0 kg	N/A
	Tool Head	3.5 kg	6.0 kg	6.0 kg	6.0 kg	5.0 kg
Speed	PTP (X, Y)	5 to 700 mm/s	8 to 800 mm/s	8 to 800 mm/s	8 to 800 mm/s	15 to 1500 mm/s
	PTP (Z)	5 to 250 mm/s	3.2 to 320 mm/s	3.2 to 320 mm/s	3.2 to 320 mm/s	3.2 to 320 mm/s
	PTP (R)	6 to 600 °/s	8 to 800 °/s	8 to 800 °/s	8 to 800 °/s	10 to 1,000 °/s
	CP (X, Y, Z)	0.1 to 500 mm/s	0.1 to 800 mm/s	0.1 to 800 mm/s	0.1 to 800 mm/s	0.1 to 800 mm/s
Item Number	3 axis	98279A	98287A	98295A	98602	1008351
	4 axis	98283A	98291A	98299A	98606	1008338

## Loctite® Brand Mounting Hardware, Workbenches, and Guarding Enclosures

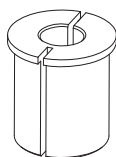
**MOUNTING BRACKET KITS** – Mounting bracket kits are used to grasp syringe barrels, Loctite® Posi-Link™ syringe and dual cartridge nests, 300 ml cartridges, dispense valves, and LEDs. Mounting rails or adapters are required to mount the brackets on the robot or dispense station.

Item #	Description
98316	30 ml syringe mounting bracket kit
98318	300 ml cartridge mounting bracket kit
98326	98009 and 98013 valve mounting bracket kit
98327	97113 and 97114 valve mounting bracket kit
98406	983914 and 986300 poppet valve mounting bracket kit
98441	98520 spray and 98084 micro needle valve mounting bracket kit
98646	Universal syringe bracket for Posi-Link™
98647	50 ml dual cartridge bracket for Posi-Link™
98669	98591 and 98595 LED mounting bracket kit



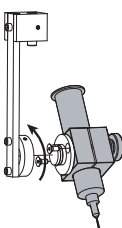
**3, 5 AND 10 ML SYRINGE ADAPTERS** – These adapters are inserted into the 30 ml syringe mounting bracket kit to adapt it for 3, 5 and 10 ml syringes. The 30 ml syringe mounting bracket (item 98316) must be purchased separately.

Item #	Description
98320	10 ml adapter for use with 98316
98321	5 ml adapter for use with 98316
98322	3 ml adapter for use with 98316



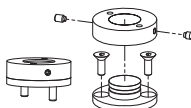
**MOUNTING ADAPTER FOR ALL 4 AXIS ROBOTS** – A mounting adapter is required when using Loctite® brand mounting hardware for all 4-axis robots. The mounting adapter includes a 360-degree rotation kit.

Item #	Description
98336	Mounting adapter for 4-axis robots



**360-DEGREE ROTATION KIT** – This is used to allow for 360 degrees of rotation when using a mounting bracket kit or tip locator. A 360-degree rotation kit is already included with the mounting adapter for 4-axis robots.

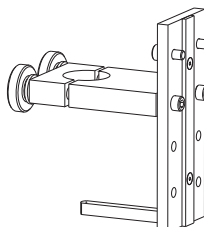
Item #	Description
98325	360-degree rotation kit



### COMPLETE MOUNTING KITS FOR 3-AXIS SCARA ROBOTS\*

Complete mounting adapter kits hold the syringe, cartridge or valve; and position the dispense tip 60 mm from the end of the tool arm.

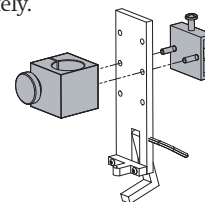
Item #	Description
98340	30 ml syringe holder
98341	300 ml cartridge holder
98342	98009 and 98013 valve holder
98343	97113 and 97114 valve holder
98408	983914 and 986300 poppet valve holder



\* These are sized for 25 gauge needles and must be modified by the user for larger gauge sizes.

**TIP LOCATOR BRACKETS\*** – Tip locator brackets position the dispense tip to increase precision and are used to mechanically set the tip height during installation. A mounting bracket and rail, plate or adapter must be purchased separately.

Item #	Description
98332	Tip locator bracket for 30 ml syringes
98333	Tip locator bracket for 300 ml cartridges
98334	Tip locator bracket for 98009 and 98013 valves
98335	Tip locator bracket for 97113 and 97114 valves
98407	Tip locator bracket for 983914 and 986300 poppet valve

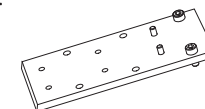


\* These are sized for 1", 25 gauge stainless steel needles and must be modified by the user for larger gauge sizes.

### Z HEIGHT ADJUSTMENT PLATE FOR 3-AXIS BENCHTOP ROBOTS

This plate allows you to attach the mounting rails above or below the mounting bracket on the robot.

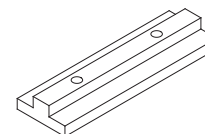
Item #	Description
98357	Z height adjustment plate
929541	Z height adjustment plate - Posi-Link™ 200-400 Nests



### MOUNTING RAILS FOR 3-AXIS BENCHTOP ROBOTS AND DISPENSE STATIONS

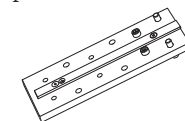
A mounting rail is required when using Loctite® brand mounting hardware for all 3-axis Benchtop Robots and Dispense Stations.

Item #	Description
98328	3 3/4 inch bar with two cap screws
98329	8 3/4 inch bar with two cap screws
98330	12 inch bar with two cap screws



**MOUNTING PLATE FOR 3-AXIS SCARA ROBOTS** – A mounting plate is required when using Loctite® brand mounting hardware for all 3-axis SCARA Robots (except when using a complete mounting kit).

Item #	Description
98337	Mounting plate for SCARA robot



### WORKBENCHES

- Strong and sturdy
- Accommodate all Loctite® brand robots

**GUARDING SYSTEMS** – For plants requiring higher safety levels

- Light Curtain or Interlocked Sliding Door\* on front
- Sturdy extruded aluminum frame
- Polycarbonate panels on left, right and rear
- Operator control panel mounted on front right
- Direct plug-in to robots

\* Interlocked door model for Benchtop units only



Item #	Description	Dimensions
989783	200 Series Workbench	36" W x 24" D x 36" H
989784	300 Series Workbench	42" W x 30" D x 36" H
989785	400 / 500 Series Workbench	48" W x 36" D x 36" H
989860	SCARA Series Workbench	48" W x 48" D x 36" H
989787	200 Series Slide Door	22" W x 24" D x 27" H
989763	200 Series Light Curtain	22" W x 24" D x 27" H
989788	300 Series Slide Door	30" W x 30" D x 30" H
989771	300 Series Light Curtain	30" W x 30" D x 30" H
989789	400 / 500 Series Slide Door	32" W x 36" D x 35" H
989777	400 / 500 Series Light Curtain	32" W x 36" D x 35" H
989852	SCARA Light Curtain	48" W x 48" D x 36" H



# Agency Approvals

## NSF International

### NON-FOOD COMPOUND

Loctite® 222MS™ Threadlocker, Low Strength / Small Screw  
Loctite® 242™ Threadlocker, Medium Strength  
Loctite® 262™ Threadlocker, Medium to High Strength  
Loctite® 290™ Threadlocker, Wicking Grade  
Loctite® 587™ Blue, High Performance RTV  
Silicone Gasket Maker  
Loctite® 5900™ Flange Sealant, Heavy Body RTV Silicone  
Loctite® 7649™ Primer N™  
Loctite® Food Grade Anti-Seize  
Loctite® Food Grade Grease  
Loctite® ODC-Free Cleaner & Degreaser

### STANDARD 51

Loctite® Superflex® RTV Silicone Adhesive Sealants  
(Black, Clear, White)

### STANDARD 61

Loctite® H4000™ Speedbonder™ Structural Adhesive, Non-Sag  
Loctite® 55™ Pipe Sealing Cord  
Loctite® 242™ Threadlocker, Medium Strength  
Loctite® 243™ Threadlocker, Medium Strength / Oil Resistant  
Loctite® QuickStix™ 248™ Threadlocker,  
Medium Strength / Removable  
Loctite® 290™ Threadlocker, Wicking Grade  
Loctite® 480™ Prism® Instant Adhesive, Black / Toughened  
Loctite® 518™ Gasket Eliminator® Flange Sealant  
Loctite® QuickStix™ 561™ PST® Pipe Sealant  
Loctite® 564™ Thread Sealant, General Purpose  
Loctite® 565™ PST® Thread Sealant, Controlled Strength  
Loctite® 567™ PST® Thread Sealant, High Temperature  
Loctite® 680™ Retaining Compound, Slip Fit / High Strength  
Loctite® 7649™ Primer N™  
Loctite® Fixmaster® Metal Magic Steel™

### H1

Loctite® ViperLube® Clear High Performance Synthetic Grease  
Loctite® ViperLube® High Performance Synthetic Grease  
Loctite® ViperLube® High Performance Synthetic Lubricant ISO-220  
Loctite® ViperLube® High Performance Synthetic Lubricant ISO-32  
Loctite® ViperLube® ISO-46  
Loctite® ViperLube® ISO-460  
Loctite® ViperLube® ISO-68  
Loctite® ViperLube® High Performance Synthetic Grease (aerosol)  
Loctite® Food Grade Anti-Seize  
Loctite® Food Grade Grease  
Loctite® ODC-Free Cleaner & Degreaser

## American Bureau of Shipping (ABS)

Loctite® 242™ Threadlocker, Medium Strength  
Loctite® 262™ Threadlocker, Medium to High Strength  
Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose  
Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel  
Loctite® 495™ Super Bonder® Instant Adhesive  
Loctite® 545™ Thread Sealant, Hydraulic / Pneumatic Fittings  
Loctite® 567™ PST® Thread Sealant, High Temperature  
Loctite® 587™ Blue, High Performance RTV  
Silicone Gasket Maker  
Loctite® 598™ Black, High Performance RTV  
Silicone Gasket Maker  
Loctite® 620™ Retaining Compound, Slip Fit / High Temperature  
Loctite® 680™ Retaining Compound, Slip Fit / High Strength  
Loctite® Extend® Rust Treatment  
Loctite® Fixmaster® Aluminum Liquid  
Loctite® Fixmaster® Aluminum Putty  
Loctite® Fixmaster® Poxy Pak™, Fast Cure Epoxy  
Loctite® Fixmaster® Fast Set Steel Putty  
Loctite® Fixmaster® Flex 80™ Putty  
Loctite® Fixmaster® Marine Chocking  
Loctite® Fixmaster® Stainless Steel Putty  
Loctite® Fixmaster® Steel Liquid  
Loctite® Fixmaster® Steel Putty

Loctite® Fixmaster® Wear Resistant Putty  
Loctite® Fixmaster® Wet Surface Repair Putty  
Loctite® Marine Grade Anti-Seize  
Loctite® Nickel Anti-Seize  
Loctite® Nordbak® Brushable Ceramic, Grey  
Loctite® Nordbak® Pneu-Wear  
Loctite® Silver Grade Anti-Seize

## Navy Environmental Health Center (NEHC) and Naval Sea Systems Command (NAVSEA)

Loctite® Fixmaster® Aluminum Putty  
Loctite® Fixmaster® Fast Set Steel Epoxy  
Loctite® Fixmaster® Marine Chocking – Orange  
Loctite® Fixmaster® Stainless Steel Putty  
Loctite® Fixmaster® Steel Liquid  
Loctite® Fixmaster® Steel Putty  
Loctite® Fixmaster® Superior Metal  
Loctite® Fixmaster® Wear Resistant Putty  
Loctite® Fixmaster® Wet Surface Repair Putty  
Loctite® Nordbak® Brushable Ceramic – Grey  
Loctite® Nordbak® Pneu-Wear  
Loctite® Nordbak® Wearing Compound

## Canadian Food Inspection Agency (CFIA)

Loctite® 220™ Threadlocker, Wicking Grade / Low Strength  
Loctite® 222MS™ Threadlocker, Low Strength / Small Screw  
Loctite® 242™ Threadlocker, Medium Strength  
Loctite® 243™ Threadlocker, Medium Strength / Oil Resistant  
Loctite® QuickStix™ 248™ Threadlocker,  
Medium Strength / Removable  
Loctite® 262™ Threadlocker, Medium to High Strength  
Loctite® 266™ Threadlocker, High Strength / High Temperature  
Loctite® QuickStix™ 268™ Threadlocker, High Strength  
Loctite® 271™ Threadlocker, High Strength  
Loctite® 272™ Threadlocker, High Strength / High Temperature  
Loctite® 2760™ Threadlocker, Primerless / High Strength  
Loctite® 290™ Threadlocker, Wicking Grade  
Loctite® 330™ Depend® Adhesive, No Mix  
Loctite® 380™ Black Max® Instant Adhesive, Toughened  
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive  
Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose  
Loctite® 410™ Prism® Instant Adhesive, Black / Toughened  
Loctite® 414™ Super Bonder® Instant Adhesive  
Loctite® 416™ Super Bonder® Instant Adhesive  
Loctite® 422™ Super Bonder® Instant Adhesive  
Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel  
Loctite® 518™ Gasket Eliminator® Flange Sealant  
Loctite® 545™ Thread Sealant, Pneumatic / Hydraulic  
Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant  
Loctite® 554™ Thread Sealant, Refrigerant Sealant  
Loctite® QuickStix™ 561™ PST® Pipe Sealant  
Loctite® 564™ Thread Sealant, General Purpose  
Loctite® 565™ PST® Thread Sealant, Controlled Strength  
Loctite® 567™ PST® Thread Sealant, High Temperature  
Loctite® 569™ Thread Sealant, Hydraulic Sealant  
Loctite® 5699™ Grey, High Performance RTV  
Silicone Gasket Maker  
Loctite® 587™ Blue, High Performance RTV  
Silicone Gasket Maker  
Loctite® 5900™ Flange Sealant, Heavy Body RTV Silicone  
Loctite® 5905™ Flange Sealant, RTV Silicone  
Loctite® 5910™ Flange Sealant, RTV Silicone  
Loctite® 592™ PST® Thread Sealant, Slow Cure  
Loctite® 5920™ Copper, High Performance RTV  
Silicone Gasket Maker  
Loctite® Superflex® Silicone Adhesive Sealant, Black  
Loctite® Superflex® Silicone Adhesive Sealant, White  
Loctite® Superflex® Silicone Adhesive Sealant, Clear  
Loctite® Superflex® Red High Temp RTV,  
Silicone Adhesive Sealant  
Loctite® 598™ Black, High Performance RTV  
Silicone Gasket Maker

Loctite® 609™ Retaining Compound, Press Fit / General Purpose  
Loctite® 620™ Retaining Compound, Slip Fit / High Temperature  
Loctite® 638™ Retaining Compound, Slip Fit / Maximum Strength  
Loctite® 641™ Retaining Compound,  
Press & Slip Fit / Controlled Strength  
Loctite® 660™ Quick Metal® Retaining Compound,  
Press Fit Repair  
Loctite® 680™ Retaining Compound, Slip Fit / High Strength  
Loctite® 712™ Tak Pak® Accelerator  
Loctite® 7649™ Primer N™  
Loctite® 770™ Prism® Primer  
Loctite® Aviation Gasket Sealant  
Loctite® Belt Dressing & Conditioner  
Loctite® Big Foot™ Acrylic Pedestrian Grade  
Loctite® Big Foot™ Heavy Duty Pedestrian Grade  
Loctite® Big Foot™ Low Profile Pedestrian Grade  
Loctite® Big Foot™ Vehicular Grade  
Loctite® Big Foot™ Zero V.O.C.  
Loctite® QuickStix™ C5-A® Copper Anti-Seize  
Loctite® Chisel® Gasket Remover  
Loctite® Cold Galvanizing Compound  
Loctite® Color Guard®, Black  
Loctite® Color Guard®, Blue  
Loctite® Color Guard®, Red  
Loctite® Color Guard®, Yellow  
Loctite® Contact Adhesive, Yellow  
Loctite® Contact Adhesive, Black  
Loctite® Extend® Rust Treatment  
Loctite® Fixmaster® Aluminum Liquid  
Loctite® Fixmaster® Aluminum Putty  
Loctite® Nordbak® Brushable Ceramic, Grey  
Loctite® Nordbak® Brushable Ceramic, Red  
Loctite® Nordbak® Brushable Ceramic, White  
Loctite® Nordbak® Chemical Resistant Coating  
Loctite® Fixmaster® Deep Pour Grout  
Loctite® Fixmaster® Fast Cure Epoxy, Mixer Cups  
Loctite® Fixmaster® Poxy Pak™  
Loctite® Fixmaster® Fast Set Grout  
Loctite® Fixmaster® Fast Set Steel Epoxy  
Loctite® Fixmaster® Fast Set Steel Putty  
Loctite® Fixmaster® Floor Fill  
Loctite® Fixmaster® General Purpose Epoxy, Mixer Cups  
Loctite® Fixmaster® High Performance Epoxy  
Loctite® Fixmaster® High Performance Quartz  
Loctite® Fixmaster® Magna-Crete  
Loctite® Fixmaster® Marine Chocking  
Loctite® Nordbak® Fast Cure Pneu-Wear  
Loctite® Nordbak® Pneu-Wear  
Loctite® Fixmaster® Stainless Steel Putty  
Loctite® Fixmaster® Steel Liquid  
Loctite® Fixmaster® Steel Putty  
Loctite® Fixmaster® Superior Metal  
Loctite® Fixmaster® Underwater Repair Epoxy  
Loctite® Fixmaster® Wear Resistant Putty  
Loctite® Food Grade Anti-Seize  
Loctite® Food Grade Grease  
Loctite® Silicone Lubricant  
Loctite® Form-A-Thread® Stripped Thread Repair  
Loctite® Gasket Sealant 1  
Loctite® High Temperature Gasket Maker  
Loctite® H.V.A.C. Blue Pipe Joint Compound  
Loctite® 0151™ Hysol® Epoxy Adhesive, Ultra Clear  
Loctite® 10C™ Hysol® Epoxy Adhesive  
Loctite® 11C™ Hysol® Epoxy Adhesive  
Loctite® 1C™ Hysol® Epoxy Adhesive  
Loctite® 608™ Hysol® Epoxy Adhesive, High Strength  
Loctite® 615™ Hysol® Epoxy Adhesive, Sandable  
Loctite® 6C™ Hysol® Epoxy Adhesive  
Loctite® 907™ Hysol® Epoxy Adhesive  
Loctite® 9340™ Hysol® Epoxy Adhesive  
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor  
Loctite® E-00NS™ Hysol® Epoxy Adhesive, Non-Sag

Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened  
 Loctite® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength  
 Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting  
 Loctite® E-20NS™ Hysol® Epoxy Adhesive, Metal Bonder  
 Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder  
 Loctite® E-40FL™ Hysol® Epoxy Adhesive, Flexible  
 Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened  
 Loctite® E-60NC™ Hysol® Epoxy Adhesive,  
 Electrically Non-Corrosive  
 Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible  
 Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength  
 Loctite® U-10FL™ Hysol® Urethane Adhesive  
 Loctite® Instant Gasket  
 Loctite® Maintain® Lubricant Penetrant  
 Loctite® Maxi-Coat™, Aerosol  
 Loctite® Maxi-Coat™, Liquid  
 Loctite® Natural Blue® Biodegradable Cleaner & Degreaser  
 Loctite® Natural Blue® Biodegradable  
 Cleaner & Degreaser, Fragrance-Free  
 Loctite® No More Leaks™ Plastic Pipe Sealant  
 Loctite® O-Ring Making Kit  
 Loctite® Pipe Repair Kit  
 Loctite® QuickStix™ Silver Grade Anti-Seize  
 Loctite® Silver Grade Anti-Seize  
 Loctite® Silver Grade Anti-Seize, Aerosol  
 Loctite® Solvo-Rust® Super Penetrating Oil  
 Loctite® Thread Sealant With PTFE  
 Loctite® Urethane Sealant  
 Loctite® ViperLube® Clear High Performance Synthetic Grease  
 Loctite® ViperLube® High Performance Synthetic Grease  
 Loctite® ViperLube® High Performance Synthetic Grease, Aerosol

### Military Specifications (Mil Spec)

Loctite® 220™ Threadlocker, Wicking Grade / Low Strength  
 Loctite® 222MS™ Threadlocker, Low Strength / Small Screw  
 Loctite® 242™ Threadlocker, Medium Strength  
 Loctite® 262™ Threadlocker, Medium to High Strength  
 Loctite® 271™ Threadlocker, High Strength  
 Loctite® 277™ Threadlocker, High Strength / Large Threads  
 Loctite® 290™ Threadlocker, Wicking Grade  
 Loctite® 571™ Thread Sealant, Pipe Sealant HVV  
 Loctite® 609™ Retaining Compound, Press Fit / General Purpose  
 Loctite® 635™ Retaining Compound,  
 Slip Fit / High Strength / Slow Cure  
 Loctite® 640™ Retaining Compound,  
 Press Fit / Medium Strength / High Temperature  
 Loctite® 675™ Retaining Compound, Press Fit / Medium Strength  
 Loctite® 712™ Tak Pak® Accelerator  
 Loctite® 5040™ RTV Silicone  
 Loctite® 5045™ Flange Sealant  
 Loctite® 7452™ Tak Pak® Accelerator  
 Loctite® 7471™ Primer T™  
 Loctite® 7649™ Primer N™  
 Loctite® C5-A® Copper Anti-Seize Lubricant  
 Loctite® Moly-50™ Anti-Seize  
 Loctite® QuickStix™ C5-A® Copper Anti-Seize  
 Loctite® QuickStix™ Silver Grade Anti-Seize  
 Loctite® Silver Grade Anti-Seize  
 Loctite® Thread Sealant With PTFE

### Military Specifications (Commercial Item Standard)

Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose  
 Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive  
 Loctite® 414™ Super Bonder® Instant Adhesive  
 Loctite® 415™ Super Bonder® Instant Adhesive  
 Loctite® 416™ Super Bonder® Instant Adhesive  
 Loctite® 420™ Super Bonder® Instant Adhesive  
 Loctite® 422™ Super Bonder® Instant Adhesive  
 Loctite® 430™ Super Bonder® Instant Adhesive

Loctite® 444™ Tak Pak® Instant Adhesive  
 Loctite® 493™ Super Bonder® Instant Adhesive  
 Loctite® 495™ Super Bonder® Instant Adhesive  
 Loctite® 496™ Super Bonder® Instant Adhesive

### FDA CFR175.105.

Loctite® 1X™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® 3X™ Hysol® Polyshot™ Hot Melt Adhesive, EVA Based  
 Loctite® 232™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® 236™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® 342™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® 740™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® 0740LV™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® 6002™ Hysol® Hot Melt Adhesive  
 Loctite® CoolMelt™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® QuikPac™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® SuperPac™ Hysol® Hot Melt Adhesive, EVA Based  
 Loctite® WaxPac™ Hysol® Hot Melt Adhesive, EVA Based

### UL Classified / Listed for U.S.

Loctite® 55™ Pipe Sealing Cord  
 Loctite® 271™ Threadlocker, High Strength  
 Loctite® 510™ Gasket Eliminator® Flange Sealant  
 Loctite® 515™ Gasket Eliminator® Flange Sealant  
 Loctite® QuickStix™ 561™ PST® Pipe Sealant  
 Loctite® 565™ PST® Thread Sealant, Controlled Strength  
 Loctite® 567™ PST® Thread Sealant, High Temperature  
 Loctite® 587™ Blue, High Performance RTV  
 Silicone Gasket Maker  
 Loctite® 592™ PST® Thread Sealant, Slow Cure  
 Loctite® 5083™ Nuva-Sil® Silicone Potting Compound  
 Loctite® 5091™ Nuva-Sil® Silicone  
 Potting Compound, High Adhesion  
 Loctite® 5600™ Silicone Sealant  
 Loctite® 5950™ Fastgasket® Flange Sealant, Cure-in-Place  
 Loctite® 7804FRM-HV™ Hysol® Hot Melt Adhesive  
 Loctite® 7809FR™ Hysol® Hot Melt Adhesive, Polyamide  
 Loctite® Superflex® Clear Non-Corrosive RTV,  
 Clear Silicone Adhesive Sealant  
 Loctite® Superflex® RTV, Silicone Adhesive Sealants  
 (Black, Clear, White)

### ULC Classified for Canada

Loctite® 564™ Thread Sealant, General Purpose  
 Loctite® 565™ PST® Thread Sealant, Controlled Strength  
 Loctite® 567™ PST® Thread Sealant, High Temperature  
 Loctite® 592™ PST® Thread Sealant, Slow Cure  
 Loctite® QuickStix™ 561™ PST® Pipe Sealant  
 Loctite® Superflex® RTV, Silicone Adhesive Sealants  
 (Black, Clear, White)

### CSA International

Loctite® 55™ Pipe Sealing Cord  
 Loctite® 564™ Thread Sealant, General Purpose  
 Loctite® 565™ PST® Thread Sealant, Controlled Strength  
 Loctite® 567™ PST® Thread Sealant, High Temperature  
 Loctite® QuickStix™ 561™ PST® Pipe Sealant

### ISO 10993 Compliant

Loctite® M-11FL™ Hysol® Medical Device Urethane Adhesive  
 Loctite® M-21HP™ Hysol® Medical Device Epoxy Adhesive  
 Loctite® M-31CL™ Hysol® Medical Device Epoxy Adhesive  
 Loctite® M-121HP™ Hysol® Medical Device Epoxy Adhesive  
 Loctite® 713™ Prism® Medical Device Accelerator  
 Loctite® 3201™ Light Cure Adhesive,  
 Polycarbonate / Thermoplastics  
 Loctite® 3211™ Light Cure Adhesive,  
 Polycarbonate / Thermoplastics  
 Loctite® 3301™ Light Cure Adhesive, Plastic / Metal

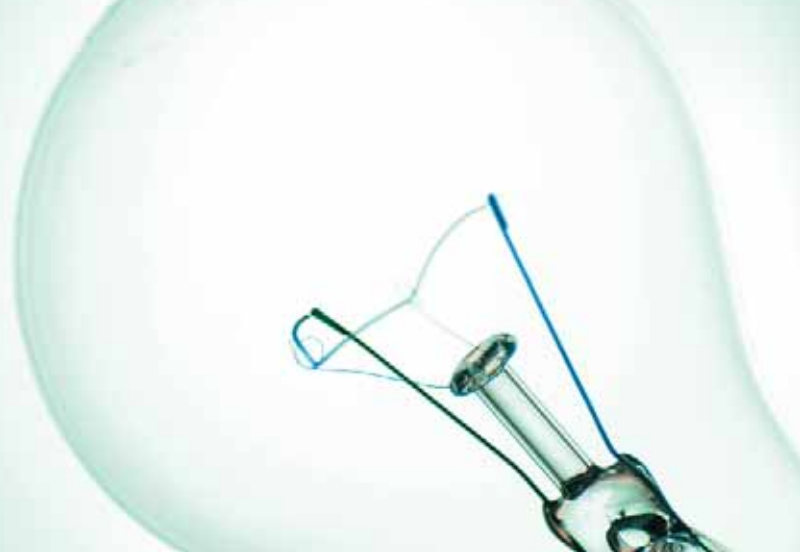
Loctite® 3311™ Light Cure Adhesive, Plastic / Metal  
 Loctite® 3321™ Light Cure Adhesive, Plastic / Metal  
 Loctite® 3341™ Light Cure Adhesive, Plasticized Substrates  
 Loctite® 3345™ Light Cure Adhesive, Glass / Metal  
 Loctite® 3381™ Light Cure Adhesive, Flexible / Plastics  
 Loctite® 3552™ Indigo™ Light Cure Adhesive  
 Loctite® 3553™ Indigo™ Light Cure Adhesive  
 Loctite® 3911™ Light Cure Adhesive  
 Loctite® 3912™ Light Cure Adhesive  
 Loctite® 3913™ Light Cure Adhesive  
 Loctite® 3921™ Light Cure Adhesive, Plastic / Metal  
 Loctite® 3922™ Light Cure Adhesive, Plastic / Metal  
 Loctite® 3924™ Light Cure Adhesive, Plastic / Metal  
 Loctite® 3926™ Light Cure Adhesive, Plastic / Metal  
 Loctite® 3933™ Light Cure Adhesive  
 Loctite® 3936™ Light Cure Adhesive  
 Loctite® 3941™ Light Cure Adhesive,  
 High Performance / Various Substrates  
 Loctite® 3942™ Light Cure Adhesive,  
 High Performance / Various Substrates  
 Loctite® 3943™ Light Cure Adhesive,  
 High Performance / Various Substrates  
 Loctite® 3944™ Light Cure Adhesive  
 Loctite® 3971™ Light Cure Adhesive, Plasticized Substrates  
 Loctite® 3972™ Light Cure Adhesive, Plasticized Substrates  
 Loctite® 3981™ Hysol® Epoxy Adhesive,  
 High Performance / Various Substrates  
 Loctite® 3982™ Hysol® Epoxy Adhesive,  
 High Performance / Various Substrates  
 Loctite® 3984™ Hysol® Epoxy Adhesive,  
 High Performance / Various Substrates  
 Loctite® 4011™ Prism® Medical Device Instant Adhesive  
 Loctite® 4013™ Prism® Medical Device Instant Adhesive  
 Loctite® 4014™ Prism® Medical Device Instant Adhesive  
 Loctite® 4031™ Prism® Medical Device Instant Adhesive  
 Loctite® 4061™ Prism® Medical Device Instant Adhesive  
 Loctite® 4081™ Prism® Medical Device Instant Adhesive  
 Loctite® 4161™ Super Bonder® Medical  
 Device Instant Adhesive  
 Loctite® 4206™ Prism® Medical Device Instant Adhesive  
 Loctite® 4304™ Flashcure® Light Cure Adhesive  
 Loctite® 4305™ Flashcure® Light Cure Adhesive  
 Loctite® 4306™ Flashcure® Light Cure Adhesive, Instant  
 Loctite® 4307™ Flashcure® Light Cure Adhesive, Instant  
 Loctite® 4541™ Prism® Medical Device Instant Adhesive  
 Loctite® 4601™ Prism® Medical Device Instant Adhesive  
 Loctite® 4851™ Prism® Medical Device Instant Adhesive, Flexible  
 Loctite® 4861™ Prism® Medical Device Instant Adhesive, Flexible  
 Loctite® 4981™ Super Bonder® Medical Device Instant Adhesive  
 Loctite® 5248™ Nuva-Sil® Medical Device Silicone Adhesive  
 Loctite® 7451™ Prism® Medical Device Accelerator  
 Loctite® 7701™ Prism® Medical Device Adhesive Primer

### Lloyd's Register Certification

Loctite® Fixmaster® Aluminum Liquid  
 Loctite® Fixmaster® Aluminum Putty  
 Loctite® Fixmaster® Fast Set Steel epoxy  
 Loctite® Fixmaster® Marine Chocking – Orange  
 Loctite® Fixmaster® Marine Chocking – Green  
 Loctite® Fixmaster® Steel Liquid  
 Loctite® Fixmaster® Steel Putty  
 Loctite® Fixmaster® Stainless Steel Putty  
 Loctite® Fixmaster® Superior Metal  
 Loctite® Fixmaster® Wear Resistant Putty  
 Loctite® Nordbak® Pneu-Wear  
 Loctite® Nordbak® Brushable Ceramic – Grey

The information above is an abbreviated list of Loctite® products that hold industry approvals. It is designed to serve as a quick reference tool only and is subject to change. There are other Loctite® brand products that qualify for additional industry approvals that are not promoted in this catalog. Please call Henkel Technical Support at **1-800-LOCTITE** (562-8483) with any inquiries.

# F.A.Q.s



## Durometer Hardness

Durometer hardness is a property presented on technical data sheets that shows how hard the resin is in the cured state. A durometer gauge is the actual measuring device consisting of a small drill or blunt indenter point under pressure. Different measurement scales are used for different materials depending on how soft or hard the material. The following chart compares three (3) different graduated measurement scales and relates hardness values to some common objects as well as Loctite® brand products.

SHORE A	SHORE D	ROCKWELL M	REFERENCE OBJECT	LOCTITE® PRODUCT
30	–	–	Art Gum Eraser	5140™
40	–	–	Pink Pearl Eraser	5900®
50	15	–	Rubber Stamp	–
60	–	–	Pencil Eraser	5699™
70	30	–	Rubber Heel	–
80	–	–	Rubber Sole	–
90	45	–	Typewrite Roller	366™
100	55	–	Pipe Stem	3106™
–	74	0	Textbook Cover	334™
–	78	32	Douglas Fir Plywood	–
–	82	63	–	E-60HP™
–	86	95	Hardwood Desktop	–
–	90	125	Glass or Formica	–

The higher the number within each scale, the harder the material. Shore readings are typically used for plastics. Shore A is for softer materials; Shore D is for harder materials. Rockwell readings are typically used for metals.

## Mathematical Conversions

The following are some common conversions that might be helpful when utilizing Loctite® products:

- 1 milliliter (ml) = 1 cubic centimeter (cc)
- 1,000 ml = 1 liter
- 29.5 ml = 1 fl. oz.
- 3.78 liters = 1 gallon
- 473 ml = 1 pint
- 454 grams = 1 lb.
- 947 ml = 1 quart
- 1 kilogram = 2.2 lbs.
- *Weight to Volume:* grams ÷ specific gravity = cc (ml)
- *Volume to Weight:* cc (ml) x specific gravity = grams
- *Density* = specific gravity x 0.99823
- *Centipoises* = centistokes x density (at a given temp.)
- *Temperature:* degrees F - 32 x 0.556 = degrees C  
degrees C x 1.8 + 32 = degrees F
- Square Inches to Square Feet: ÷ by 144
- Square Feet to Square Inches: x by 144
- In./lbs. ÷ 12 = ft./lbs.
- Ft./lbs. x 12 = in./lbs.
- 16 in. oz. = 1 in. lb.
- 192 in. oz. = 1 ft. lb.

## Area Coverage

### Flat Parts:

Length x Width x Bondline Thickness x 16.4 = cc/ml requirement per part

### Non-threaded Cylindrical Parts:

Diameter x Engagement Length x Bondline Thickness  
(on radius / per side)  
x 3.14 x 16.4 = cc/ml requirement per part

### Potting / Encapsulating Applications:

Area (3.14 x R<sup>2</sup>) x Potting Depth x 16.4 = cc/ml requirement per part

For no induced gap, make the bondline thickness figure 0.001";  
16.4 is a constant for converting cubic inches to cubic centimeters.

## Viscosity

Viscosity is a product property associated with all Loctite® adhesive / sealants. Viscosity is defined as a measure of the resistance of a fluid to flow (usually through a specific orifice). A measure of this fluid “thickness” is expressed in centipoise values. The higher the number, the thicker the product. Thicker products are less flowable, and in most cases, will fill a larger gap if necessary. The following chart relates viscosity to some products we are all familiar with:

PRODUCT	APPROXIMATE VISCOSITY IN CENTIPOISE (cP)	CYANOACRYLATES	ANAEROBICS
Water at 70°C	1 - 5	420™	–
Blood or Kerosene	10	–	290™
Antifreeze or Ethylene Glycol	15	406™	Letter Grade A
Motor Oil SAE 10 or Corn Oil	50 - 100	414™ / 496™	609™
Motor Oil SAE 30 or Maple Syrup	150 - 200	–	675™
Motor Oil SAE 40 or Castor Oil	250 - 500	4203™ / 4471™	640™
Motor Oil SAE 60 or Glycerin	1,000 - 2,000	403™ / 422™	222MS™ / 242™ / 262™
Corn Syrup or Honey	2,000 - 3,000	410™ / 4211™	635™
Blackstrap Molasses	5,000 - 10,000	411™ / 382™	277™ / 620™
Chocolate Syrup	10,000 - 25,000	–	324™ / 326™
Ketchup or Mustard	50,000 - 70,000	409™	330™
Tomato Paste or Peanut Butter	150,000 - 250,000	–	592™
Shortening or Lard	1,000,000 - 2,000,000	–	660™
Caulking Compound	5,000,000 - 10,000,000	–	593™
Window Putty	100,000,000	–	–

Some products are considered thixotropic. This describes materials that are gel-like at rest but fluid when agitated. Ketchup is a good example that exhibits this property. Loctite® products include Loctite® 262™ Threadlocker and Loctite® 509™ Flange Sealant.

## Shelf Life

### What is the Henkel shelf life policy for Loctite® products?

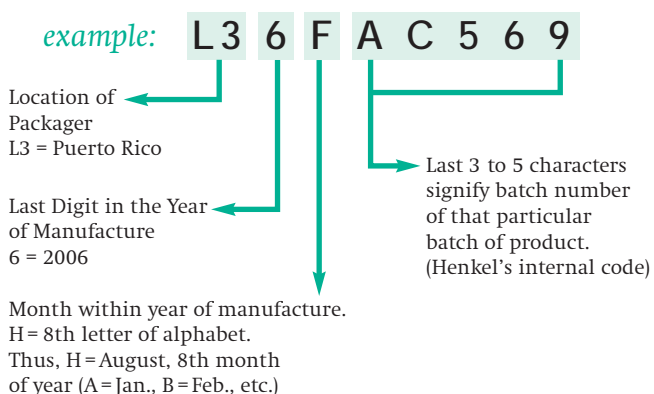
The shelf life period for Loctite® products is one year from date of shipment from Henkel facilities or as indicated by package labeling. For optimal storage, maintain product at a temperature between 8°C (46°F) to 21°C (70°F). Storage below 8°C (46°F) or greater than 28°C (82°F) can adversely affect product properties. Cyanoacrylate products must be stored under refrigerated conditions at 2°C (36°F) to 8°C (46°F). Storage below 2°C (36°F) or greater than 8°C (46°F) can adversely affect product properties. Products requiring storage at conditions other than those specified here are labeled accordingly. Material removed from containers may be contaminated during use. Do not return product to original containers. Henkel cannot assume responsibility for product that has been contaminated or stored under conditions other than as recommended. This policy supersedes all previous policies regarding shelf life and storage of Loctite® products.

### Do the 9 character batch codes on containers signify the date of shipment?

**No...** This code signifies date of manufacture.

Certified shelf life is based on this code only if date of shipment cannot be determined. This is generally two years from date of manufacturing for most products.

### How do you read this 9 character batch code?



### Once a product reaches its “1 year from date of shipment” date, does this mean it can no longer be used?

**No...** Henkel offers a policy for extension of shelf life. Contact Customer Service (800-243-4874) for details.



# Services

## Engineering Services

Henkel Corporation offers complete engineering services for projects demanding expertise and support beyond the limits of our standard technical services. As a result, our engineers and scientists can quote the following value-added services:

- On-site engineering assistance and consultation
- Joint product development programs
- Contract lab services and testing
- Prototype testing and fixture preparation
- Custom formulations

In today's volatile and fluid market landscape, a manufacturer's survival and success are directly related to its technical capability. Rapidly emerging, innovative processes and materials mandate an unprecedented breadth and depth of engineering savvy. Not every company can house the equipment and engineering staff necessary to compete in today's marketplace. The engineering services group of Henkel understands the necessity of partnering with manufacturers and sharing this expertise with the industry through cost-effective, custom-tailored programs.

These programs range from specialized field teams that evaluate specifications and in-line process requirements, to the development of adhesives, and the design, construction and implementation of dispensing and curing systems. Whether you need competent recommendations on chemical properties, or a full-blown, turnkey process line, the engineering services group of Henkel can provide solutions through the seamless integration of mechanical, electrical, industrial manufacturing, and chemical engineering teams.



The Application Engineering Lab plays host to a battery of testing equipment. Here, experienced technicians conduct a multitude of tests, such as detack, surface contamination, deforming, fixture, tensile and peel strengths.

To access these and other Engineering Services, contact our Adhesives and Sealants Specialists at **1-800-LOCTITE** (562-8483).

Immediate technical assistance is available between 8 am to 5 pm EST.



Crucial in the engineering process is determining whether the customer's application and the adhesive criteria can withstand the gauntlet of rigorous strength tests performed by Henkel. Custom test fixtures and protocols can be developed to meet specific end-use requirements.



Engineers specializing in Loctite® products are frequently called upon to provide process simulations of customer parts on short production runs, such as gasketing. Our prototyping capability provides valuable data regarding the feasibility of full-scale manufacture.



Our engineers can also create environmental conditions that simulate, and even exceed, the most severe conditions. With heat aging, salt fog, humidity and thermal cycling chambers, manufacturers can be provided confidence in the durability and longevity of an assembly in the field.

# OEM Training Services

Educate your engineers on how to cut costs, improve quality and increase production through the integration of adhesives into the new product design process. Each instructional event touches on the wide array of Loctite® product solutions including adhesives and sealants, dispensing and curing equipment, as well as the unmatched technical support of our product specialists.



## PRODUCT WORKSHOPS

### LOCTITE® OEM WORKSHOP

Full or half day on-site product training customized to address specific design needs at your client's manufacturing location.

### LOCTITE® OEM CUSTOMER TRAINING SCHOOL

Full or half day off-site training designed specifically for design, product, process, material and manufacturing engineers responsible for assemblies involving the use of adhesives.

## INDUSTRY WORKSHOPS

### DESIGNING PUMPS WITH ADHESIVES SEMINAR

Two- to four-hour training on adhesives, coatings, lubricants and the performance improvements their implementation provides to pump manufacturers.

### DESIGNING ELECTRIC MOTORS WITH ADHESIVES SEMINAR

This half-day seminar reviews in detail the many ways motor manufacturers are using adhesives and sealants to improve performance, reduce costs and enhance manufacturability. The seminar includes many hands-on demonstrations and real world case histories.

### MEDICAL ADVANCED WORKSHOP

A four- to seven-hour off-site program providing solutions to medical device manufacturers on design and assembly challenges. The workshop is designed specifically for product, manufacturing, and design engineers and includes hands-on demonstrations of adhesives and equipment.

### MEDICAL TECHNOLOGY ON-SITE SEMINAR

Select from a menu of seven of the most requested medical device adhesive topics or create a customized seminar to meet your client's specific requirements. Courses are conducted at a client location ("on-site") and include instruction, hands-on demonstrations, samples, and technical guides.

## SERVICES

### PLANT SURVEY

A detailed manufacturing process evaluation performed by a Loctite® Adhesives and Sealants Specialist to identify potential cost savings and process improvements.



# MRO Training Services

All of the following services will teach your maintenance personnel how to save time, reduce costs, improve safety in your plant, and increase the reliability of your equipment.

PRODUCT WORKSHOPS	<p><b>LOCTITE® MAINTENANCE WORKSHOP</b> Two hours of on-site product training customized to your clients' needs. Optional cost documentation process available.</p> <p><b>LOCTITE® PUMP REBUILD WORKSHOP</b> Two to four hours of product training on how Loctite® products can improve pump reliability and reduce common failures. Includes pump rebuild manual.</p> <p><b>LOCTITE® MAINTENANCE CUSTOMER TRAINING SCHOOL</b> Full- or half-day product training with review of common maintenance challenges and the appropriate Loctite® product solutions.</p>
MANUFACTURING RELIABILITY TRAINING	<p><b>MAINTENANCE RELIABILITY TRAINING (MRT)</b> Four hours of CEU accredited training on mechanical basics, failure fundamentals, and the role of machinery adhesives in equipment reliability. Includes training manual and product tool kit.</p> <p><b>MAINTENANCE RELIABILITY TRAINING (MRT) DOCUMENTED</b> Offers the same features and benefits of the Maintenance Reliability Training detailed above and includes Henkel's Cost Documentation Process.</p>
SERVICES	<p><b>ENGINEERING ASSISTANCE</b> Henkel offers many other services including air leak surveys, pump rebuild assistance, and flooring application assistance. In addition, Henkel offers an optional cost documentation process with the MRT programs and Maintenance Workshop listed above.</p>





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## Obsolete Part Number Listing

REMOVED LOCTITE® ITEM		AVAILABLE REPLACEMENT LOCTITE® ITEM	
IDH Number	Product Description	Product Number	Product Description
10320	Loctite® 120042 Retaining Compound		
18659	Loctite® 3091™ Medical Device Light Cure Adhesive		
18870	Loctite® 3091™ Medical Device Light Cure Adhesive		
20282	Loctite® 7453™ Accelerator		
23692	Loctite® 3103™ Light Cure Adhesive	19890	Loctite® 7451™ Prism®
24575	Loctite® Super Lube® Lubricant with PTFE		
29345	Loctite® Hysol® U10-FL Urethane Adhesive		
30288	Loctite® 3335™ Light Cure Adhesive, UV Cationic Epoxy		
30289	Loctite® 3335™ Light Cure Adhesive, UV Cationic Epoxy		
30507	Loctite® Instant Gasket	40479	Loctite® Instant Gasket
30541	Loctite® Superflex® Blue RTV Silicone Adhesive Sealant	40482	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant
30562	Loctite® Superflex® Clear RTV Silicone Adhesive Sealant	40481	Loctite® Superflex® Clear RTV, Silicone Adhesive Sealant
30563	Loctite® Superflex® Black RTV Silicone Adhesive Sealant	40464	Loctite® Superflex® Black RTV, Silicone Adhesive Sealant
30564	Loctite® Superflex® Red High Temp RTV Silicone Adhesive Sealant	40465	Loctite® Superflex® Red High Temp RTV
30567	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	40462	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker
30684	Loctite® Instant Gasket	40478	Loctite® Instant Gasket
31360	Krytox® RFE PFPE Lubricant	31361	Krytox® RFE PFPE Lubricant
34663	Loctite® Chisel® MC-Free Gasket Remover	79040	Loctite® Chisel® Gasket Remover (Methylene Chloride)
36057	Loctite® 3337™ Light Cure Adhesive, UV Cationic Epoxy		
36058	Loctite® 3337™ Light Cure Adhesive, UV Cationic Epoxy		
36646	Loctite® Non-Flammable Contact Cleaner	24379	Loctite® Electrical Contact Cleaner
36906	Loctite® 3340™ Light Cure Adhesive, UV Cationic Epoxy		
36907	Loctite® 3340™ Light Cure Adhesive, UV Cationic Epoxy		
38872	Loctite® ViperLube® High Performance Synthetic Lubricant, Lightweight Oil – 15W		
38873	Loctite® ViperLube® High Performance Synthetic Lubricant, Lightweight Oil – 15W		
38874	Loctite® ViperLube® High Performance Synthetic Lubricant, Lightweight Oil – 15W		
38875	Loctite® ViperLube® High Performance Synthetic Lubricant, Lightweight Oil – 20W		
38876	Loctite® ViperLube® High Performance Synthetic Lubricant, Lightweight Oil – 20W		
38877	Loctite® ViperLube® High Performance Synthetic Lubricant, Lightweight Oil – 20W		
38878	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil – 140W		
38879	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil – 140W		
38880	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil – 140W		
39363	Loctite® ViperLube® Clear High Performance Synthetic Grease		

REMOVED LOCTITE® ITEM		AVAILABLE REPLACEMENT LOCTITE® ITEM	
IDH Number	Product Description	Product Number	Product Description
39716	Loctite® Clover® Reel Sharp – 120 Grit		
39727	Loctite® Clover® Reel Sharp – 150 Grit		
39898	Loctite® Moly Dry Film Lubricant	39897	Loctite® Moly Dry Film Lubricant
40136	Loctite® Fixmaster® Concrete Repair		
40141	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive		
40142	Loctite® Fixmaster® Concrete Repair		
40143	Loctite® Fixmaster® MP Fast Setting Concrete Repair		
40578	Loctite® Under Pressure Pipe Repair Kit		
40579	Loctite® Under Pressure Pipe Repair Kit		
40878	Loctite® H8500™ Speedbonder™		
40959	Loctite® H4720™ Speedbonder™		
40971	Loctite® 3552™ Indigo™ Visible Light Cure Adhesive*	1072199	Loctite® 3552™ Indigo™ Visible Light Cure Adhesive*
40972	Loctite® 3552™ Indigo™ Visible Light Cure Adhesive*	1072198	Loctite® 3552™ Indigo™ Visible Light Cure Adhesive*
40973	Loctite® 3553™ Indigo™ Visible Light Cure Adhesive*	1072223	Loctite® 3553™ Indigo™ Visible Light Cure Adhesive*
40977	Loctite® 3553™ Indigo™ Visible Light Cure Adhesive*	1072222	Loctite® 3553™ Indigo™ Visible Light Cure Adhesive*
40979	Loctite® H4500™ Speedbonder™		
40980	Loctite® H8000™ Speedbonder™		
41378	Loctite® MS930™ Elastic Sealant	1073347	Loctite® 5510™ Adhesive / Sealant
41379	Loctite® MS9360™ Elastic Adhesive	41379	Loctite® 5572™ Adhesive
41380	Loctite® MS939™ Elastic Adhesive	41380	Loctite® 5512™ Adhesive / Sealant
41386	Loctite® MS9360™ Elastic Adhesive	41386	Loctite® 5572™ Adhesive
41387	Loctite® MS939™ Elastic Adhesive	41387	Loctite® 5512™ Adhesive / Sealant
43004	Loctite® 430™ Super Bonder® Instant Adhesive		
43050	Loctite® 430™ Super Bonder® Instant Adhesive		
43061	Loctite® 430™ Super Bonder® Instant Adhesive		
59866	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	40463	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker
61383	Loctite® PP Accelerator		
82338	Loctite® Super Lube® Oil		
82518	Loctite® Superflex® White RTV, Silicone Adhesive Sealant	40466	Loctite® Superflex® White RTV, Silicone Adhesive Sealant
83098	Loctite® 907™ Hysol® Epoxy Adhesive	29329	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder
83107	Loctite® 9412™ Hysol® Epoxy Adhesive	29326	Loctite® E-60NC™ Hysol® Epoxy Adh., Electrically Non-Corrosive
83108	Loctite® 9412™ Hysol® Epoxy Adhesive	29326	Loctite® E-60NC™ Hysol® Epoxy Adh., Electrically Non-Corrosive
83119	Loctite® 9433™ Hysol® Epoxy Adhesive		
83149	Loctite® 9739™ Hysol® Epoxy Adhesive	83105	Loctite® 9340™ Hysol® Epoxy Adhesive High Temperature
83150	Loctite® 9739™ Hysol® Epoxy Adhesive	83105	Loctite® 9340™ Hysol® Epoxy Adhesive High Temperature
83186	Loctite® 11C™ Hysol® Epoxy Adhesive		
83207	Loctite® 1C-LV™ Hysol® Epoxy Adhesive	29335	Loctite® E-20NS™ Hysol® Epoxy Adhesive, Metal Bonder
83208	Loctite® 1C-LV™ Hysol® Epoxy Adhesive	29334	Loctite® E-20NS™ Hysol® Epoxy Adhesive, Metal Bonder
83211	Loctite® 6C™ Hysol® Epoxy Adhesive		
83224	Loctite® 9460F™ Hysol® Epoxy Adhesive		
83225	Loctite® 9460F™ Hysol® Epoxy Adhesive		

\*Available to existing customers

REMOVED LOCTITE® ITEM		AVAILABLE REPLACEMENT LOCTITE® ITEM	
IDH Number	Product Description	Product Number	Product Description
83226	Loctite® 9460F™ Hysol® Epoxy Adhesive		
83227	Loctite® 9460F™ Hysol® Epoxy Adhesive		
83230	Loctite® 9460PB™ Hysol® Epoxy Adhesive		
83231	Loctite® 9460PB™ Hysol® Epoxy Adhesive		
83232	Loctite® 9460PB™ Hysol® Epoxy Adhesive		
83233	Loctite® 9460PB™ Hysol® Epoxy Adhesive		
83237	Loctite® 0232™ Hysol® Hot Melt Adhesive, EVA Based		
83244	Loctite® 0232™ Hysol® Hot Melt Adhesive, EVA Based		
83246	Loctite® 0232™ Hysol® Hot Melt Adhesive, EVA Based		
83251	Loctite® 236™ Hysol® Hot Melt Adhesive, EVA Based		
83263	Loctite® 740™ Hysol® Hot Melt Adhesive, EVA Based		
83268	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based		
83273	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based		
83276	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based		
83283	Loctite® 6002™ Hysol® Hot Melt Adhesive		
83329	Loctite® 7804™ Hysol® Hot Melt Adhesive		
83343	Loctite® 7901™ Hysol® Hot Melt Adhesive, Polyamide		
83346	Loctite® 0420™ Hysol® SprayPac™ Polyshot™ Hot Melt Adh.		
83348	Loctite® 0430™ Hysol® SprayPac™ Polyshot™ Hot Melt Adh.		
83350	Loctite® 0430™ Hysol® SprayPac™ Polyshot™ Hot Melt Adh.		
83355	Loctite® 0450™ Hysol® SprayPac™ Polyshot™ Hot Melt Adh.		
83359	Loctite® 1X™ Hysol® Hot Melt Adhesive, EVA Based		
83362	Loctite® 1X™ Hysol® Hot Melt Adhesive, EVA Based		
83364	Loctite® 1X™ Hysol® Hot Melt Adhesive, EVA Based		
83367	Loctite® 1X™ Hysol® Hot Melt Adhesive, EVA Based		
83374	Loctite® 740LV™ Hysol® Hot Melt Adhesive, EVA Based		
83383	Loctite® 7804FRM-HV™ Hysol® Hot Melt Adhesive		
83386	Loctite® 7804FRM-HV™ Hysol® Hot Melt Adhesive		
83390	Loctite® 7809FR™ Hysol® Hot Melt Adhesive, Polyamide		
83391	Loctite® 7809FR™ Hysol® Hot Melt Adhesive, Polyamide		
83399	Loctite® Hysol® QuikPac™ Hot Melt Adhesive, EVA Based		
83402	Loctite® Hysol® SuperPac™ Hot Melt Adhesive, EVA Based		
83408	Loctite® Hysol® WaxPac™ Hot Melt Adhesive, EVA Based		
83410	Loctite® Hysol® WaxPac™ Hot Melt Adhesive, EVA Based		
83653	Loctite® 9437™ Hysol® Epoxy Adhesive		
83668	Loctite® 9437™ Hysol® Epoxy Adhesive		
98029	Loctite® Hysol™ 050-LITE Hot Melt Applicator	916281	Loctite® Hysol™ 050-LITE Hot Melt Applicator
98032	Loctite® Hysol™ 050-GAS Hot Melt Applicator	916268	Loctite® Hysol™ 050-GAS Hot Melt Applicator
39951	Loctite® Hysol® 3142™ Epoxy Resin, 5 Gallon Pail	39950	Loctite® Hysol® 3142™ Epoxy Resin
39965	Loctite® Hysol® 3163™ Epoxy Hardener, 1 Gallon Can	39964	Loctite® Hysol® 3163™ Epoxy Hardener
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E-220IC	Loctite® E-220IC™ Hysol® Epoxy Adhesive	20, 21	268	Loctite® QuickStix™ 268™ Threadlocker, High Strength	111, 113
E-30CL	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder	26, 27	271	Loctite® 271™ Threadlocker, High Strength	111, 113
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E-40HT	Loctite® E-40HT™ Hysol® Epoxy Adhesive	28, 29	290	Loctite® 290™ Threadlocker, Wicking Grade	112, 113
E-50CR	Loctite® E-50CR™ Hysol® Epoxy Adhesive	28, 29	294	Loctite® 294™ Threadlocker, Wicking Grade/High Temperature	112, 113
E-50GW	Loctite® E-50GW™ Hysol® Epoxy Adhesive	23, 24	312	Loctite® 312™ Speedbonder™ Structural Adhesive	20, 21
E-60HP	Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened	22, 24, 28, 29	324	Loctite® 324™ Speedbonder™ Structural Adhesive, High Impact	28, 29
E-60NC	Loctite® E-60NC™ Hysol® Epoxy Adhesive, Electrically Non-Corrosive	27	325	Loctite® 325™ Speedbonder™ Structural Adhesive, High Temperature	20, 21
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U-09LV	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	27	352	Loctite® 352™ Light Cure Adhesive	13, 15
D609	Loctite® D609™ Hysol® Epoxy Adhesive, Ultra Clear	27	363	Loctite® 363™ Impruv® Light Cure Adhesive	15
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H4100	Loctite® H4100™ Speedbonder™ Structural Adhesive, Ultra Fast	30, 32	403	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	4, 6
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H4500	Loctite® H4500™ Speedbonder™ Structural Adhesive	22, 24	406	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	4, 6
H4710	Loctite® H4710™ Speedbonder™ Structural Adhesive	22, 24	408	Loctite® 408™ Prism® Instant Adhesive, Low Odor/Low Bloom	6
H4720	Loctite® H4720™ Speedbonder™ Structural Adhesive	22, 24	409	Loctite® 409™ Super Bonder® Instant Adhesive, Industrial Grade Gel	7
H4800	Loctite® H4800™ Speedbonder™ Structural Adhesive, Toughened	30, 32	410	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	6
H6051	Loctite® H6051™ Speedbonder™ Structural Adhesive	30, 32	411	Loctite® 411™ Prism® Instant Adhesive, Clear/Toughened	4, 6
H8000	Loctite® H8000™ Speedbonder™ Structural Adhesive, Fast Fixture	23, 24	414	Loctite® 414™ Super Bonder® Instant Adhesive	7
H8010	Loctite® H8010™ Speedbonder™ Structural Adhesive, Fast Fixture	23, 24	415	Loctite® 415™ Super Bonder® Instant Adhesive	7
H8100	Loctite® H8100™ Speedbonder™ Structural Adhesive	24	416	Loctite® 416™ Super Bonder® Instant Adhesive	7
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H8610	Loctite® H8610™ Speedbonder™ Structural Adhesive	23, 24	426	Loctite® 426™ Prism® Instant Adhesive, Black/Toughened Gel	4, 6
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0232	Loctite® 0232™ Hysol® Hot Melt Adhesive, EVA Based	9, 11	454	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	4, 6
03333	Loctite® 312™ Speedbonder™ Structural Adhesive	20, 21	455	Loctite® 455™ Prism® Instant Adhesive Gel, Low Odor/Low Bloom	4, 6
0430	Loctite® 0430™ Hysol® SprayPac™ Polyshot™ Hot Melt Adhesive, EVA Based	8, 10	460	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	6
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1C	Loctite® 1C™ Hysol® Epoxy Adhesive	28, 29	496	Loctite® 496™ Super Bonder® Instant Adhesive	7
1X	Loctite® 1X™ Hysol® Hot Melt Adhesive, EVA Based	9, 11	498	Loctite® 498™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant	5, 7
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ITEM/PART NUMBER	PRODUCT DESCRIPTION	PAGE NUMBER	ITEM/PART NUMBER	PRODUCT DESCRIPTION	PAGE NUMBER
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36334	Loctite® Magna-Crete Activator	50	38584	Loctite® C5-A® Copper Based Anti-Seize Lubricant	66, 68, 69
36390	Loctite® 363™ Impruv® Light Cure Adhesive	15	38588	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	27
36437	Loctite® 3941™ Light Cure Adhesive, High Performance/Various Substrates	124, 125	38589	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	27
36476	Loctite® 3941™ Light Cure Adhesive, High Performance/Various Substrates	124, 125	38590	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	27
36478	Loctite® 3943™ Light Cure Adhesive, High Performance/Various Substrates	124, 125	38591	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	27
36480	Loctite® 3943™ Light Cure Adhesive, High Performance/Various Substrates	124, 125	38760	Loctite® H8600™ Speedbonder™ Structural Adhesive	23, 24
36481	Loctite® 3942™ Light Cure Adhesive, High Performance/Various Substrates	124, 125	38761	Loctite® H8600™ Speedbonder™ Structural Adhesive	23, 24
36483	Loctite® 3942™ Light Cure Adhesive, High Performance/Various Substrates	124, 125	38762	Loctite® H8600™ Speedbonder™ Structural Adhesive	23, 24
36484	Loctite® 3921™ Light Cure Adhesive, Plastic/Metal	124, 125	38956	Loctite® Toolbox	120, 121
36485	Loctite® 3921™ Light Cure Adhesive, Plastic/Metal	124, 125	39011	Loctite® H4720™ Speedbonder™ Structural Adhesive	22, 24
36488	Loctite® 3924™ Light Cure Adhesive, Plastic/Metal	124, 125	39036	Loctite® 55™ Pipe Sealing Cord	117, 118
36489	Loctite® 3924™ Light Cure Adhesive, Plastic/Metal	124, 125	39062	Loctite® Reliability Tacklebox	120, 121
36492	Loctite® 3926™ Light Cure Adhesive, Plastic/Metal	124, 125	39088	Loctite® Fixmaster® Fast Cure Epoxy, Mixer Cups	91, 92, 93
36493	Loctite® 3926™ Light Cure Adhesive, Plastic/Metal	124, 125	39136	Loctite® Fixmaster® Marine Chocking	49, 50, 51
36536	Loctite® 3911™ Light Cure Adhesive	125	39146	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73
36537	Loctite® 3911™ Light Cure Adhesive	125	39147	Loctite® QuickStix™ 668™ Retaining Compound, High Temperature	96, 98
36539	Loctite® 3912™ Light Cure Adhesive	125	39148	Loctite® QuickStix™ 668™ Retaining Compound, High Temperature	96, 98
36540	Loctite® 3912™ Light Cure Adhesive	125	39149	Loctite® QuickStix™ 668™ Retaining Compound, High Temperature	96, 98
36631	Loctite® 366™ Light Cure Adhesive	15	39151	Loctite® QuickStix™ 548™ Gasket Eliminator®	54, 56, 57
36766	Loctite® 3981™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	28, 29, 128, 129	39152	Loctite® QuickStix™ 548™ Gasket Eliminator®	54, 56, 57
36767	Loctite® 3982™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	30, 32, 128, 129	39153	Loctite® QuickStix™ 548™ Gasket Eliminator®	54, 56, 57
36768	Loctite® 3984™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	23, 24, 28, 128, 129	39155	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	55, 56, 57
36780	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39156	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	55, 56, 57
36781	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39157	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	55, 56, 57
36782	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39186	Loctite® 220™ Threadlocker, Wicking Grade/Low Strength	112, 113
36783	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39202	Loctite® QuickTite® Instant Adhesive	7
36784	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39222	Loctite® QuickStix™ C5-A® Copper Based Anti-Seize Lubricant	66, 68, 69
36786	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39223	Loctite® QuickStix™ Silver Grade Anti-Seize	66, 68, 69
36788	Loctite® ViperLube® High Performance Synthetic Lubricant	70, 72, 73	39250	Loctite® 392™ Structural Adhesive, Fast Fixture/Magnet Bonder	20, 21
36789	Loctite® ViperLube® High Performance Synthetic Lubricant	70, 72, 73	39275	Loctite® 392™ Structural Adhesive, Fast Fixture/Magnet Bonder	20, 21
36791	Loctite® 3913™ Light Cure Adhesive	125	39280	Loctite® 392™ Structural Adhesive, Fast Fixture/Magnet Bonder	20, 21
36792	Loctite® 3971™ Light Cure Adhesive, Plasticized Substrates	124, 125	39317	Loctite® H4710™ Speedbonder™ Structural Adhesive	22, 24
36804	Loctite® 3913™ Light Cure Adhesive	125	39341	Loctite® ViperLube® Clear High Performance Synthetic Grease	70, 72, 73
36805	Loctite® 3971™ Light Cure Adhesive, Plasticized Substrates	124, 125	39342	Loctite® ViperLube® Clear High Performance Synthetic Grease	70, 72, 73
36923	Loctite® 5905™ Flange Sealant, RTV Silicone	60, 62, 63	39364	Loctite® ViperLube® Clear High Performance Synthetic Grease	70, 72, 73
37061	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39366	Loctite® Fixmaster® Concrete Repair	48, 50, 51, 90, 92, 93
37087	Loctite® QuickStix™ 248™ Threadlocker – Medium Strength	110, 113	39395	Loctite® 3165™ Hysol® Epoxy Hardener, Low Shrinkage	80, 82, 83
37127	Loctite® QuickStix™ 561™ PST® Pipe Sealant	117, 118	39397	Loctite® 3184™ Hysol® Polyurethane Hardener, Flame Retardant	80, 81
37229	Loctite® QuickStix™ C5-A® Copper Based Anti-Seize Lubricant	66, 68, 69	39398	Loctite® 3184™ Hysol® Polyurethane Hardener, Flame Retardant	80, 81
37230	Loctite® QuickStix™ Silver Grade Anti-Seize	66, 68, 69	39401	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37297	Loctite® 3981™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	28, 29, 128, 129	39404	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37298	Loctite® 3982™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	30, 32, 128, 129	39406	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
37299	Loctite® 3984™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	23, 24, 28, 128, 129	39413	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37312	Loctite® Maximum Strength Headliner Adhesive	18, 19	39418	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
37316	Loctite® Fixmaster® Marine Chocking	49, 50, 51	39419	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
37388	Loctite® 220™ Threadlocker, Wicking Grade/Low Strength	112, 113	39426	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37439	Loctite® 4306™ Flashcure® Light Cure Adhesive	5, 6, 12, 14, 126, 127	39428	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37441	Loctite® 4307™ Flashcure® Light Cure Adhesive	5, 6, 12, 14, 126, 127	39431	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
37442	Loctite® 4306™ Flashcure® Light Cure Adhesive	5, 6, 12, 14, 126, 127	39439	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37443	Loctite® 4307™ Flashcure® Light Cure Adhesive	5, 6, 12, 14, 126, 127	39441	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37535	Loctite® Dielectric Grease	71, 73	39444	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
37684	Loctite® QuickStix™ 248™ Threadlocker – Medium Strength	110, 113	39452	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37685	Loctite® QuickStix™ 268™ Threadlocker – High Strength	111, 113	39455	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37686	Loctite® QuickStix™ 268™ Threadlocker – High Strength	111, 113	39457	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
37708	Loctite® 4861™ Prism® Instant Adhesive, Flexible	5, 6, 126, 127	39458	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
37710	Loctite® ViperLube® High Performance Synthetic Grease	70, 72, 73	39463	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37711	Loctite® 4861™ Prism® Instant Adhesive, Flexible	5, 6, 126, 127	39465	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
37719	Loctite® Fixmaster® Instant Belt Repair	88, 89	39466	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
			39468	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
			39473	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
			39476	Loctite® Clover® Silicon Carbide Grease Mix	76, 77
			39478	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
			39479	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77
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39488	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40347	Loctite® Fixmaster® Flexible Joint Sealant	48, 50, 51
39499	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40352	Loctite® Big Foot® Low Profile Pedestrian Grade	46, 47
39504	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40361	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	4, 6
39510	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40404	Loctite® 5040™ RTV Silicone	84, 85
39512	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40405	Loctite® 5040™ RTV Silicone	84, 85
39515	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40407	Loctite® 5040™ RTV Silicone	84, 85
39523	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40408	Loctite® 5045™ Flange Sealant	60, 62
39528	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40409	Loctite® 5045™ Flange Sealant	60, 62
39536	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40438	Loctite® 5039™ Nuva-Sil® Silicone Adhesive Sealant	12, 14, 60, 62
39541	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40439	Loctite® 5039™ Nuva-Sil® Silicone Adhesive Sealant	12, 14, 60, 62
39542	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40462	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	61, 63
39549	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40463	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	61, 63
39551	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40464	Loctite® Superflex® Black RTV, Silicone Adhesive Sealant	61, 63
39554	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40465	Loctite® Superflex® Red High Temp RTV	61, 63
39561	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40466	Loctite® Superflex® White RTV, Silicone Adhesive Sealant	61, 63
39566	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40478	Loctite® Instant Gasket	61, 63
39574	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40479	Loctite® Instant Gasket	61, 63
39579	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40481	Loctite® Superflex® Clear RTV, Silicone Adhesive Sealant	61, 63
39587	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40482	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	61, 63
39589	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40488	Loctite® O-Ring Making Kit	120, 121
39590	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40505	Loctite® 5699™ Grey, High Performance RTV Silicone Gasket Maker	61, 62, 63
39592	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	76, 77	40511	Loctite® 3145™ Hysol® Epoxy Resin, Flame Retardant	80, 83
39598	Loctite® Clover® Duplex Packaging	76, 77	40512	Loctite® 3145™ Hysol® Epoxy Resin, Flame Retardant	80, 83
39633	Loctite® Fixmaster® Rapid Rubber Repair Static Mixers	89	40515	Loctite® 5905™ Flange Sealant, RTV Silicone	60, 62, 63
39635	Loctite® Fixmaster® Rapid Rubber Repair Dispenser	88, 89, 132	40590	Loctite® Nordbak® Brushable Ceramic	41, 42, 43
39636	Loctite® Fixmaster® Flex™ Cleaner	88	40591	Loctite® Nordbak® Brushable Ceramic	41, 42, 43
39637	Loctite® Fixmaster® Fast Set Grout	48, 50, 51	40592	Loctite® Nordbak® Brushable Ceramic	41, 42, 43
39643	Loctite® C5-A® Copper Based Anti-Seize Lubricant	66, 68, 69	40594	Loctite® H8010™ Speedbonder™ Structural Adhesive, Fast Fixture	23, 24
39711	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40604	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	4, 6
39712	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40640	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	4, 6
39715	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40661	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	4, 6
39723	Loctite® Clover® Silicon Carbide Grease Mix	76, 77	40724	Loctite® 5045™ Flange Sealant	60, 62
39893	Loctite® C-200® High Temperature Solid Film Lubricant	71, 73	40760	Loctite® 3032™ Structural Adhesive	31, 32
39894	Loctite® C-200® High Temperature Solid Film Lubricant	71, 73	40792	Loctite® 3355™ Light Cure Adhesive, Pre-Activated Epoxy	12, 14
39895	Loctite® Moly Dry Film Lubricant	71, 73	40793	Loctite® 3355™ Light Cure Adhesive, Pre-Activated Epoxy	12, 14
39896	Loctite® Moly Dry Film Lubricant	71, 73	40840	Loctite® 408™ Prism® Instant Adhesive, Low Odor/Low Bloom	6
39897	Loctite® Moly Dry Film Lubricant	71, 73	40861	Loctite® 408™ Prism® Instant Adhesive, Low Odor/Low Bloom	6
39901	Loctite® Zinc Anti-Seize	67, 68, 69	40870	Loctite® 3985™ Hysol® Epoxy Adhesive, Non-Sag	28, 29
39904	Loctite® Thread Sealing Tape with PTFE	117, 118	40875	Loctite® H8600™ Speedbonder™ Structural Adhesive	23, 24
39915	Loctite® Big Foot® Zero V.O.C.	46, 47	40884	Loctite® H8500™ Speedbonder™ Structural Adhesive	23, 24
39916	Loctite® Urethane Sealant	61, 63	40888	Loctite® H8500™ Speedbonder™ Structural Adhesive	23, 24
39917	Loctite® Fixmaster® Fast Set Steel Putty	90, 92, 93	40889	Loctite® H8500™ Speedbonder™ Structural Adhesive	23, 24
39918	Loctite® Nordbak® High Impact Wearing Compound	41, 42, 43	40900	Loctite® Fixmaster® Superior Metal	90, 92, 93
39944	Loctite® 3140™ Hysol® Epoxy Resin, General Purpose	80, 82	40904	Loctite® 409™ Super Bonder® Instant Adhesive Gel, Industrial Grade	7
39945	Loctite® 3140™ Hysol® Epoxy Resin, General Purpose	80, 82	40945	Loctite® 409™ Super Bonder® Instant Adhesive Gel, Industrial Grade	7
39947	Loctite® 3141™ Hysol® Epoxy Resin, High Temperature	80, 82	40969	Loctite® 5905™ Flange Sealant, RTV Silicone	60, 62, 63
39948	Loctite® 3141™ Hysol® Epoxy Resin, High Temperature	80, 82	40974	Loctite® 409™ Super Bonder® Instant Adhesive Gel, Industrial Grade	7
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39958	Loctite® 3160™ Hysol® Epoxy Hardener, Glossy Surface Finish	80, 82, 83	40995	Loctite® 435™ Prism® Instant Adhesive	5, 6, 126, 127
39960	Loctite® 3162™ Hysol® Epoxy Hardener, Fast Cure	80, 82, 83	40996	Loctite® 438™ Prism® Instant Adhesive	6
39962	Loctite® 3162™ Hysol® Epoxy Hardener, Fast Cure	80, 82, 83	40997	Loctite® 438™ Prism® Instant Adhesive	6
39964	Loctite® 3163™ Hysol® Epoxy Hardener, Excellent Adhesion	80, 82, 83	41004	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	6
39966	Loctite® 3163™ Hysol® Epoxy Hardener, Excellent Adhesion	80, 82, 83	41005	Loctite® 435™ Prism® Instant Adhesive	5, 6, 126, 127
39969	Loctite® 3164™ Hysol® Epoxy Hardener, General Purpose	80, 82, 83	41006	Loctite® 438™ Prism® Instant Adhesive	6
39970	Loctite® 3164™ Hysol® Epoxy Hardener, General Purpose	80, 82, 83	41045	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	6
39973	Loctite® 3165™ Hysol® Epoxy Hardener, Low Shrinkage	80, 82, 83	41061	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	6
39984	Loctite® 3173™ Hysol® Polyurethane Resin, General Purpose	80, 81	41104	Loctite® 411™ Prism® Instant Adhesive, Clear Toughened	4, 6
39985	Loctite® 3173™ Hysol® Polyurethane Resin, General Purpose	80, 81	41145	Loctite® 411™ Prism® Instant Adhesive, Clear Toughened	4, 6
39986	Loctite® 3173™ Hysol® Polyurethane Resin, General Purpose	80, 81	41161	Loctite® 411™ Prism® Instant Adhesive, Clear Toughened	4, 6
39995	Loctite® 3182™ Hysol® Polyurethane Hardener, Fast Cure	80, 81	41205	Loctite® QuickStix™ Heavy Duty Anti-Seize	67, 68, 69
39996	Loctite® 3182™ Hysol® Polyurethane Hardener, Fast Cure	80, 81	41254	Loctite® 431™ Prism® Instant Adhesive	4, 6, 126, 127
39997	Loctite® 3182™ Hysol® Polyurethane Hardener, Fast Cure	80, 81	41255	Loctite® 431™ Prism® Instant Adhesive	4, 6, 126, 127
39998	Loctite® 3183™ Hysol® Polyurethane Hardener, General Purpose	80, 81	41256	Loctite® 431™ Prism® Instant Adhesive	4, 6, 126, 127
39999	Loctite® 3183™ Hysol® Polyurethane Hardener, General Purpose	80, 81	41327	Loctite® 5600™ Adhesive Sealant	60, 62
40086	Loctite® 5031™ Nuva-Sil® Silicone Potting Compound	12, 14, 84, 85	41330	Loctite® H8510™ Speedbonder™ Structural Adhesive	23, 24
40087	Loctite® 5031™ Nuva-Sil® Silicone Potting Compound	12, 14, 84, 85	41343	Loctite® Nordbak® Low Odor Wearing Compound	40, 42, 43
40088	Loctite® 5033™ Nuva-Sil® Silicone Adhesive Sealant	12, 14	41379	Loctite® 5572™ Adhesive	16, 17, 58, 59
40089	Loctite® 5033™ Nuva-Sil® Silicone Adhesive Sealant	12, 14	41380	Loctite® 5512™ Adhesive Sealant	16, 17, 58, 59
40104	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive	4, 6	41386	Loctite® 5572™ Adhesive	16, 17, 58, 59
40140	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive	4, 6	41387	Loctite® 5512™ Adhesive Sealant	16, 17, 58, 59
40161	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive	4, 6	41404	Loctite® 414™ Super Bonder® Instant Adhesive	7
40270	Loctite® Fixmaster® Magna-Crete Winter Additive	48, 50	41450	Loctite® 414™ Super Bonder® Instant Adhesive	7
40271	Loctite® Fixmaster® Magna-Crete Summer Additive	48, 50	41461	Loctite® 414™ Super Bonder® Instant Adhesive	7
40302	Loctite® Big Foot® Heavy Duty Pedestrian Grade	46, 47	41550	Loctite® 415™ Super Bonder® Instant Adhesive	7
40303	Loctite® Big Foot® Heavy Duty Pedestrian Grade	46, 47	41561	Loctite® 415™ Super Bonder® Instant Adhesive	7
40304	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	4, 6	41650	Loctite® 416™ Super Bonder® Instant Adhesive	7
40340	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	4, 6	41661	Loctite® 416™ Super Bonder® Instant Adhesive	7

Items listed in **RED** are **TOP CHOICE** Selections

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41732	Loctite® 5600™ Adhesive Sealant	60, 62	51272	Loctite® N-7000™ High Purity Anti-Seize	67, 68, 69
42050	Loctite® 420™ Super Bonder® Instant Adhesive	7	51273	Loctite® N-7000™ High Purity Anti-Seize	67, 68, 69
42061	Loctite® 420™ Super Bonder® Instant Adhesive	7	51277	Loctite® C5-A® Copper Based Anti-Seize Lubricant	66, 68, 69
42250	Loctite® 422™ Super Bonder® Instant Adhesive	7	51286	Loctite® Nickel Anti-Seize	66, 68, 69
42261	Loctite® 422™ Super Bonder® Instant Adhesive	7	51299	Loctite® C5-A® Copper Based Anti-Seize Lubricant	66, 68, 69
42540	Loctite® 425™ Assure™ Instant Adhesive, Surface Curing Threadlocker	112, 113	51346	Loctite® N-5000™ High Purity Anti-Seize	67, 68, 69
42561	Loctite® 425™ Assure™ Instant Adhesive, Surface Curing Threadlocker	112, 113	51360	Loctite® Silicone Lubricant	70, 73
43004	Loctite® 430™ Super Bonder® Instant Adhesive	7	51387	Loctite® Superflex® Non-Corrosive RTV, Clear Silicone Adhesive Sealant	61, 63
43050	Loctite® 430™ Super Bonder® Instant Adhesive	7	51388	Loctite® Superflex® Non-Corrosive RTV, Clear Silicone Adhesive Sealant	61, 63
43061	Loctite® 430™ Super Bonder® Instant Adhesive	7	51517	Loctite® 515™ Gasket Eliminator® Flange Sealant	54, 56, 57
45404	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	4, 6	51531	Loctite® 515™ Gasket Eliminator® Flange Sealant	54, 56, 57
45440	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	4, 6	51572	Loctite® High Performance N-5000™ High Purity Anti-Seize	67, 68, 69
45474	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	4, 6	51580	Loctite® 515™ Gasket Eliminator® Flange Sealant	54, 56, 57
45478	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	4, 6	51604	Loctite® Tight®, Multipurpose Anaerobic Gel	113, 114, 117, 118
46004	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	6	51605	Loctite® Heavy Duty Anti-Seize	67, 68, 69
46040	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	6	51606	Loctite® Heavy Duty Anti-Seize	67, 68, 69
46061	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	6	51607	Loctite® Heavy Duty Anti-Seize	67, 68, 69
46548	Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose	5, 7	51608	Loctite® Heavy Duty Anti-Seize	67, 68, 69
46551	Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose	5, 7	51609	Loctite® Heavy Duty Anti-Seize	67, 68, 69
46561	Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose	5, 7	51642	Loctite® Tight®, Multipurpose Anaerobic Gel	113, 114, 117, 118
48040	Loctite® 480™ Prism® Instant Adhesive, Black/Toughened	6	51817	Loctite® 518™ Gasket Eliminator® Flange Sealant	54, 56, 57
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49350	Loctite® 493™ Super Bonder® Instant Adhesive	7	51845	Loctite® 518™ Gasket Eliminator® Flange Sealant	54, 56, 57
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*A Quick Reference Guide to the Most Common Maintenance Problems*

PROBLEM	SOLUTION
Rust, corrosion, galling, or seizing on metal threaded and unthreaded assemblies	Anti-Seize Compounds
Slippery pedestrian/vehicular areas	Anti-Slip Coatings
Damaged conveyor belts	Belt Repair/Urethanes
Fastening and joining	Bonding – Acrylic, Cyanoacrylate, Epoxy & Urethane, Hot Melt
Worn surfaces/damaged parts	Epoxies
Cracked floors, restoring old concrete, bonding to concrete/set anchor bolts, mount equipment	Flooring & Grout
Leaks – gasket, oil, transmission, coolant	Gasketing & Sealing
Friction, heat, or wear between solid metal surfaces	Lubricants
Backlash, key wallowing, spun bearings, shaft alignment, wear	Retaining Compounds
Vibrational loosening	Threadlocking
Leaks – air, hydraulic, fouled valves	Thread Sealing
Worn or corroded surfaces – material handling equipment	Wearing Compounds



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