



LOCTITE®



**the
adhesive
sourcebook**

volume 5

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



Acrylic Adhesives

Cyanoacrylate Adhesives

Epoxy Adhesives

Urethane Adhesives

Fiber Optic Adhesives

Hot Melt Adhesives

Light Cure Adhesives

Anaerobic Gasketing

Silicone Gasketing

Potting Compounds

Encapsulating Compounds

Retaining Compounds

Surface Preparation

Threadlockers

Thread Sealants

Medical Adhesives

Anti-Seize

Anti-Slip Coatings

Belt Repair/Urethanes

Cleaners

Coatings

Repair Epoxies

Flooring & Grouting

Lubricants

Machining Compounds

Wearing Compounds

Special Products

Dispensing Equipment

Curing Equipment

Custom Equipment



Henkel

The Adhesive Sourcebook

The complete source on Loctite® brand 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® brand products will help you tackle the toughest challenges the world can throw your way.

Organized into four major categories:

- Assembly Products – For virtually any industrial application
- Medical Products – Distinctive line for medical device assemblies
- Maintenance & Repair – Wide range of products for maintenance, repair and operational needs
- Equipment – Adhesive dispensing and curing systems

Throughout *The Adhesive Sourcebook*, easy-to-use product selection guides will help you narrow the search for the right solution to your design, assembly, maintenance, or repair requirements.

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

In addition to support from your local Henkel representative, *The Adhesive Sourcebook* is also supported by 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:

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 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 available.

WHAT'S NEW

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

At Henkel Corporation, we invent more than just quality Loctite® brand products, we provide solutions to the industries' 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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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® 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® 587™ Blue, High Performance RTV Silicone Gasket Maker
Loctite® 680™ Retaining Compound, Slip Fit/High Strength
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone
Loctite® 7649™ Primer N™
Loctite® Food Grade Anti-Seize
Loctite® Food Grade Grease
Loctite® No More Leaks™, Plastic Pipe Sealant
Loctite® ODC-Free Cleaner & Degreaser
Loctite® Superflex® RTV, Silicone Adhesive Sealants (Black, Clear, White)
Loctite® ViperLube® Clear High Performance Synthetic Grease
Loctite® ViperLube® High Performance Synthetic Grease
Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oils
Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oils

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 Comp., Slip Fit/High Strength
Loctite® Extend® Rust Treatment
Loctite® Fixmaster® Aluminum Liquid
Loctite® Fixmaster® Aluminum Putty
Loctite® Fixmaster® Poxypak™, 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

Canadian Food Inspection Agency (CFIA)

Loctite® E-00CL™ Hysol® Epoxy Adhesive, Fast Setting
Loctite® E-00NS™ Hysol® Epoxy Adhesive, Non-Sag
Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened
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® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength
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® 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, Hydraulic/Pneumatic Fittings
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® 587™ Blue, High Performance RTV Silicone Gasket Maker
Loctite® 592™ PST® Thread Sealant, Slow Cure
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, Controlled Strength
Loctite® 660™ Quick Metal® Retaining Compound, Press Fit Repair
Loctite® 712™ Tak Pak® Accelerator
Loctite® 770™ Prism® Primer
Loctite® 2760™ Threadlocker, Primerless/High Strength
Loctite® 4210™ Prism® Instant Adhesive, Thermal Resistant
Loctite® 4212™ Prism® Instant Adhesive, Thermal Resistant Gel
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone
Loctite® 7649™ Primer N™
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® Black Contact Adhesive
Loctite® QuickStix™ C5-A® Copper Based Anti-Seize
Loctite® Cold Galvanizing Compound
Loctite® Color Guard®, Tough Rubber Coating
Loctite® Contact Adhesive
Loctite® Extend® Rust Treatment
Loctite® Fixmaster® Aluminum Liquid
Loctite® Fixmaster® Aluminum Putty
Loctite® Fixmaster® Deep Pour Grout
Loctite® Fixmaster® Fast Cure Epoxy, Mixer Cups
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® Fixmaster® Poxypak™, Fast Cure Epoxy
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® Form-A-Thread® Stripped Thread Repair Kit
Loctite® Gasket Sealant 1
Loctite® H.V.A.C. Blue Pipe Joint Compound
Loctite® High Temperature Gasket Maker
Loctite® Instant Gasket
Loctite® No More Leaks™, Plastic Pipe Sealant
Loctite® O-Ring Making Kit
Loctite® Pipe Repair Kit
Loctite® Silver Grade Anti-Seize
Loctite® QuickStix™ Silver Grade Anti-Seize

Loctite® Solvo-Rust® Super Penetrating Oil
 Loctite® Superflex® RTV, Silicone Adhesive Sealants (Black, Clear, White)
 Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant
 Loctite® Thread Sealant with PTFE
 Loctite® Urethane Sealant
 Loctite® ViperLube® High Performance Synthetic Grease
 Loctite® ViperLube® High Performance Synthetic Grease-Aerosol
 Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oils
 Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oils

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 Temp.
 Loctite® 675™ Retaining Compound, Press Fit/Medium Strength
 Loctite® 712™ Tak Pak® Accelerator
 Loctite® 7452™ Tak Pak® Accelerator
 Loctite® 7471™ Primer T™
 Loctite® 7649™ Primer N™
 Loctite® C5-A® Copper Based Anti-Seize Lubricant
 Loctite® QuickStix™ C5-A® Copper Based Anti-Seize
 Loctite® Moly-50™ Anti-Seize
 Loctite® Silver Grade Anti-Seize
 Loctite® QuickStix™ Silver Grade Anti-Seize
 Loctite® Thread Sealing Tape 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® 5950™ Fastgasket® Flange Sealant, Cure-in-Place
 Loctite® 7804FRM-HV™ Hysol® Hot Melt Adhesive
 Loctite® 7809FR™ Hysol® Hot Melt Adhesive, Polyamide
 Loctite® Superflex® Non-Corrosive RTV, Clear Silicone Adhesive Sealant
 Loctite® Superflex® RTV, Silicone Adhesive Sealants (Black, Clear, White)

ULC Classified for Canada

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® 592™ PST® Thread Sealant, Slow Cure
 Loctite® Superflex® RTV, Silicone Adhesive Sealants (Black, Clear, White)

CSA International

Loctite® 55™ Pipe Sealing Cord
 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

ISO-10993 Compliance

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® 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/Variou Substrates
 Loctite® 3942™ Light Cure Adhesive, High Performance/Variou Substrates
 Loctite® 3943™ Light Cure Adhesive, High Performance/Variou 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/Variou Substrates
 Loctite® 3982™ Hysol® Epoxy Adhesive, High Performance/Variou Substrates
 Loctite® 3984™ Hysol® Epoxy Adhesive, High Performance/Variou Substrates
 Loctite® 4011™ Prism® Medical Device Adhesive
 Loctite® 4013™ Prism® Medical Device Adhesive
 Loctite® 4014™ Prism® Medical Device Adhesive
 Loctite® 4031™ Prism® Medical Device Adhesive
 Loctite® 4061™ Prism® Medical Device Adhesive
 Loctite® 4081™ Prism® Medical Device Adhesive
 Loctite® 4161™ Super Bonder® Medical Device Instant Adhesive
 Loctite® 4206™ Prism® Medical Device 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 Adhesive
 Loctite® 4601™ Prism® Medical Device Adhesive
 Loctite® 4851™ Prism® Instant Adhesive, Flexible
 Loctite® 4861™ Prism® Instant Adhesive, Flexible
 Loctite® 4981™ Super Bonder® Medical Device Adhesive
 Loctite® 5248™ Nuva-Sil® Medical Device Sealant
 Loctite® 7701™ Prism® Medical Device Adhesive Primer

The information above is an abbreviated list of Loctite® brand 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.



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

To access these and other Henkel Engineering Services, contact our Adhesives and Sealants Specialists at 1-800-LOCTITE (562-8483). Immediate technical assistance is available between 8 am – 5 pm EST.

ENGINEERING SERVICES

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. Henkel Engineering Services 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, Henkel Engineering Services 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.



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® brand 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 chambers, humidity chambers, and thermal cycling chambers, manufacturers can be provided with confidence in the durability and longevity of an assembly in the field.

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 adhesives without specific testing. It is recommended that you conduct on-part testing to ensure adhesive performance before specifying any adhesive.

Henkel Adhesives and Sealants Specialists are available to assist you with new product designs, or to help you re-engineer an existing application using Loctite® brand products 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 and select "Contact Loctite."

SENSOR BRACKET
DO NOT ASSEMBLE

SENSOR REF. ONLY

PERFORMANCE CONSIDERATIONS	ADHESIVE CATEGORY							
	Cyanoacrylates	Epoxies	Hot Melts	Light Cure	Silicones	Urethanes	2-Part Acrylics	2-Step Acrylics
Benefits	Excellent adhesion to most rubber or plastics	Wide range of formulations	Fast, large gap filling	Rapid cure/adhesion to plastics	Excellent temperature resistance	Excellent toughness/flexibility	Good impact resistance/flexibility	Good impact resistance, no-mix
Limitations	Low solvent resistance	Mixing required	Low heat resistance	Light Cure System required	Low strength	Sensitive to moisture	Mixing required	Primer required
Temperature Resistance Typical for the category (°F) Highest Rated Product (°F)	-65 to +180 +250	-65 to +180 +400	-65 to +250 +330	-65 to +300 +350	-65 to +400 +600	-65 to +250 +300	-65 to +250 +250	-65 to +300 +400
Environmental Resistance Polar Solvents (ex. H ₂ O, Ethylene Glycol, IPA, Acetone) Non-Polar Solvents (ex. Motor Oil, Toluene, Gasoline, ATF)	Poor ¹ Good	Very good Excellent	Good Good	Good Very good	Good Poor-fair	Good Good	Good Very good	Good Very good
Adhesion to Substrates Metals Plastics² Glass Rubber Wood	Very good Excellent Poor Very good Good	Excellent Fair Excellent Fair Very Good	Good Very good Good Fair Excellent	Good Excellent Excellent Fair Poor	Good Fair Very good Good Fair	Good Very good Good Good Fair	Excellent Excellent Good Poor Good	Excellent Fair Excellent Poor Good
Overlapping Shear Strength	High	High	Low	High	Low	Medium	High	High
Peel Strength	Low	Medium	Medium	Medium	Medium	Medium	High	Medium
Tensile Strength	High	High	Low	High	Low	Medium	High	High
Elongation/Flexibility	Low	Low	High	Medium	Very High	High	High	Medium
Hardness	Rigid	Rigid	Semi-soft	Semi-rigid	Soft	Soft	Semi-rigid	Semi-rigid
PROCESS CONSIDERATIONS								
Number of Components	1	2	1	1	1	2	2	2
Cure Temperature	Room Temp.	Room Temp.	Room Temp. ³	UV/Visible	Room Temp.	Room Temp.	Room Temp.	Room Temp.
Fixture Time Average Fastest	60 seconds 10 seconds	35 minutes 3-5 minutes	70 seconds 20 seconds	30 seconds 5 seconds	25 minutes 10 minutes	25 minutes 5 minutes	20 minutes 3-5 minutes	5 minutes 30 seconds
Full Cure Time	24 hours	12 - 24 hours	1 hour (or when cooled) ⁴	30 - 60 seconds	24 hours	24 hours	24 hours	24 hours
Gap Fill Ideal (in inches) Maximum (in inches)	0.001 - 0.003 0.010	0.004 - 0.006 0.125	0.002 - 0.005 0.240	.002 to .010 0.25	0.004 - 0.006 0.250	0.004 - 0.006 0.125	0.010 - 0.040 0.5	0.002 - 0.004 0.040
Dispensing/Mixing Equipment Required?	No	Yes	Yes	No	No	Yes	Yes	No
Light Cure Versions Available?	Yes	Yes	No	Yes	Yes	No	No	Yes
For more information on each adhesive category, refer to pages...	12-15, 29, 31, 59, 60	16-19, 21, 59, 61	24-27	28-31, 58-60	29, 31, 59, 61	17, 20, 21, 59, 61	9, 11	8, 10

¹ Cyanoacrylates have very good moisture resistance on plastics.

² 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 (LT2197) or contact 1-800-LOCTITE for more information.

³ Elevated temperatures are required to dispense liquid Hot Melt Adhesives.

⁴ Urethane Hot Melts require 24 hours for full cure.



Loctite® brand structural acrylic adhesives were developed for structural bonding applications that require tensile, shear and peel strength combined with maximum impact, stress and shock resistance. Available in two major categories:

- Two-Step No-Mix Structural Acrylics
- Two-Part Structural Acrylics

BONDING

ACRYLIC ADHESIVES

TWO-STEP NO MIX STRUCTURAL ACRYLIC ADHESIVES – when in contact with a liquid activator, these no mix materials cure rapidly at room temperature to a weather-resistant bond. Ideal for close fitting parts and where extended open time is required.

Loctite® 324™ Speedbonder™ Structural Adhesive

High Impact

Ideal for large gap applications. Offers the strength of an epoxy and the speed of an instant adhesive. Solvent resistant. Cures in minutes. Specially formulated for toughness and impact strength.

Loctite® 325™ Speedbonder™ Structural Adhesive

High Temperature

Solvent resistant, activator-cured in minutes. Forms flexible bonds on gaps up to 0.40". Designed for severe environments and temperatures to 350°F.

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.

Loctite® 330™ Depend® Adhesive

No-Mix

A no-mix high viscosity adhesive for a wide range of materials, including metal, wood, ferrite, ceramic, and plastic.

Loctite® 332™ Structural Adhesive

Severe Environment

An activator-cured, no mix adhesive that provides high temperature capability with thermal durability up to 400°F.

Loctite® 392™ Structural Adhesive

Fast Fixture/Magnet Bonder

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

TWO-PART STRUCTURAL ACRYLIC ADHESIVES – when statically mixed, these adhesives develop a tough, durable bond to a wide variety of substrates, including metals, plastics, and composites. Loctite® brand two-part structural acrylics are available in mixer-friendly packaging to minimize waste and process time. Refer to the Dispensing section for available dual cartridge dispensers and mix nozzles.

**Loctite® H3000™
Speedbonder™
Structural Adhesive**

General Purpose

A low viscosity adhesive ideal for bonding plastics and composites.

**Loctite® H3300™
Speedbonder™
Structural Adhesive**

General Purpose/Fast Fixturing

A non-sag, fast fixturing structural adhesive for bonding plastics and composites.

**Loctite® H3151™
Speedbonder™
Structural Adhesive**

Metal Bonder

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

**Loctite® H4000™
Speedbonder™
Structural Adhesive**

Non-Sag

A two component and room temperature cure methacrylate adhesive that fixtures rapidly. Bonds various plastic substrates, stainless steel, epoxy coated metal, and many fiber reinforced plastics, such as glass fiber reinforced polyester.

**Loctite® H4100™
Speedbonder™
Structural Adhesive**

Ultra Fast

Fast fixturing structural adhesive. Forms strong bonds to plastics and composites.

**Loctite® H4200™
Speedbonder™
Structural Adhesive**

Toughened

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

**Loctite® H4500™
Speedbonder™
Structural Adhesive**

Metal Bonder

High strength structural adhesive for metals. Fixtures in 10 minutes.

**Loctite® H4800™
Speedbonder™
Structural Adhesive**

Toughened

Provides extended open time, making it ideal for the assembly and adjustment of large parts. Excellent peel and impact resistance. Provides high bond strengths on composites.

**Loctite® H8000™
Speedbonder™
Structural Adhesive**

Fast Fixture

Features fast fixture time and excellent bond strength on multiple substrates, including metals and composites.

Loctite® 3030™ Adhesive

Polyolefin Bonder

A fast curing thixotropic acrylic adhesive. Designed to bond low energy plastic substrates.

NEW

**REQUIRED
EQUIPMENT**

Equipment is sold separately. Please refer to the Dispensing section on pages 106 & 107 for a complete line of dual cartridge dispensers and mix nozzles.



LOCTITE® BRAND STRUCTURAL ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Typical Use	Color	Gap Fill	Viscosity, cP at 20 RPM	Shear Strength psi*	Temperature Range	Cure Speed	Recommended Primer	Specific Gravity	Agency Approvals
312™ Speedbonder™	03333 00144 31231 31243	10 ml kit ¹ 50 ml kit ² 50 ml bottle 1 liter bottle	Fast cure on close fitting parts	Amber	.003"	1,000	3,000	-65°F to 225°F	Fixture - 30 sec.* Full - 24 hrs.	736™	1.08	-
324™ Speedbonder™	32430 32490	50 ml bottle 1 liter bottle	High impact applications	Amber	.040"	17,000	2,175	-65°F to 275°F	Fixture - 5 min. Full - 24 hrs.	7075™	1.11	-
325™ Speedbonder™	32530 32586	50 ml bottle 1 liter bottle	High temperature applications	Amber	.040"	20,000	2,200	-65°F to 350°F	Fixture - 5 min. Full - 24 hrs.	7075™	1.11	-
326™ Speedbonder™	32629 32685	50 ml bottle 1 liter bottle	Fast fixturing applications	Amber	.020"	18,000	2,700	-65°F to 225°F	Fixture - 1 min. Full - 24 hrs.	7649™	1.10	-
330™ Depend®	20253 20251 20252 33058 33064 33081	3 ml kit ³ 25 ml kit ⁴ 250 ml kit ⁵ 250 ml tube 300 ml cartdg. 1 liter bottle	Rough or porous surfaces	Amber	.030"	67,500	3,300	-65°F to 250°F	Fixture - 5 min.* Full - 24 hrs.	7387™/ 7380™	1.05	CFIA
332™	33201 33275 33290	25 ml syringe 300 ml cartdg. 1 liter bottle	High temperature applications	Pale yellow	.020"	200,000	3,500	-65°F to 400°F	Fixture - 3 min. Full - 24 hrs.	7387™/ 7380™	0.97	-
334™	33403 33470	25 ml syringe 300 ml cartdg.	Tough magnet bonder	Pale yellow	.020"	80,000/ 140,000 Thixotropic	2,800	-65°F to 300°F	Fixture - 90 sec. Full - 24 hrs.	7387™/ 7380™	1.05	-
392™	39250 39275 39280	50 ml tube 300 ml cartdg. 1 liter bottle	Fast fixturing magnet bonder	Amber	.025"	60,000	2,800	-65°F to 300°F	Fixture - 60 sec. Full - 24 hrs.	7387™/ 7380™	1.16	-

* Varies with substrates.

 Indicates worldwide availability.

¹ Contains 10 ml bottle of Loctite® 312™ Speedbonder™ and 40 gm aerosol can of Loctite® 736™ Primer NF™.

² Contains 50 ml bottle of Loctite® 312™ Speedbonder™ and 6 oz. aerosol can of Loctite® 736™ Primer NF™.

³ Contains 0.2 fl. oz. tube of Loctite® 330™ Depend® Adhesive and 0.7 fl. oz. ampule of Loctite® 7387™ Depend® Activator.

⁴ Contains 25 ml syringe of Loctite® 330™ Depend® Adhesive and 25 gm aerosol can of Loctite® 7387™ Depend® Activator.

⁵ Contains 250 ml tube of Loctite® 330™ Depend® Adhesive and 4.5 fl. oz. aerosol can of Loctite® 7387™ Depend® Activator.



LOCTITE® BRAND SPEEDBONDER™
PLASTIC AND COMPOSITE
BONDERS PROPERTIES CHART


PRODUCT	Item Number	Container	Viscosity cP (part A / part B)	Color (mixed)	Open Time in Minutes	Fixture Time in Minutes	Peel Strength, pli	Impact Strength, kJ/m ²	Aluminum Shear Strength, psi	Steel Shear Strength, psi	Fiberglass Shear Strength, psi	Gelcoat Shear Strength, psi	ABS Shear Strength, psi	PVC Shear Strength, psi	Agency Approvals
1:1 Products															
H3000™ Speedbonder™	83001 83000	50 ml dual cartridge 400 ml dual cartridge	65,000/ 24,000	Cream	5	12-15	-45	25	2,360	3,830	1,740	1,495	1,550	2,510	-
H3101™ Speedbonder™	83007 83006	50 ml dual cartridge 400 ml dual cartridge	95,000/ 65,000	Cream	15-20	25	35	20-25	1,610	2,510	1,810	1,565	1,420	2,080	-
H3300™ Speedbonder™	83020 83019 83024* 83022*	50 ml dual cartridge 400 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	150,000/ 85,000	Yellow	5	6	35-40	20	1,700	3,350	1,650	1,425	1,880	990	-
10:1 Products															
3030™ Speedbonder™	37220	35 ml dual cartridge	30,000/ 5,000	Off white	2-3	10	2-4	6	975	1,450	N/A	N/A	1,330	2,000	-
H4000™ Speedbonder™	83025 83031* 83028*	490 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	100,000/ 70,000	Pale yellow	8	14	45	20-25	2,580	3,500	1,645	1,500	790	1,980	NSF/ ANSI 61
H4100™ Speedbonder™	83032	490 ml dual cartridge	95,000/ 145,000	Pale yellow	2	3-5	13	8	710	3,140	1,725	1,405	2,270	2,850	-
H4200™ Speedbonder™	83038	490 ml dual cartridge	95,000/ 45,000	Pale yellow	5	15	55	>42	2,870	4,020	1,640	1,520	740	2,440	-
H4800™ Speedbonder™	83045 83047* 83046*	490 ml dual cartridge 40 lb. pail, adhesive 36 lb. pail, activator	50,000/ 55,000	Light yellow	20-25	35	50	>42	1,810	3,930	1,725	1,590	530	2,090	-
H8000™ Speedbonder™	36160 35939* 35940*	490 ml dual cartridge 35 lb. pail, adhesive 45 lb. pail, activator	160,000/ 40,000	Green	10-15	15-20	50-60	>42	3,000	3,500	1,600	1,500	460	1,740	-

Peel Strength measured on steel.
Impact Strength measured on as-received aluminum.
* Made-to-order item.

LOCTITE® BRAND
SPEEDBONDER™ METAL BONDERS
PROPERTIES CHART

PRODUCT	Item Number	Container	Viscosity cP (part A / part B)	Color (mixed)	Open Time in Minutes	Fixture Time in Minutes	Peel Strength, pli	Impact Strength, kJ/m ²	Aluminum Shear Strength, psi	Steel Shear Strength, psi	Fiberglass Shear Strength, psi	Gelcoat Shear Strength, psi	ABS Shear Strength, psi	PVC Shear Strength, psi
1:1 Products														
H3151™ Speedbonder™	83015 83014	50 ml dual cartridge 400 ml dual cartridge	70,000/ 70,000	Pale yellow	35-40	60	40	>42	3,600	3,770	1,835	1,440	1,570	1,590
10:1 Products														
H4500™ Speedbonder™	83041	490 ml dual cartridge	54,000/ 54,000	Pale yellow	8-10	10	40	40	4,020	4,130	1,760	1,455	1,560	2,200

Peel Strength measured on steel.
Impact Strength measured on as-received aluminum.
Fixture time measured on steel.



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® brand instant adhesives are available in a variety of viscosities, cure speeds, gap-filling capabilities, and substrate compatibilities. The ultra high-performance Loctite® brand Prism® family offers additional products that surpass the most stringent demands, including toughened formulations, low odor and low blooming products, surface insensitive and thermally resistant formulations.

BONDING

CYANOACRYLATE ADHESIVES

Loctite® 380™ Black Max® Instant Adhesive

Toughened

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

Loctite® 403™ Prism® Instant Adhesive

Low Odor/Low Bloom

An adhesive for less precisely fitted parts. Eliminates the need for sophisticated ventilation.

Loctite® 404™ Quick Set™ Instant Adhesive

General Purpose

For general maintenance and repair. Excellent for rubber bonding.

Loctite® 411™ Prism® Instant Adhesive

Clear Toughened

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

Loctite® 430™ Super Bonder® Instant Adhesive

A general industrial-grade instant adhesive. Excellent choice for bonding close fitting metal parts.

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

General Purpose

Designed to bond rubber, metal, and plastic parts with gaps to .004".

For technical information and/or product availability, call 1-800-LOCTITE or on the web

Visit

www.loctite.com



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 223°F continuous or up to 250°F intermittent.

Loctite® 4204™ Prism® Instant Adhesive

Thermal Resistant

Part of the family of clear, toughened, thermally resistant instant adhesives. Excellent hot strength and heat aging properties up to 250°F.

Loctite® 4210™ Prism® Instant Adhesive

Thermal Resistant

Part of the family of black toughened thermally resistant instant adhesives. Low viscosity and thermally resistant up to 250°F.

Loctite® 4212™ Prism® Instant Adhesive

Thermal Resistant Gel

A high viscosity, black, toughened, instant adhesive. Thermally resistant up to 250°F.

Loctite® 4500™ Prism® Instant Adhesive

Fast Curing/Surface Insensitive Gel

Specifically formulated for faster cure speeds on dry or acidic surfaces and substrates. The gel consistency prevents adhesive flow even on vertical surfaces.

Loctite® 4501™ Prism® Instant Adhesive

Wicking Viscosity

A single component, fast-curing instant adhesive. Formulated to maintain cure speed throughout its shelf life.

Loctite® 4502™ Prism® Instant Adhesive

Fast Curing/Surface Insensitive

A medium viscosity, single component instant adhesive specifically formulated for faster cure speeds on dry or acidic surfaces and substrates.

Loctite® 4503™ Prism® Instant Adhesive

Fast Curing/Surface Insensitive

A high viscosity, single component instant adhesive specifically formulated for faster cure speeds on dry or acidic surfaces and substrates.

Loctite® 4851™ Prism® Instant Adhesive

Flexible

A medium viscosity, flexible, single component material for porous or absorbent substrates, such as paper and leather.

Loctite® 4861™ Prism® Instant Adhesive

Flexible

A high viscosity, flexible, single component, general-purpose material for gaps up to .008".

ADDITIONAL OFFERINGS

For Light Cure Cyanoacrylate Adhesives, see the Light Cure Adhesives section beginning on page 29.



**LOCTITE® BRAND INSTANT
ADHESIVES PROPERTIES CHART**

PRODUCT	Item Number	Container	Typical Use	Color	Gap Fill	Category	Viscosity, cP	Strength, psi* Tensile Shear	Temperature Range	Cure Speed**	Specific Gravity	Agency Approvals
380™ Black Max®	38004 38050 38061	3 gm tube 1 oz. bottle 1 lb. bottle	Close fitting parts	Black	.006"	Toughened Ethyl	200	3,750	-65°F to 225°F	Fixture - 90 sec. Full - 24 hrs.	1.10	CFIA
382™ Tak Pak®	38203 20420 38240 38261	3 gm tube 20 gm kitt 20 gm bottle 1 lb. bottle	Tak Pak® ultra-performance wire tacking	Clear	.008"	General purpose Ethyl	5,000	3,200	-65°F to 250°F	Fixture - 30 sec. Full - 24 hrs.	1.05	-
401™ Prism®	40104 40140 40161	3 gm tube 20 gm bottle 1 lb. bottle	General purpose	Clear	.005"	Surface insensitive Ethyl	110	3,200	-65°F to 180°F	Fixture - 15 sec. Full - 24 hrs.	1.05	CFIA
403™ Prism®	40304 40340 40361	3 gm tube 20 gm bottle 1 lb. bottle	Gap filling	Clear	.008"	Low odor/ low bloom Alkoxy	1,000	2,600	-65°F to 160°F	Fixture - 50 sec. Full - 24 hrs.	1.10	-
404™ Quick Set™	46551 46548 46561	1/3 oz. bottle 4 oz. bottle 1 lb. bottle	Rubber O-ring bonder	Clear	.005"	General purpose 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
406™ Prism®	40604 40640 40661	3 gm tube 20 gm bottle 1 lb. bottle	Wicking grade	Clear	.004"	Surface insensitive Ethyl	20	3,200	-65°F to 180°F	Fixture - 15 sec. Full - 24 hrs.	1.05	Commercial item std. A-A-3097
408™ Prism®	40840 40861	20 gm bottle 1 lb. bottle	Wicking grade	Clear	.002"	Low odor/ low bloom Alkoxy	5	2,600	-65°F to 160°F	Fixture - 50 sec. Full - 24 hrs.	1.05	-
409™ Super Bonder®	40904 21922 40945 40974 18030	3 gm tube 10 gm syringe 20 gm tube 200 gm tube 300 gm cartridge	General purpose gel adhesive	Clear	.010"	General purpose Ethyl	Gel	3,200	-65°F to 180°F	Fixture - 75 sec. Full - 24 hrs.	1.10	-
410™ Prism®	41004 41045 41061	3 gm tube 20 gm bottle 1 lb. bottle	Gap filling	Black	.008"	Toughened Ethyl	3,500	3,200	-65°F to 225°F	Fixture - 90 sec. Full - 24 hrs.	1.07	CFIA
411™ Prism®	41104 41145 41161	3 gm tube 20 gm bottle 1 lb. bottle	Clear gap filling	Clear	.008"	Toughened Ethyl	5,000	3,200	-65°F to 210°F	Fixture - 30 sec. Full - 24 hrs.	1.07	-
414™ Super Bonder®	41404 41450 41461	3 gm tube 1 oz. bottle 1 lb. bottle	Plastic bonder	Clear	.006"	General purpose 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 41561	1 oz. bottle 1 lb. bottle	Gap filling metal bonder	Clear	.008"	General purpose 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 41661	1 oz. bottle 1 lb. bottle	Gap filling plastic bonder	Clear	.008"	General purpose 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 42061	1 oz. bottle 1 lb. bottle	Wicking type plastic bonder	Clear	.002"	General purpose 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 42261	1 oz. bottle 1 lb. bottle	Gap filling plastic bonder	Clear	.008"	General purpose 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
426™ Prism®	21921 18398 17451 17529	10 gm syringe 20 gm tube 200 gm tube 300 gm cartridge	Porous surfaces	Black	.010"	Toughened Ethyl	Gel	3,000	-65°F to 210°F	Fixture - 20 sec. Full - 24 hrs.	1.10	-
430™ Super Bonder®	43004 43050 43061	3 gm tube 1 oz. bottle 1 lb. bottle	Metal bonder for close fitting parts	Clear	.005"	General purpose 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 20419 12294	20 gm bottle 20 gm kitt 1 lb. bottle	Tak Pak® Wire tacking adhesive	Clear	.007"	General purpose Ethyl	700	3,200	-65°F to 180°F	Fixture - 30 sec. Full - 24 hrs.	1.05	Commercial item std. A-A-3097
454™ Prism®	45404 21925 45440 45474 45478	3 gm tube 10 gm syringe 20 gm tube 200 gm tube 300 gm cartridge	Porous surfaces	Clear	.010"	Surface insensitive Ethyl	Gel	3,200	-65°F to 180°F	Fixture - 15 sec. Full - 24 hrs.	1.05	CFIA, ABS

* Grit blasted steel. ** Varies with substrates.












† Contains Loctite® 382™ Tak Pak® Instant Adhesive (20 gm 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® brand instant adhesives. Refer to the Surface Preparation section.



Indicates worldwide availability.


LOCTITE® BRAND INSTANT ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Typical Use	Color	Gap Fill	Category	Viscosity, cP	Strength, psi* Tensile Shear	Temperature Range	Cure Speed**	Specific Gravity	Agency Approvals
455™ Prism®	22309 17421	10 gm syringe 200 gm tube	Porous surfaces	Clear	.010"	Low odor/ low bloom Alkoxy	Gel	2,600	-65°F to 160°F	Fixture - 90 sec. Full - 24 hrs.	1.10	-
460™ Prism® 	46004 46040 46061	3 gm tube 20 gm bottle 1 lb. bottle	Close fitting parts	Clear	.004"	Low odor/ low bloom Alkoxy	45	2,600	-65°F to 160°F	Fixture - 50 sec. Full - 24 hrs.	1.10	-
480™ Prism® 	48040 48061	20 gm bottle 1 lb. bottle	General filling	Black	.006"	Toughened Ethyl	300	3,800	-65°F to 210°F	Fixture - 90 sec. Full - 24 hrs.	1.10	NSF/ANSI 61
493™ Super Bonder®	49350 49361	1 oz. bottle 1 lb. bottle	Wicking type metal bonder	Clear	.002"	General purpose 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 49504 49550 49561	.07 fl. oz. Gluematic® Pen 3 gm tube 1 oz. bottle 1 lb. bottle	General purpose	Clear	.004"	General purpose 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 49661	1 oz. bottle 1 lb. bottle	General purpose rubber bonder	Clear	.006"	General purpose 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 49861	1 oz. bottle 1 lb. bottle	Thermal cycling adhesive	Clear	.007"	General purpose Ethyl	500	3,000	-65°F to 250°F	Fixture - 50 sec. Full - 24 hrs.	1.10	-
499™ Super Bonder®	49904 21924 49945 49974	3 gm tube 10 gm syringe 20 gm tube 200 gm tube	Thermal cycling gel adhesive	Clear	.010"	General purpose Ethyl	Gel	3,200	-65°F to 200°F	Fixture - 75 sec. Full - 24 hrs.	1.10	-
4203™ Prism®	28026 28027	20 gm tube 1 lb. bottle	Close fitting parts	Clear	.005"	Thermally resistant Ethyl	375	2,200	-65°F to 250°F	Fixture - 30 sec. Full - 24 hrs.	1.10	-
4204™ Prism®	26324 26325	20 gm tube 1 lb. bottle	Gap filling	Clear	.008"	Thermally resistant Ethyl	4,000	2,100	-65°F to 250°F	Fixture - 30 sec. Full - 24 hrs.	1.10	-
4205™ Prism®	28028 28029 28030	20 gm tube 20 gm tube 300 gm cartridge	Porous surfaces	Clear	.010"	Thermally resistant Ethyl	Gel	2,300	-65°F to 250°F	Fixture - 30 sec. Full - 24 hrs.	1.10	-
4210™ Prism® 	19757 19758 19759	3 gm tube 20 gm bottle 1 lb. bottle	Close fitting parts	Black	.005"	Thermally resistant Ethyl	160	3,600	-65°F to 250°F	Fixture - 120 sec. Full - 24 hrs.	1.10	CFIA
4211™ Prism®	19761 19762 19763	3 gm tube 20 gm bottle 1 lb. bottle	Gap filling	Black	.007"	Thermally resistant Ethyl	2,500	3,600	-65°F to 250°F	Fixture - 210 sec. Full - 24 hrs.	1.07	-
4212™ Prism® 	19765 21923 19766 19767 19768	3 gm tube 10 gm syringe 20 gm tube 200 gm tube 300 gm cartridge	Porous surfaces	Black	.008"	Thermally resistant Ethyl	11,000	3,900	-65°F to 250°F	Fixture - 360 sec. Full - 24 hrs.	1.05	CFIA
4471™ Prism®	44704 44740 44761	3 gm tube 20 gm bottle 1 lb. bottle	Gap filling	Clear	.007"	Surface insensitive Ethyl	600	3,200	-65°F to 180°F	Fixture - 10 sec. Full - 24 hrs.	1.10	-
4500™ Prism® 	35533 35534 35813 35814	3 gm tube 20 gm tube 200 gm tube 300 gm cartridge	Porous surfaces	Clear	.010"	Surface insensitive Ethyl	Gel	2,760	-65°F to 180°F	Fixture - 5 sec. Full - 24 hrs.	1.11	-
4501™ Prism® 	38146 38145 38147	3 gm tube 20 gm bottle 1 lb. bottle	Wicking grade	Clear	.004"	Surface insensitive Ethyl	20	2,600	-65°F to 180°F	Fixture - 5 sec. Full - 24 hrs.	1.10	-
4502™ Prism® 	39231 39232 39233	3 gm tube 20 gm bottle 1 lb. bottle	General purpose	Clear	.005"	Surface insensitive Ethyl	100	2,810	-65°F to 180°F	Fixture - 5 sec. Full - 24 hrs.	1.10	-
4503™ Prism® 	39213 39214 39170	3 gm tube 20 gm bottle 1 lb. bottle	Gap filling	Clear	.007"	Surface insensitive Ethyl	650	2,910	-65°F to 180°F	Fixture - 5 sec. Full - 24 hrs.	1.10	-
4851™ Prism® 	37732 37733	20 gm bottle 1 lb. bottle	Flexible	Clear	.006"	Flexible Alkyl	400	2,175	-65°F to 212°F	Fixture - 30 sec. Full - 24 hrs.	1.10	-
4861™ Prism® 	37708 37711	20 gm bottle 1 lb. bottle	Flexible	Clear	.008"	Flexible Alkyl	4,000	2,465	-65°F to 212°F	Fixture - 25 sec. Full - 24 hrs.	1.10	-

* Grit blasted steel. ** Varies with substrates.

† Contains Loctite® 444™ Tak Pak® Instant Adhesive (20 gm bottle), Loctite® 7452™ Tak Pak® Accelerator (1.75 fl. oz. bottle).

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

 Indicates worldwide availability.



The Loctite® brand offers a complete line of one-part and two-part epoxy and urethane adhesives for structural bonding, potting, and encapsulating.

The Loctite® brand Hysol® line contains a wide range of application-specific products designed to outperform the competition in all aspects:

- Better Adhesion
- Better Flow
- Less Odor
- Improved Clarity
- Higher Strength
- Greater Durability

From fast setting to high temperature properties, Hysol® Epoxy and Urethane adhesives offer a variety of performance benefits to meet your assembly requirements.

BONDING

EPOXY & URETHANE ADHESIVES

EPOXY ADHESIVES

Loctite® E-00CL™ Hysol® Epoxy Adhesive

Low Odor

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

Loctite® E-00NS™ Hysol® Epoxy Adhesive

Non-Sag

A translucent, controlled flow, low odor epoxy with a 5-minute worklife.

Loctite® E-05CL™ Hysol® Epoxy Adhesive

Toughened

An ultra clear, high peel, low odor epoxy with a 5-minute worklife.

Loctite® E-20HP™ Hysol® Epoxy Adhesive

Fast Setting

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

Loctite® E-20NS™ Hysol® Epoxy Adhesive

Metal Bonder

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

Loctite® E-30CL™ Hysol® Epoxy Adhesive

Glass Bonder

An ultra clear, low viscosity, impact resistant epoxy with a 30-minute worklife.

Loctite® E-40FL™ Hysol® Epoxy Adhesive

Flexible

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

Loctite® E-60HP™ Hysol® Epoxy Adhesive

Toughened

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

For the name and number of your nearest distributor, call: 1-800-LOCTITE (562-8483)

or use the "Distributor Locator" on our web site at www.loctite.com/distributor

**Loctite® E-60NC™ Hysol®
Epoxy Adhesive***Non-Corrosive*

An electronics-grade potting compound with a 60-minute worklife. Black, opaque, low viscosity.

**Loctite® E-90FL™ Hysol®
Epoxy Adhesive***Flexible*

A grey, impact resistant, toughened epoxy with a 90-minute worklife

**Loctite® E-120HP™ Hysol®
Epoxy Adhesive***Ultra Strength*

An amber, non-sag, aerospace grade epoxy with a 120-minute worklife.

**Loctite® E-214HP™ Hysol®
Epoxy Adhesive***High Strength*

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

**Loctite® 608™ Hysol®
Epoxy Adhesive***High Strength*

A fast setting, low odor epoxy with a 5-minute worklife. Cures at room temperature to form a clear bondline.

**Loctite® D609™ Hysol®
Epoxy Adhesive***Ultra Clear*

A high performance epoxy with a 5-minute worklife. Low odor, very fast room temperature cure, heat resistant to 180°F.

**Loctite® 615™ Hysol®
Epoxy Adhesive***Sandable*

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

**Loctite® 0151™ Hysol®
Epoxy Adhesive***Ultra Clear*

A general purpose thixotropic paste epoxy with a 50-minute worklife. Allows for extended adjustment time.

**Loctite® 9433™ Hysol®
Epoxy Adhesive***Self-Leveling*

A high strength epoxy with a 30-minute worklife. Cream in color, flowable, toughened, high peel resistance.

**Loctite® 9430™ Hysol®
Epoxy Adhesive***High Strength*

An off white, toughened, light paste, high peel, high shear strength epoxy with a 40-minute worklife.

**Loctite® 9460™ Hysol®
Epoxy Adhesive***Non-Sag*

A grey, impact resistant, high viscosity, high peel, high shear epoxy with a 30-minute worklife.

**Loctite® 9459™ Hysol®
Epoxy Adhesive***High Temperature Resistance*

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

**Loctite® 9432NA™ Hysol®
Epoxy Adhesive***Non-Sag*

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

URETHANE ADHESIVES**Loctite® U-05FL™ Hysol®
Urethane Adhesive***High Strength*

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

**Loctite® U-09FL™ Hysol®
Urethane Adhesive***Highly Flexible*

A two-part, high performance urethane adhesive for plastic bonding with a 10-minute worklife. Ultra clear, impact resistant, high peel.

**Loctite® U-09LV™ Hysol®
Urethane Adhesive***Low Viscosity*

A two-part, high performance urethane adhesive for plastic bonding with a 10-minute worklife.

**REQUIRED
EQUIPMENT**

Equipment is sold separately. Please refer to the Dispensing section on pages 106 & 107 for a complete line of dual cartridge dispensers and mix nozzles.



**LOCTITE® BRAND HYSOL® EPOXY
ADHESIVES PROPERTIES CHART**

PRODUCT	Item Number	Container	Features	Color	Viscosity at 25°C	Worklife	Mix Ratio by Volume (resin:hardener)	Peel Strength, pli*	Overlap Shear Strength,† psi	Tg, °C	Hardness (Shore D)	Agency Approvals	
FAST SETTING	E-00CL™ Hysol®	29289 29290 29291	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Fast setting Flowable Low odor	Clear	Mixed - low Resin: 9,300 cP Hardener: 2,700 cP	3-5 min.	1:1	1-5	2,000-4,000	20	80	CFIA
	E-00NS™ Hysol®	29294 29295 29296	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Non-sag Controlled flow Low odor	Translucent	Mixed - high Resin: 375,000 cP Hardener: 2,800 cP	3-5 min.	1:1	1-5	2,000-4,000	20	80	CFIA
	E-05CL™ Hysol®	29299 29300 29301 29302 29303	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Toughened High peel Low odor	Ultra clear	Mixed - low Resin: 1,900 cP Hardener: 2,800 cP	3-5 min.	1:1	5-30	2,000-4,000	10	55	CFIA
	608™ Hysol®	83086 83075 83082 83083	4 gm foil pack 50 ml dual cartridge EPK 2.8 oz. kit 5 lb. kit	Fast cure Clear High strength	Clear	Mixed - medium Resin: 325,000 cP Hardener: 30,000 cP	5 min.	1:1	N/A	2,000	-	80	-
	D609™** Hysol®	83089	50 ml dual cartridge	Fast cure Ultra clear High strength	Ultra clear	Mixed - low Resin: 15,000 cP Hardener: 15,000 cP	5 min.	1:1	N/A	2,800	-	75	-
	615™ Hysol®	83094 83095	EPK 3.2 oz. kit 12 lb. kit	Fast cure Gap filling Sandable	Blue	Mixed - paste Resin: 700,000 cP Hardener: 140,000 cP	10 min.	1:1	N/A	2,500	-	65	-
GENERAL PURPOSE	1C™ Hysol®	83200 83202 83201	EPK 4 oz. kit 4 lb. kit 17 lb. kit	General purpose Gap-filling High temperature	White	Mixed - paste Resin: 235,000 cP Hardener: 710,000 cP	20 min.	2.5:1	N/A	1,750	98	80	-
	1C-LV™ Hysol®	83208 83207	50 ml dual cartridge 200 ml dual cartridge	General purpose Gap-filling Impact resistant	Light tan	Mixed - medium Resin: 82,000 cP Hardener: 36,200 cP	20 min.	2:1	N/A	2,100	-	75	-
	907™ Hysol®	83098	EPK 2.2 oz. kit	General purpose Minimal surface preparation	Light blue	Mixed - medium Resin: 100,000 cP Hardener: 150,000 cP	20 min.	1:1	N/A	3,100	-	79	-
	6C™ Hysol®	83211	EPK 4 oz. kit	General purpose Bonds and seals Machineable Gap-filling	Grey	Mixed - paste Resin: 235,000 cP Hardener: 710,000 cP	25 min.	2.5:1	N/A	1,750	98	80	-
	11C™ Hysol®	83186	EPK 4 oz. kit	General purpose Bonds and seals Machineable	Black	Mixed - paste Resin: 235,000 cP Hardener: 710,000 cP	25 min.	2.5:1	N/A	1,750	98	80	-
	0151™ Hysol®	83069 83176 83179 83178	50 ml dual cartridge EPK 3.3 oz. kit 2.6 lb. kit 10.7 lb. kit	General purpose Ultra clear Extended work life	Clear	Mixed - light paste Resin: 70,000 cP Hardener: 60,000 cP	50 min.	2.7:1	N/A	1,850	58	85	-
HIGH PERFORMANCE	9460F™ Hysol®	83225 83224	50 ml dual cartridge 200 ml dual cartridge	Impact resistant High shear High peel	Grey	Mixed - paste Resin: 225,000 cP Hardener: 175,000 cP	20 min.	1:1	40†	3,800	-	80	-
	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	High strength Rubber toughened High peel High shear Fast setting	Off white	Mixed - medium Resin: 65,000 cP Hardener: 7,000 cP	20 min.	2:1	20-70	3,000-5,000	60	80	CFIA
	9433™ Hysol®	83119	50 ml dual cartridge	Self-leveling High strength High peel	Cream	Mixed - medium Resin: 174,000 cP Hardener: 115,000 cP	30 min.	2:1	45†	3,800	-	75	-
	9430™ Hysol®	83114 83113	2 lb. kit 10 lb. kit	High strength High peel	Off white	Mixed - light paste Resin: 300,000 cP Hardener: 40 cP	40 min.	4:1	60†	4,700	-	75	-

* Tested on aluminum lap shears. ** Formerly Dexter® Hysol® 609. †ASTM D3167. N/A = Not available at time of printing. EPK = Epoxi-Patch® Kit.

LOCTITE® BRAND HYSOL® EPOXY
ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Features	Color	Viscosity at 25°C	Worklife	Mix Ratio by Volume (resin:hardener)	Peel Strength,* piw	Overlap Shear Strength,* psi	Tg, °C	Hardness (Shore D)	Agency Approvals	
HIGH PERFORMANCE	9460™ Hysol®	83129 83128 83131 83130 83133 83134	50 ml cartridge 200 ml cartridge 5 lb. kit 20 lb. kit 50 lb. pail, hardener 50 lb. pail, resin	High peel Impact resistant High viscosity Non-sag	Grey	Mixed - paste Resin: 225,000 cP Hardener: 175,000 cP	40 min.	1:1	35†	3,200	-	80	-
	E-40FL™ Hysol®	29304 29305 29306	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Toughened Flexible Impact resistant	Grey	Mixed - medium Resin: 75,000 cP Hardener: 65,500 cP	40 min.	1:1	5-40	1,000-3,000	30	75	CFIA
	9462™ Hysol®	83142 83135	50 ml cartridge 200 ml cartridge	Impact Resistant Toughened Non-sag	Beige	Mixed - medium Resin: 82,500 cP Hardener: 52,500 cP	50 min.	1:1	20†	3,500	-	77	-
	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 strength Toughened High peel High shear	Off-White	Mixed - medium Resin: 67,500 cP Hardener: 7,000 cP	60 min.	2:1	20-70	3,000-5,000	70	80	CFIA
	E-90FL™ Hysol®	29309 29310** 29311	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Toughened Flexible Impact resistant	Grey	Mixed - medium Resin: 71,500 cP Hardener: 19,000 cP	90 min.	1:1	5-40	1,000-3,000	-5	60	CFIA
	9460PB™ Hysol®	83233 83232	5 lb. kit 20 lb. kit	Bonds printing blanket stock High strength	Grey	Mixed - paste Resin: 225,000 cP Hardener: 100,000 cP	100 min.	1:1	N/A	2,000	-	-	-
	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	Ultra strength Non-sag Aerospace grade	Amber	Mixed - high Resin: 41,500 cP Hardener: 2,800 cP	120 min.	2:1	20-50	3,000-6,000	90	85	CFIA
HIGH TEMP.	9739™ Hysol®	83149 83150	42 lb. pail, hardener 168 lb. pail, resin	High temperature resistance High chemical resistance	Black	Mixed - paste Resin: 1,400,000 cP Hardener: 2,250,000 cP	90 min.	3.3:1	N/A	2,500	-	-	-
ADHESION SPECIFIC	E-20NS™ Hysol®	29334 29335 29336	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Metal bonder Non-sag High peel High shear	Light tan	Mixed - paste Resin: 60,000 cP Hardener: 30,000 cP	20 min.	2:1	5-30	2,000-4,000	87	90	CFIA
	E-30CL™ Hysol®	29329 29330 29331	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Glass bonder Low viscosity Impact resistant	Ultra clear	Mixed - low Resin: 10,500 cP Hardener: 2,200 cP	30 min.	2:1	5-30	2,000-4,000	70	85	CFIA
POTTING	E-60NC™ Hysol®	29324 29325 29326	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Potting†† Electrically non-corrosive Low viscosity	Black opaque	Mixed - low Resin: 6,200 cP Hardener: 13,000 cP	60 min.	1:1	1-5	1,000-3,000	55	85	CFIA
	9412™ Hysol®	83108 83107	2 lb. kit 10 lb. kit	Potting†† High strength Self-leveling	Pink	Mixed - low Resin: 15,000 cP Hardener: 40 cP	60 min.	3.5:1	35†	4,000	-	75	-
ONE-PART	9459™ Hysol®	83126	10 lb. can	High temperature resistance Self-leveling High chemical resistance	White	Low 39,000 cP	60 min.	1 part	N/A	3,000	-	-	-
	E-214HP™ Hysol®	29339 29340	30 ml cartridge 300 ml cartridge	High strength Temperature resistant Non-sag	Grey	Paste 150,000 cP	Heat cure	1 part	30-70	3,000-6,000	120	85	-
	9432NA™ Hysol®	83217 83216	2 lb. can 55 lb. pail	Non-sag Surface insensitive High temperature	Grey	Paste 225,000 cP	N/A	1 part	8	3,800	-	90	-

* Tested on aluminum lap shears. † ASTM D3167. †† For additional potting and encapsulating products, refer to page 40. N/A = Not available at time of printing.

** Made-to-order item.

LOCTITE® BRAND HYSOL® URETHANE ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Features	Color	Viscosity at 25°C	Worklife	Mix Ratio by Volume (resin:hardener)	Peel Strength,* piw	Overlap Shear Strength,* psi	Tg °C	Hardness (Shore D)	Agency Approvals	
POLYURETHANES	U-05FL™ Hysol®	29348 29349 29350	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Metal bonder Highly flexible High strength	Off white	Mixed - low Resin: 640 cP Hardener: 35,000 cP	5 minutes	1:2	5-30	1,000-3,000	48	45	CFIA
	U-09FL™ Hysol®	29460 29461 29462 29370** 29371**	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Plastic bonder Highly flexible High peel	Ultra clear	Mixed - low Resin: 10,000 cP Hardener: 1,150 cP	10 minutes	1:1	5-30	500-2,000	-20	45	-
	U-09LV™ Hysol® NEW	38588 38589 38590** 38591**	50 ml dual cartridge 200 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Plastic bonder Highly flexible High peel Low viscosity	Ultra clear	Mixed - very low Resin: 920 cP Hardener: 1,030 cP	10 minutes	1:1	N/A	500-2,000	N/A	45	-

* Varies with substrates.
** Made-to-order item.



SUBSTRATE SELECTOR GUIDE

Loctite® brand Hysol® Structural Adhesives Bond to a Variety of Substrates

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 to evaluate the selected product in your application to determine suitability.

	Metals	Thermo-Plastics	Thermoset Plastics	Rubber	Glass	Ceramic	Masonry	Wood	Leather	Paper/ Hardboard
Metals	E-20NS™ E-214HP™ U-05FL™	U-05FL™ E-40FL™ E-20HP™ 9430™	E-20NS™ E-20HP™ E-120HP™ 608™	U-05FL™ E-40FL™ U-09LV™ 9460™	E-30CL™ E-20NS™ U-05FL™ 0151™	E-20HP™ E-30CL™ U-05FL™ E-20NS™ 9430™	E-20HP™ E-120HP™ E-20NS™ E-40FL™ 9432NA™	E-00NS™ E-20HP™ E-40FL™ 608™	U-05FL™ E-40FL™ U-09LV™ 9460™	E-05CL™ E-40FL™ E-00CL™ D609™
Thermo-Plastics	U-05FL™ E-40FL™ E-20HP™ 615™	U-05FL™ U-09LV™ E-40FL™ 615™	U-05FL™ U-09LV™ E-40FL™ 615™	U-05FL™ E-40FL™ U-09LV™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-05CL™ E-20HP™ 615™	E-05CL™ E-40FL™ E-20HP™ 11C™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-05CL™ E-40FL™ E-20HP™ 9433™
Thermoset Plastics	E-20HP™ E-20NS™ E-120HP™ 615™	U-05FL™ U-09LV™ E-40FL™ 615™	E-20HP™ E-120HP™ E-214HP™ 615™	U-05FL™ E-20HP™ E-40FL™ 9460™	E-30CL™ U-05FL™ E-00CL™ 0151™	E-30CL™ E-20HP™ E-40FL™ 9433™	E-20HP™ E-120HP™ E-00CL™ E-40FL™ 9432NA™	E-20HP™ E-40FL™ E-00NS™ 11C™	E-05CL™ U-09LV™ E-40FL™ 615™	E-40FL™ E-00CL™ U-05FL™ D609™
Rubber	U-05FL™ E-40FL™ U-09LV™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	U-05FL™ E-40FL™ E-20HP™ 9433™	E-40FL™ E-90FL™ U-05FL™ 9460™	U-05FL™ E-40FL™ U-09LV™ 9460™	U-05FL™ E-40FL™ U-09LV™ 9460™	E-40FL™ E-90FL™ E-05CL™ 9460™	E-40FL™ E-05CL™ E-20HP™ 9433™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-05CL™ U-09LV™ 9460™
Glass	E-20NS™ E-30CL™ U-05FL™ 0151™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-00CL™ E-30CL™ U-05FL™ D609™	E-05CL™ U-05FL™ U-09LV™ 615™	E-30CL™ E-00CL™ U-09LV™ D609™	E-30CL™ E-20NS™ U-05FL™ 0151™	E-30CL™ E-00NS™ E-20HP™ 0151™	E-30CL™ E-40FL™ E-00CL™ D609™	E-40FL™ E-05CL™ U-09LV™ 615™	E-05CL™ E-40FL™ E-30CL™ 9460™
Ceramic	E-20NS™ E-30CL™ E-20HP™ 9430™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-20HP™ E-30CL™ 9433™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-30CL™ E-00CL™ U-05FL™ D609™	E-20HP™ E-30CL™ E-120HP™ 9433™	E-00NS™ E-20HP™ E-20NS™ 608™	E-20HP™ E-40FL™ E-00NS™ 608™	E-40FL™ E-05CL™ U-09LV™ 9460™	E-40FL™ E-05CL™ E-00CL™ D609™
Masonry	E-20NS™ E-20HP™ E-120HP™ 9433™	E-40FL™ E-20HP™ E-05CL™ 9433™	E-20HP™ E-120HP™ E-00CL™ D609™	E-40FL™ E-90FL™ E-05CL™ 615™	E-30CL™ E-00NS™ E-20HP™ 0151™	E-00NS™ E-20HP™ E-20NS™ 9433™	E-20HP™ E-00NS™ E-120HP™ 608™	E-20HP™ E-00NS™ E-40FL™ 9433™	E-05CL™ E-40FL™ U-05FL™ 9460™	E-05CL™ E-00CL™ E-20HP™ D609™
Wood	E-20HP™ E-40FL™ E-00NS™ 9433™	E-40FL™ E-05CL™ E-20HP™ 11C™	E-20HP™ E-40FL™ E-00NS™ 11C™	E-40FL™ E-05CL™ E-20HP™ 9433™	E-30CL™ E-40FL™ E-00CL™ 0151™	E-20HP™ E-40FL™ E-00NS™ 608™	E-20HP™ E-00NS™ E-40FL™ 608™	E-00CL™ E-20HP™ E-40FL™ 11C™	E-05CL™ E-40FL™ E-90FL™ 615™	E-00CL™ E-20HP™ E-40FL™ D609™
Leather	E-40FL™ U-05FL™ U-09LV™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-05CL™ U-09LV™ E-40FL™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-05CL™ U-09LV™ 9460™	E-40FL™ E-05CL™ U-09LV™ 9460™	E-05CL™ E-40FL™ U-05FL™ 615™	E-05CL™ E-40FL™ E-90FL™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-05CL™ E-40FL™ U-05FL™ 9460™
Paper/ Hardboard	E-40FL™ E-05CL™ E-00CL™ D609™	E-40FL™ E-05CL™ E-20HP™ 9433™	E-40FL™ E-05CL™ U-05FL™ 9460™	E-40FL™ E-05CL™ U-09LV™ 9460™	E-05CL™ E-40FL™ E-30CL™ 0151™	E-40FL™ E-05CL™ E-00CL™ D609™	E-05CL™ E-00CL™ E-20HP™ D609™	E-00CL™ E-20HP™ E-40FL™ 9460™	E-05CL™ E-40FL™ U-05FL™ 615™	E-05CL™ E-40FL™ E-00CL™ D609™

Thermoplastics: ABS, PC, Acrylic, Nylon, SAN, PVC

Thermoset Plastics: Epoxy, Phenolic, Polyester, DAP

Rubber: Butyl, Neoprene, Nitrile, SBR, Natural, EPDM

Loctite® brand adhesives are specified by the world's leading fiber optic component manufacturers. With the most diversified line of adhesives and sealants in the industry, Henkel offers Loctite® brand products to meet your specific needs. Whether you are manufacturing modulators, collimators, amplifiers, beam splitters, switches, etc., Henkel is the best resource for fiber optics assistance. Loctite® brand adhesives provide design advantages, speed assembly time, and increase production efficiency and quality.

BONDING

FIBER OPTIC ADHESIVES

Loctite® 3400™ OptiLOC® Fiber Optic Epoxy Adhesive

A low viscosity, fast curing epoxy. Once mixed, this two-part epoxy cures at room temperature or with heat to form a dark blue rigid potting and sealing material.

Loctite® 3401™ OptiLOC® Fiber Optic Epoxy Adhesive

A low viscosity, impact absorbing epoxy with enhanced dielectric properties. Designed for bonding optical connectors, fibers, lenses, and other optical components.

Loctite® 3402™ OptiLOC® Fiber Optic Epoxy Adhesive

A low viscosity, general purpose impact absorbing epoxy adhesive with an extended pot life and high glass transition temperature. Develops strong bonds to aluminum, ceramic, glass, and select plastics.

Loctite® 3403™ OptiLOC® Fiber Optic Epoxy Adhesive

A medium viscosity, impact absorbing epoxy adhesive with a moderate pot life. Once mixed, this two-part epoxy cures at room temperature or with heat to form an amber, rigid potting and sealing material.

Loctite® 661™ Anaerobic Adhesive


Slip Fit/UV Cure

A fast curing, high strength retaining compound. Achieves fixture strength in 5 minutes or in 15 seconds by exposing edge fillets to high intensity long wavelength UV light. Offers secondary room temperature cure for shadowed areas.

**LOCTITE® BRAND LIGHT CURE
ACRYLIC ADHESIVES
PROPERTIES CHART**

PRODUCT	Item Number	Container	Cure Type	Color	Viscosity, ¹ cP	% Transmission ² NIR / Visible	Modulus, ³ psi	Elongation, ³ %	Hardness ⁴ (Shore D)	Tg, °C ⁵	CTE, ⁶ ppm/°C	Refractive Index ⁷	Linear Shrinkage, ⁸ %
3345™	33417	25 ml syringe	UV/visible	Clear/straw	1,500	>95 / >90	37,000	250	53	53	95	1.5	1.9
3491™	28366	25 ml syringe	UV	Clear/straw	1,100	>90 / >90	288,000	27	75	63	100	1.51	1.98
3492™	28367	25 ml syringe	UV	Clear/straw	500	>90 / >90	200,000	5	79	64	90	1.51	1.93
3526™	30756	25 ml syringe	UV/visible/heat	Clear/straw	17,800	>90 / >90	42,000	185	62	64	110	1.51	2.14

**LOCTITE® BRAND EPOXY ADHESIVES
PROPERTIES CHART**

PRODUCT	Item Number	Container	Cure Type	Color	Viscosity, ¹ cP	% Transmission ² NIR / Visible	Modulus, ³ psi	Hardness ⁴ (Shore D)	Tg, °C ⁵	CTE, ⁶ ppm/°C	Refractive Index ⁷	Linear Shrinkage, ⁸ %
0151™ Hysol®	83176	EPK 3.3 oz. kit	Rt 2 pt	Clear	70,000/60,000	>95 / >90	300,000	85	84*	70	1.56	1.6
3337™	36057	25 ml syringe	Flexible cationic	Clear	5,000	>85	6,000	55	35	62	1.55	1.3
3340™ 	36906	25 ml syringe	Rigid cationic	Slightly hazy	5,000	>85	310,000	90	114	58	1.54	1.6
3400™ OptiLOC®	32545	2.5 gram twin-pak	Rt 2 pt	Blue	3,500/2,400	>90 / NA	290,000	85	122*	54	NA	1.7
3401™ OptiLOC®	32546	2.5 gram twin-pak	Rt 2 pt	Blue	8,300/80	>90 / NA	275,000	84	89*	63	NA	1.7
3402™ OptiLOC®	32547	2.5 gram twin-pak	Heat 2 pt	Red/amber	2,000/400	>95 / NA	340,000	90	120*	56	NA	1.5
3403™ OptiLOC®	32550	2.5 gram twin-pak	Rt 2 pt	Amber	79,000/29,000	>90 / >85	290,000	90	80*	73	NA	1.7

* Optimal Cure Conditions.

**LOCTITE® BRAND ANAEROBIC
ADHESIVES PROPERTIES CHART**

PRODUCT	Item Number	Container	Cure Type	Color	Viscosity, ¹ cP	Shear Strength Steel/Steel, psi	Temperature Range
661™	66141	250 ml bottle	UV/primer/heat	Amber	500	3,500	65°F to 300°F


**LOCTITE® BRAND SILICONE
ADHESIVES PROPERTIES CHART**

PRODUCT	Item Number	Container	Cure Type	Color	Viscosity, ¹ cP	% Transmission ² NIR / Visible	Hardness ⁴ (Shore A)	Tg, °C ⁵	CTE, ⁶ ppm/°C
3407™ OptiLOC®	35173	30 ml syringe	Heat	Black	125 g/min*	NA	33	-48	275

* Extrusion Rate.

KEY

- 1 - Brookfield, 25°C
- 2 - ASTM E 1790 NIR (1000-2000 nm)
- Loctite® ARM 1122 VIS (420-1000 nm)
- 3 - ASTM D 882
- 4 - ASTM D 2240
- 5 - ASTM E 1545
- 6 - ASTM E 831, pre Tg
- 7 - ASTM D 542
- 8 - ASTM D 792
- 9 - ASTM E 831, post Tg

 Indicates worldwide availability.

**See the Equipment Section for a full line of
Loctite® brand Dispensing and Curing systems.**



Loctite® brand 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. Hysol® Hot Melts are ideal for applications that require high speed manufacturing, bonding versatility, very large gap filling, fast green strength, and minimal shrinkage. Hysol® Hot Melts are solvent-free, environmentally friendly materials with no harmful VOCs.

BONDING

HOT MELT ADHESIVES

Loctite® 3631™ Hysol® Hot Melt Adhesive

Urethane

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

Loctite® 3651™ Hysol® Hot Melt Adhesive

Polyolefin

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

Loctite® 7460™ Hysol® SprayPac® Polyshot™ Hot Melt Adhesive

Polyamide

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

Polyamide

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

Loctite® 7809FR™ Hysol® Hot Melt Adhesive

Polyamide

Modified with fire retardant materials. It has a UL 94V-0 flammability rating.

Loctite® 7811™ Hysol® Hot Melt Adhesive

Polyamide

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

Loctite® 7901™ Hysol® Hot Melt Adhesive

Polyamide

Low viscosity polyamide used extensively for potting and encapsulating.

Loctite® 1X™ Hysol® Hot Melt Adhesive

EVA Based

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

Loctite® 3X™ Hysol® Polyshot™ Hot Melt Adhesive

EVA Based

Used extensively for bonding sand molds and other porous substrates.

Loctite® 232™ Hysol® Hot Melt Adhesive

EVA Based

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

Loctite® 236™ Hysol® Hot Melt Adhesive

EVA Based

Clear, toughened, flexible EVA based adhesive with superior wetting properties.

Loctite® 1942™ Hysol® Hot Melt Adhesive

EVA Based

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

Loctite® 0420™ Hysol® SprayPac® Polyshot™ Hot Melt Adhesive

EVA Based

Formulated for spray applications. Has an open time of 2 minutes when sprayed and 45 seconds when bead applied.

Loctite® 0430™ Hysol® SprayPac® Polyshot™ Hot Melt Adhesive

EVA Based

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

EVA Based

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

Loctite® 0450™ Hysol® SprayPac® Polyshot™ Hot Melt Adhesive

EVA Based

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

Loctite® 0452™ Hysol® SprayPac® Hot Melt Adhesive

EVA Based

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

Loctite® CoolMelt™ Hysol® Hot Melt Adhesive

EVA Based

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

Loctite® QuikPac™ Hysol® Hot Melt Adhesive

EVA Based

Fast setting material with a 15 second open time.

Loctite® SuperPac™ Hysol® Hot Melt Adhesive

EVA Based

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

Loctite® WaxPac™ Hysol® Hot Melt Adhesive

EVA Based

Medium setting flexible based material formulated to bond wax coated substrates and withstand low temperatures.

ADDITIONAL OFFERINGS

For related dispensing equipment, see pages 108–110 in the Equipment section of this catalog.



**LOCTITE® BRAND HYSOL® HOT MELT
ADHESIVES PROPERTIES CHART**


PRODUCT	Item Number	Container	Color	Viscosity cP at Dispense Temperature	Tensile Strength, psi	Open Time	Temperature Resistance	% Elongation	Hardness (Shore A)	Agency Approvals
1X™ Hysol®	83357	Sample 5 lb. pellets	Light yellow	2,000	370	15 seconds	150°F	90	-	FDA CFR175.105
	83358	40 lb. carton pellets								
	83359	Maxistick™ sample 7 oz. bag								
	83360	Maxistick™ 35 lb. carton								
	83362	PT™ stick 35 lb. carton								
	83364	Superstick™ sample 10" 5 oz. bag								
	83365	Superstick™ 10" 25 lb. carton								
	83367	Polyshot™ 12 oz. bag								
83368	Polyshot™ 35 lb. carton									
3X™ Hysol®	83369	Polyshot™ sample 12 oz. bag	-	4,000	580	60 seconds	135°F	300	-	FDA CFR175.105
	83370	Polyshot™ 35 lb. carton								
342™ Hysol®	83255	Polyshot™ 35 lb. carton	-	8,250	800	5 seconds	166°F	60	-	FDA CFR175.105
740™ Hysol®	83260	Superstick™ sample 10" 5 oz. bag	-	9,000	750	10 seconds	168°F	75	-	FDA CFR175.105
	83261	Superstick™ 10" 25 lb. carton								
	83263	Polyshot™ sample 12 oz. bag								
	83264	Polyshot™ 35 lb. carton								
O420™ Hysol® SprayPac®	83346	12 oz. Polyshot™ sample bag	Cream	10,500	-	2 minutes sprayed	153°F	-	-	-
O430™ Hysol® SprayPac®	83348	Polyshot™ 12 oz. sample bag	Cream	5,000	280	3.5 minutes sprayed	170°F	-	75	-
	83349	Polyshot™ 35 lb. carton								
O430™ Red Hysol® SprayPac®	83350	Polyshot™ 12 oz. sample bag	Pink	5,000	280	3.5 minutes sprayed	170°F	-	75	-
	83351	Polyshot™ 35 lb. carton								
O437™ Hysol® SprayPac®	83256	21 lb. carton pucks	Cream	5,200	270	3.5 minutes sprayed	170°F	-	75	-
	83352	36 lb. carton bricks								
O450™ Hysol® SprayPac®	83353	Polyshot™ 12 oz. sample bag	Natural	4,500	-	5-8 minutes	156°F	-	-	-
	83354	Polyshot™ 35 lb. carton								
O450™ Red Hysol® SprayPac®	83355	Polyshot™ 12 oz. sample bag	Pink	4,500	-	5-8 minutes	156°F	-	-	-
	83356	Polyshot™ 35 lb. carton								
O452™ Hysol® SprayPac®	83257	21 lb. SprayPac® pucks	Natural	4,300	-	5-8 minutes	156°F	-	-	-
1942™ Hysol®	83266	5 lb. sample bag pellets	Tan	5,000	250	30 seconds	142°F	500	-	FDA CFR175.105
	83267	40 lb. carton pellets								
	83268	Maxistick™ sample 7 oz. bag								
	83269	Maxistick™ 35 lb. carton								
	83271	PT™ stick 35 lb. carton								
	83272	Ministick™ 35 lb. carton								
	83273	Superstick™ sample 10" 5 oz. bag								
	83274	Superstick™ 10" 25 lb. carton								
	83275	Superstick™ 4" 25 lb. carton								
	83276	Polyshot™ sample 12 oz. bag								
	83277	Polyshot™ 35 lb. carton								
6002™ Hysol®	83280	PT™ stick sample 8 oz. bag	Amber	3,500	700	10 seconds	150°F	200	-	FDA CFR175.105
	83283	Superstick™ 10" 25 lb. carton								
	83285	Polyshot™ 35 lb. carton								
CoolMelt™ Hysol®	83393	CoolMelt™ Maxistick™ sample 7 oz. bag	Off white	7,200	195	15 seconds	140°F	800	-	FDA CFR175.105
	83394	CoolMelt™ Maxistick™ 35 lb. carton								
SuperPac™ Hysol®	83402	Maxistick™ sample 7 oz. bag	Light yellow	5,750	280	30 seconds	144°F	200	-	FDA CFR175.105
	83403	Maxistick™ 35 lb. carton								
	83404	Polyshot™ sample 12 oz. bag								
	83405	Polyshot™ 35 lb. carton								
QuikPac™ Hysol®	83395	Sample pellets 5 lb. bag	Light yellow	4,645	-	15 seconds	174°F	-	-	FDA CFR175.105
	83397	Maxistick™ sample 7 oz. bag								
	83398	Maxistick™ 35 lb. carton								
	83399	Polyshot™ sample 12 oz. bag								
	83400	Polyshot™ 35 lb. carton								
WaxPac™ Hysol®	83408	Maxistick™ sample 7 oz. bag	-	2,700	730	30 seconds	150°F	-	-	FDA CFR175.105
	83410	Polyshot™ sample 12 oz. bag								

**LOCTITE® BRAND HYSOL® HOT MELT
ADHESIVES PROPERTIES CHART**

PRODUCT	Item Number	Container	Color	Viscosity cP at Dispense Temperature	Tensile Strength, psi	Open Time	Temperature Resistance	% Elongation	Hardness (Shore A)	Agency Approvals
232™ Hysol®	83237	5 lb. sample bag pellets	Clear	11,000	-	15 seconds	153°F	-	-	FDA CFR175.105
	83239	40 lb. carton pellets								
	83241	Maxistick™ 35 lb. carton								
	83244	Superstick™ 10" sample 5 oz. bag								
	83245	Superstick™ 10" 25 lb. carton								
	83246	Polyshot™ sample 12 oz. bag								
83247	Polyshot™ 35 lb. carton									
236™ Hysol®	83251	Superstick™ sample 10" 5 oz. bag	Clear	8,500	213	25 seconds	140°F	450	-	FDA CFR175.105
	83252	Superstick™ 10" 25 lb. carton								
740LV™ Hysol®	83373	40 lb. carton pellets	-	3,500	700	10 seconds	215°F	80	-	FDA CFR175.105
	83374	Polyshot™ 35 lb. carton								
3631™ Hysol®	31291	300 ml cartridge	Off white	12,000	1,800	60 seconds	250°F	940	91	-
	31279	5 gallon pail								
3651™ Hysol®	31303	12 kg squares	Beige	10,000	334	80-100 seconds	266°F	790	55	-
4046™ Hysol®	83278	Polyshot™ sample 12 oz. bag	Cream	19,000	120	60 seconds	120°F	1400	40	-
	83279	Polyshot™ 35 lb. carton								
7460™ Hysol® SprayPac®	83308	Polyshot™ 25 lb. pail	Pale/Amber	6,700	-	30 seconds	210°F	-	-	-
7500™ Hysol® SprayPac®	83312	Polyshot™ sample 13 oz. bag	Pale/Amber	1,900	-	2 minutes	200°F	-	-	-
	83313	Polyshot™ 25 lb. pail								
7803™ Hysol®	83323	Polyshot™ 25 lb. pail	Amber	1,450	380	20 seconds	248°F	-	-	-
7804™ Hysol®	83325	5 lb. bag sample pellets	Amber	7,500	340	35 seconds	220°F	900	74	-
	83326	40 lb. carton pellets								
	83327	Superstick™ sample 10" 5 oz. bag								
	83328	Superstick™ 10" 32 lb. carton								
	83329	Polyshot™ sample 13 oz. bag								
	83330	Polyshot™ 25 lb. pail								
7804FRM-HV™ Hysol®	83382	40 lb. carton pellets	Off white	6,000	245	35 seconds	220°F	300	-	UL Listed for U.S.
	83383	Superstick™ 10" sample 5 oz. bag								
	83384	Superstick™ 10" 30 lb. pail								
	83386	Polyshot™ sample 13 oz. bag								
	83387	Polyshot™ 25 lb. pail								
7809FR™ Hysol®	83388	5 lb. bag sample pellets	Amber	7,000	363	35 seconds	240°F	373	85	-
	83390	Superstick™ sample 10" 13 oz. bag								
	83391	Polyshot™ 13 oz. bag								
7811™ Hysol®	83337	5 lb. bag sample pellets	Amber	6,400	400	35 seconds	266°F	1,200	-	-
	83339	Polyshot™ sample 13 oz. bag								
	83340	Polyshot™ 25 lb. pail								
7901™ Hysol®	83341	5 lb. bag sample pellets	Amber	750	260	35 seconds	300°F	80	84	-
	83342	40 lb. carton pellets								
	83343	Polyshot™ sample 13 oz. bag								
	83344	Polyshot™ 25 lb. pail								

**LOCTITE® BRAND HYSOL® HOT MELT STICK
SIZE/DIAMETER CHART**

Description	Diameter	Lengths	Loctite® Brand Applicators by Item #
Superstick™	.50"	4" & 10"	98030, 98031, 98032, 98029
Maxistick™	.75"	2.4"	98033, 98034
Polyshot™	1.75"	1.5"	98035, 98036, 98040, 98037, 98041



Versatile Loctite® brand ultraviolet (UV) and visible light curing 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.

BONDING

LIGHT CURE ADHESIVES

ACRYLIC ADHESIVES

Loctite® 352™ **Light Cure Adhesive**

A high viscosity adhesive that creates a tough, flexible bond 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.

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 Acrylic

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

Loctite® 3525™ Light Cure Adhesive

A visible/UV 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 Acrylic

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

CYANOACRYLATE ADHESIVES



Loctite® 4306™/4307™ Flashcure® Light Cure Adhesive

Instant

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.

EPOXY ADHESIVES

Loctite® 3335™ Light Cure Adhesive

UV Cationic Epoxy

A one-part, medium viscosity, cationic epoxy. Excellent for surface cure – no oxygen inhibition. Low outgassing, very good high temperature resistance. Rigid, low shrinkage.

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® 3337™ Light Cure Adhesive

UV Cationic Epoxy

A one-part, flexible, medium viscosity cationic epoxy. Excellent for surface cure with low shrinkage and low outgassing. Use for bonding, coating, tacking applications on metal, plastic, or glass substrates.

Loctite® 3340™ Light Cure Adhesive

UV Cationic Epoxy

A one-part, rigid, medium viscosity cationic epoxy. Exhibits good thermal, water, and chemical resistance with metal, plastic and glass substrates.

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® BRAND LIGHT CURE
ACRYLIC ADHESIVES
PROPERTIES CHART



PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Brookfield, 25°C	Elongation at Break, %	Shore Hardness	Temperature Range
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
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
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
366™ 	36631 12224	50 ml bottle 1 liter bottle	Clear/ light amber	Ultraviolet, heat, activator	Glass, metal	7,500	240	D 45	-65°F to 230°F
3100™ 	19862	25 ml syringe	Slightly hazy/ straw	Ultraviolet, visible	Glass, metal, thermoset plastic	6,000	210	D 66	-65°F to 300°F
3101™ 	19861	25 ml syringe	Slightly hazy/ straw	Ultraviolet, visible, heat, activator	Glass, metal, thermoset plastic	6,000	220	D 66	-65°F to 300°F
3102™ 	23690	1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Polycarbonate, thermoplastic	3,750	265	D 59	-65°F to 300°F
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
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
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
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
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
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
3175™	29505 29506	25 ml syringe 1 liter bottle	Clear/ straw	Ultraviolet	Various	4,000	14	D 70	-65°F to 300°F
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
3492™	28367 18666	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet	Glass, metal	500	5	D 79	-65°F to 300°F
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
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
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
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
3751™ LiteTak®	21362 21363	25 ml syringe 1 liter bottle	Clear/ colorless	Ultraviolet	Various	10,000	50	D 73	-65°F to 275°F
3761™ LiteTak®	21359 21360	25 ml syringe 1 liter bottle	Clear/ straw	Ultraviolet	Various	2,500	57	D 69	-65°F to 275°F

 Indicates worldwide availability.



LOCTITE® BRAND LIGHT CURE ADHESIVES (CYANOACRYLATE) PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Brookfield, 25°C	Elongation at Break, %	Shore Hardness	Temperature Range
4304™ Flashcure®	32254 32407	1 oz. bottle 1 lb. bottle	Clear/ pale green	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	20	9	D 72	-65°F to 180°F
4305™ Flashcure®	32268 32409	1 oz. bottle 1 lb. bottle	Clear/ pale green	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	900	6	D 77	-65°F to 180°F
4306™ Flashcure® NEW	37439 37442	1 oz. bottle 1 lb. bottle	Clear/pale green/ fluorescent	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	20	9	D 72	-65°F to 180°F
4307™ Flashcure® NEW	37441 37443	1 oz. bottle 1 lb. bottle	Clear/pale green/ fluorescent	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	900	6	D 77	-65°F to 180°F

LOCTITE® BRAND LIGHT CURE ADHESIVES (EPOXY) PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Brookfield, 25°C	Elongation at Break, %	Shore Hardness	Temperature Range
3335™	30288 30289	25 ml syringe 1 liter bottle	Clear/ colorless	Ultraviolet, cationic	Metal, glass, thermoplastic	6,000	2	D 84	-65°F to 325°F
3336™	31064 31065	42 ml dual cartridge 400 ml dual cartridge	Clear/ light amber	Ultraviolet, room temperature, heat	Metal, thermoplastic	14,500	6	D 79	-65°F to 350°F
3337™ 	36057 36058*	25 ml syringe 1 liter bottle	Clear	Ultraviolet, cationic	Metal, glass	5,000	7	D 80	-65°F to 350°F
3340™ 	36906 36907*	25 ml syringe 1 liter bottle	Transparent	Ultraviolet, cationic	Metal, glass	6,000	5	D 83	-65°F to 350°F

LOCTITE® BRAND LIGHT CURE ADHESIVES (SILICONE) PROPERTIES CHART

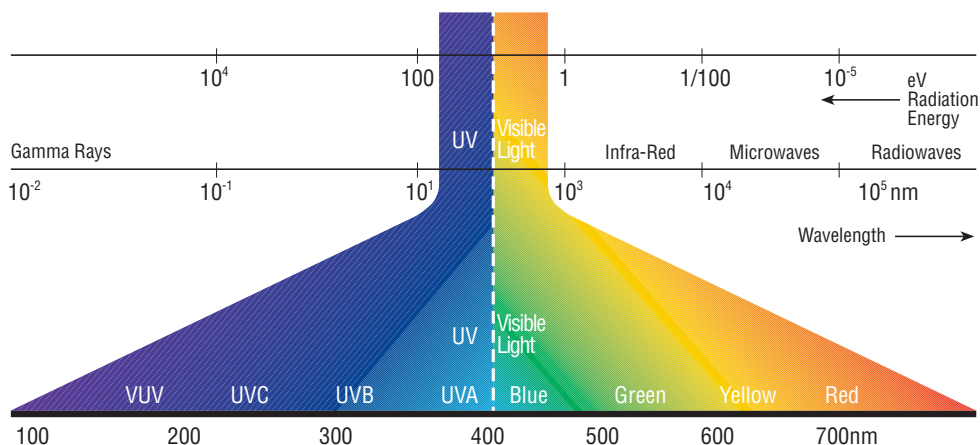
PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Brookfield, 25°C	Elongation at Break, %	Shore Hardness	Temperature Range	Agency Approvals
5031™ Nuva-Sil® NEW	40086 40087	300 ml cartridge 40 lb. pail	Translucent	Visible/ultraviolet, moisture, acetoxo	Glass, metal, ceramic	5,500	100	A 34	-65°F to 350°F	-
5033™ Nuva-Sil® NEW	40088 40089	300 ml cartridge 40 lb. pail	Translucent/ colorless/ fluorescent	Visible/ultraviolet, moisture, acetoxo	Glass, metal, ceramic	145 gm/min.†	170	A 55	-65°F to 350°F	-
5083™ Nuva-Sil® 	17528 17635	300 ml cartridge 40 lb. pail	Translucent/ colorless	Ultraviolet, moisture, acetoxo	Glass, metal, ceramic	145 gm/min.†	170	A 55	-65°F to 350°F	UL Classified for U.S.
5091™ Nuva-Sil® 	17412 18074	300 ml cartridge 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.

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

* Made-to-order item.

 Indicates worldwide availability.

The Electromagnetic Spectrum



GASKETING

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, which are applied as a liquid by tracing machines in precise beads to one of the flanges and cured by ultraviolet (UV) light, 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 to achieve the required sealing performance on a wide range of flanges. The following chart will work best when selecting the right gasket type. This 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 to help narrow your search.

This chart should not be used to specify gasket materials without specific testing. It is recommended that you conduct on-part testing to ensure adhesive performance before specifying any Loctite® brand gasketing product.

Henkel Adhesives and Sealants Specialists are available to assist you with new flange designs, or to help you re-engineer an existing application using Loctite® brand products 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 and select "Contact Loctite."

GENERAL COMPARISON	GASKET TYPE		
	Form-in-Place Anaerobic	Form-in-Place Silicone	Cure-in-Place Silicone
Benefits	Improve Structural Strength Long Open Time High Pressure Seals	High Gap Filling Resistant to Dynamic Fatigue On-line Pressure Testing	High Gap Filling Reusable/Serviceable Gasket Immediate Full Properties
Limitations	Gap Fill	Short Open Time	Requires Process Equipment
PERFORMANCE CONSIDERATIONS			
Temperature Resistance Continuous Operation Maximum	-40°F to +300°F +400°F	-60°F to +400°F +500°F	-60°F to +400°F +500°F
Fluid Resistance Oil Water/Glycol Fuel Transmission Fluid	Yes Yes Limited Yes	Yes Yes No Yes	Yes Yes No Yes
Gap Fill Ideal Maximum	0.001" - 0.005" 0.050"	0.001" - 0.125" 0.240"	0.020" - 0.125" 0.240"
Instant Seal	Low Pressure	Low Pressure	High Pressure
Flange Type	Rigid	Rigid or Flexible	Rigid or Flexible
Suitable for Use With Metals Plastics ¹	Yes No	Yes Yes	Yes Yes
PROCESS CONSIDERATIONS			
Number of Components	1	1	1
Cure Method	Anaerobic	RTV	UV/RTV
Cure Temperature	Room Temperature	Room Temperature	Room Temperature
Cure Speed Initial Cure Full Cure	15 - 30 minutes 24 - 72 hours	15 - 30 minutes 24 hours - 7 days	15 - 30 seconds 30 seconds
Processing Options Manual Automated	Yes Yes	Yes Yes	No Yes
For more information on each Adhesive Category, refer to the following pages...	34 - 35	36 - 37	36 - 37

¹ 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 for more information.



Anaerobic gasketing technology has revolutionized the sealing of flanges in the automotive industry, in the assembly of heavy equipment, and in the manufacture of various types of fluid power equipment.

Loctite® brand 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.

GASKETING

ANAEROBIC

Loctite® 504™ Gasket Eliminator® Flange Sealant

Gap Filling

A single-component, instant, low pressure seal 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 easy visual inspection during assembly.

Loctite® 510™ Gasket Eliminator® Flange Sealant

High Temperature

Product has a temperature range to 400°F with excellent solvent and chemical resistance. 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 .050" gap. Flexes with flanges that 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.

New semi-solid anaerobic gasketing QuickStix™ are available! See pages 84, 86 & 87 for more details.

LOCTITE® BRAND GASKETING PRODUCTS PROPERTIES CHART

PRODUCT	Item Number	Container	Typical Use	Color	Gap Fill	Cured State	Viscosity, cP	Temperature Range	Cure Speed	Recommended Primer	Specific Gravity	Agency Approvals
504™ Gasket Eliminator®	50441 50480	250 ml tube 300 ml cartdg.	Gap filling	Orange	Unprimed - .030" Primed - .050"	Rigid	500,000/ 1,200,000 Thixotropic	-65°F to 300°F	Unprimed - 4 to 24 hrs. Primed - 30 min. to 4 hrs.	NF™	1.08	-
509™ Gasket Eliminator®	21525 50965	300 ml cartdg. 850 ml cartdg.	Very flexible	Blue	Unprimed - .010" Primed - .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	-
510™ Gasket Eliminator®	51031 51041 51074	50 ml tube 250 ml tube 300 ml cartdg.	High temp. applications Excellent solvent resistance	Red	Unprimed - .010" Primed - .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.
515™ Gasket Eliminator®	51517 51531 51580	6 ml tube 50 ml tube 300 ml cartdg.	For flexible applications	Purple	Unprimed - .010" Primed - .050"	Flexible	275,000/ 950,000 Thixotropic	-65°F to 300°F	Unprimed - 1 to 12 hrs. Primed - 15 min. to 2 hrs.	N™	1.10	UL Classified for U.S.
518™ Gasket Eliminator®	22423 22424 51817 51831 51845	Kit Kit 6 ml tube 50 ml tube 300 ml cartdg.	For all metals including aluminum flanges	Red	Unprimed - .010" Primed - .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
549™	54941	250 ml tube	Instant seal plastic gasket	Orange	Unprimed - .020" Primed - .050"	Rigid	22,500	-65°F to 300°F	Unprimed - 6 to 24 hrs. Primed - 2 hrs. to 24 hrs.	N™ or T™	1.25	-
568™	56841	250 ml tube	Plastic gasket	Orange	Unprimed - .015" Primed - .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	-
573™	26392	250 ml tube	Slow curing for extended assembly operations	Green	Unprimed - .010" Primed - .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	-
574™	24018 26338	50 ml tube 250 ml tube	Fast curing, large gaps	Orange	Unprimed - .010" Primed - .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	-
5127™	17430	300 ml cartdg.	For flexible applications, high elongation	Blue	Unprimed - .010" Primed - .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	-
5182™	18010	850 ml cartridge	Robotic application on flanges, seals, covers	Red	Unprimed - .010" Primed - .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	-

 Indicates worldwide availability.



Loctite® brand 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.

GASKETING

SILICONE

FORM-IN-PLACE

Loctite® 5699™ Flange Sealant

*Grey High Performance
RTV Silicone Gasket Maker*

For rigid flange assemblies. Excellent fluid resistance. Easy to dispense, non-corrosive, 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. Non-corrosive, low odor, low volatility. Black in color.

NEW

Loctite® 5905™ Flange Sealant

RTV Silicone

Superior flexibility and adhesion, fast depth of cure. Offers excellent fluid resistance.

Loctite® 5910® Flange Sealant

RTV Silicone

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

Loctite® 5920™ Flange Sealant

*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. Non-corrosive, low odor, low volatility. Grey in color.

CURE-IN-PLACE

Loctite® 5950™/5951™ Fastgasket® Flange Sealant

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. Clear in color.

**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® 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.

For the name and number of your nearest distributor, call: 1-800-LOCTITE (562-8483)
Or visit us on the web at: www.loctite.com

LOCTITE® BRAND FORM-IN-PLACE SILICONE FLANGE SEALANTS PROPERTIES CHART

PRODUCT	Item Number	Container	Typical Use	Color	Gap Fill	Extrusion Rate, gm/min.	Temperature Range (intermittant)	Cure Method	Cure Speed*	Specific Gravity	Durometer**	% Elongation	Tensile Strength, psi†	Agency Approvals
5699™	18718 18581 18582 18583	70 ml tube 300 ml cartridge 50 lb. pail 550 lb. drum	Oil/water resistant	Grey	.250"	250	-75°F to 625°F	Moisture	Tack free - 30 min. Full cure - 24 hrs.	1.45	55	160	435	-
5900®	20166 20167 20168	300 ml cartridge 50 lb. pail 550 lb. drum	High adhesion, instant seal	Black	.250"	35	-65°F to 500°F	Moisture	Tack free - 20 min. Full cure - 24 hrs.	1.34	35	550	200	CFIA, NSF P1
5905™	38535 36923	300 ml cartridge 50 lb. pail	High adhesion, fast depth of cure	Black	.240"	350	-65°F to 500°F	Moisture	Tack free - 20 min. Full cure - 24 hrs.	1.30	39	345	270	-
5910®	21746 21747 21748	300 ml cartridge 50 lb. pail 550 lb. drum	High adhesion	Black	.240"	600	-65°F to 500°F	Moisture	Tack free - 20 min. Full cure - 24 hrs.	1.34	30	550	200	-
5920™	30542 82046 21472	70 ml tube 300 ml cartridge 40 lb. pail	High temperature	Copper	.240"	>300	-65°F to 700°F	Moisture	Tack free - 60 min. Full cure - 24 hrs.	1.05	31	355	275	-
5999™	21744 28298 20170	300 ml cartridge 50 lb. pail 550 lb. drum	Oil/water resistant, instant seal	Grey	.240"	105	-75°F to 625°F	Moisture	Tack free - 10 min. Full cure - 24 hrs.	1.45	60	175	500	-

* Varies with substrates. ** Shore A. † Grit blasted steel. Indicates worldwide availability.

LOCTITE® BRAND FASTGASKET® CURE-IN-PLACE SILICONE FLANGE SEALANTS PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Extrusion Rate, gm/min.	Cure Method	Cure Speed*	Hardness	% Elongation	Tensile Strength, psi	Agency Approvals
5950™ Fastgasket®	29287 18495	300 ml cartridge 40 lb. pail	Black	350	UV/ moisture	30 seconds @ 120 mW/cm ²	30	200	150	UL Classified for U.S.
5951™ Fastgasket®	18198	40 lb. pail	Clear	350	UV/ moisture	30 seconds @ 120 mW/cm ²	30	200	150	-
5960™ Fastgasket®	31132 24707	300 ml cartridge 40 lb. pail	Clear	350	UV	30 seconds @ 120 mW/cm ²	50	260	600	-

* Varies with substrates. Indicates worldwide availability.

LOCTITE® BRAND PROCURE® CURE-IN-PLACE GASKETS PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Extrusion Rate, gm/min.	Cure Method	Cure Speed*	Hardness	% Elongation	Tensile Strength, psi
5963™ Procure®	34337	50 lb. pail	Grey	250	Heat	10 minutes @150°C	50	360	620
5964™ Procure®	34347 34348	50 lb. pail 300 ml cartridge	Brown	120	Heat/ microwave	10 minutes@150°C/ VFM 2-4 minutes	32	530	635

* Varies with substrates.

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 125°C. If a soft, flexible material is needed, particularly at low temperatures, then a urethane, a silicone or a 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.

Henkel Adhesives and Sealants Specialists are available to assist you with new product designs, or to help you re-engineer an existing application using Loctite® brand products 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 and select "Contact Loctite."

PERFORMANCE CONSIDERATIONS	POTTING & ENCAPSULATING COMPOUNDS			
	Hot Melts	Urethanes	Epoxies	Silicones
Benefits	Fast, large gap filling	Excellent toughness/ flexibility	Wide range of formulations	Excellent temperature resistance
Limitations	Low heat resistance	Liquid adhesive sensitive to moisture	Mixing required	Low strength
Temperature Resistance	-65°C to +125°C	-65°C to +125°C	-65°C to +180°C	-65°C to +200°C
Environmental Resistance Polar Solvents¹ Non-Polar Solvents²	Good (Polyolefins, Polyamides) Good (Polyamides)	Good Good	Very Good Excellent	Good Poor
Hardness	Semi-Soft	Soft	Rigid	Soft
Flexibility	High	High	Low	Very High
Tg	Low	Low	High	Very Low
PROCESS CONSIDERATIONS				
Number of Components	1	2	2	1
Cure Temperature	Room Temperature (applied at elevated temperature)	Room Temperature	Room Temperature	UV/Room Temperature
Gel Time Average Fastest	60 seconds 10 - 20 seconds	1 - 3 hours 15 minutes	1 - 3 hours 15 minutes	30 seconds 5 seconds
Full Cure Time	1 hour (or when cooled)	24 hours	24 hours	24 hours
Depth of Cure	Unlimited	Unlimited	Unlimited	Shallow (<0.375")
Dispensing/Curing Equipment Required?	Yes	Yes	Yes	Yes
Light Cure Versions Available?	No	No	Yes	Yes
For more information on each Category, refer to the following pages...	44	40, 41, 44	40, 42-44	45

¹ Examples of Polar Solvents: Water, Ethylene Glycol, IPA, Acetone.

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



There are a variety of Loctite® brand potting and encapsulating compounds to choose from – epoxy, hot melt, polyurethane, and silicone.

Loctite® brand 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® brand potting and encapsulating compounds prevents corrosion and ensures long-term integrity of electrical devices.

POTTING & ENCAPSULATING

EPOXIES, POLYURETHANES, HOT MELTS & SILICONES

EPOXY & POLYURETHANE COMPOUNDS

Loctite® brand 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 resin can be combined with any hardener within the same color region to create a mixed system.

Epoxy Resin	Key Features	Epoxy Hardener	Key Features
3140™	General Purpose	3162™	Fast Cure
3141™	High Temperature	3163™	Excellent Adhesion
3142™	Thermally Conductive	3164™	General Purpose
3144™	Flame Retardant	3165™	Low Shrinkage

Polyurethane Resin	Key Features	Polyurethane Hardener	Key Features
3173™	General Purpose	3182™	Fast Cure
		3183™	General Purpose
		3184™	Flame Retardant

	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 min. at 300 g	20-40 min. at 105 g	45 min. at 300 g
Gel Time			
73°F (23°C)	14 min. at 300 g	40-70 min. at 105 g	150 min. at 300 g
Cure Cycle			
Normal 73°F (23°C)	90 min.	24 hrs.	24 hrs.
Alternate 185°F (85°C)	30 min.	1-3 hrs.	1-3 hrs.
Mix Ratio			
By Weight, Resin to Hardener	13:87	30:70	15:85
By Volume, Resin to Hardener	1: 5.2	1:3	1:4.8
Color			
Resin	dk. 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 OO	—	—	—
Tg, °C	-10	-16	-15
CTE above Tg, m/mm°C	128x10e-6	190x10e-6	151x10e-6
Typical Electrical 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
1.0 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	—	—	94V-Øat3/8"
UL File No. E106917			94V-2at1/4"

Refer to page 44 for Hysol® package sizes and ordering information.

System Characteristics	Epoxy System 3140™				Epoxy System 3141™			
	3140™/3162™	3140™/3163™	3140™/3164™	3140™/3165™	3141™/3162™	3141™/3163™	3141™/3164™	3141™/3165™
Typical Uncured Properties								
Viscosity, cP								
Resin	11,000	11,000	11,000	11,000	80,000	80,000	80,000	80,000
Hardener	120	450	105	55	120	450	105	55
Mixed	2,000	1,500	1,500	2,000	5,000	4,000	6,000	13,000
Working Time 77°F(25°C)								
	5-10 min. at 100 g	80-100 min. at 200 g	10-15 min. at 400 g	60-90 min. at 400 g	5 min. at 200 g	30-45 min. at 200 g	10 min. at 400 g	35-40 min. at 200 g
Gel Time 77°F(25°C)								
	10-15 min. at 100 g	2.5-3 hrs. at 200 g	25-35 min. at 400 g	2-3 hrs. at 400 g	10-15 min. at 200 g	60-80 min. at 200 g	20-25 min. at 200 g	65-75 min. at 200 g
Cure Cycle								
Normal 77°F(25°C)	16 hrs.	24 hrs.	16 hrs.	24 hrs./77°F +4 hrs./200°F	24 hrs.	24 hrs.	24 hrs.	24 hrs./77°F +4 hrs./200°F
Alternate 150°F(66°C)	1 hrs.	2 hrs.	2 hrs.	NA	2 hrs.	2 hrs.	2 hrs.	NA
Mix Ratio								
By Weight	100:18.1	100:29	100:29.5	100:9	100:19.8	100:30	100:31.5	100:9
By Volume	3.6:1	2:1	2:1	6.5:1	3:1	2:1	2:1	6.5:1
Color								
Resin	black	black	black	black	black	black	black	black
Hardener	clear	clear	clear	clear	clear	amber	amber	clear
Mixed	black	black	black	black	black	black	black	black
Specific Gravity								
Resin	1.64	1.64	1.64	1.64	1.61	1.61	1.61	1.61
Hardener	0.99	0.96	0.97	0.96	0.99	0.96	0.97	0.96
Mixed	1.48	1.41	1.42	1.55	1.46	1.40	1.40	1.40
Typical Cured Properties								
Hardness, Shore D								
	80	80	70	85	90	80	85	85
Tg, °C								
	35	20	27	67	75	38	31	104
CTE above Tg, mm/mm°C								
	125x10e-6	133x10e-6	150x10e-6	119x10e-6	135x10e-6	138x10e-6	111x10e-6	115x10e-5
CTE below Tg, mm/mm°C								
	37.5x10e-6	44.9x10e-6	82.6x10e-6	36.0x10e-6	39.7x10e-6	52.6x10e-6	49.2x10e-6	35x10e-6
Typical Electrical Properties								
Dielectric Constant								
0.1 kHz	4.25	4.61	4.2	4.87	3.91	3.58	4.11	4.28
1.0 kHz	4.20	4.37	4	4.83	3.88	3.52	3.97	4.18
10.0 kHz	4.16	4.20	3.8	4.75	3.84	3.46	3.87	4.06
100.0 kHz	4.10	4.05	3.7	4.64	3.79	3.39	3.77	3.92
Dissipation Factor								
0.1 kHz	0.010	0.040	0.08	0.003	0.01	0.01	0.02	0.01
1.0 kHz	0.011	0.027	0.04	0.007	0.01	0.01	0.02	0.02
10.0 kHz	0.012	0.026	0.03	0.011	0.01	0.01	0.02	0.02
100.0 kHz	0.013	0.023	0.03	0.014	0.01	0.02	0.02	0.02
Insulation Resistance, ohms								
	2.67x10e+13	1.61x10e+12	7.5x10e+11	5.19x10e+13	4.09x10e+13	1.23x10e+14	4.57x10e+13	2.15x10e+13
Volume Resistivity, ohms/cm								
	2.53x10e+15	1.02x10e+14	1.5x10e+14	2.69x10e+15	2.61x10e+15	7.41x10e+15	2.98x10e+15	1.37x10e+15
Dielectric Strength, Volts/mil								
	385	365	410	350	355	385	395	365
Flammability Rating								
UL File No. E106917	—	—	UL 94HB at 1/16"	—	—	—	—	—
Insulation System								
UL File No. E106917	—	—	UL 1446	—	—	—	—	—

Refer to page 44 for Hysol® package sizes and ordering information.

System Characteristics	Epoxy System 3142™				Epoxy System 3144™			
	3142™/3162™	3142™/3163™	3142™/3164™	3142™/3165™	3144™/3162™	3144™/3163™	3144™/3164™	3144™/3165™
Typical Uncured Properties								
Viscosity, cP								
Resin	95,000	95,000	95,000	95,000	18,000	18,000	18,000	18,000
Hardener	120	450	105	55	120	450	105	55
Mixed	6,000	7,000	8,000	18,000	4,000	2,500	3,000	7,000
Working Time 77°F(25°C)								
	10-15 min. at 200 g	2 hrs. at 400 g	25 min. at 400 g	80 min. at 400 g	15-20 min. at 200 g	3 hrs. at 200 g	30-40 min. at 200 g	3 hrs. at 400 g
Gel Time 77°F(25°C)								
	25-35 min. at 200 g	>3 hrs. at 400 g	50 min. at 400 g	2.5 hrs. at 400 g	30-40 min. at 200 g	>5 hrs. at 200 g	60-90 min. at 200 g	6 hrs. at 400 g
Cure Cycle Normal 77°F(25°C)								
	24 hrs.	48 hrs.	24 hrs.	24 hrs./77°F +4 hrs./200°F	16 hrs.	24 hrs.	24 hrs.	24 hrs./77°F +2 hrs./200°F
Alternate 150°F(66°C)								
	2 hrs.	4 hrs.	2 hrs.	4 hrs./+200°F	2 hrs.	4 hrs.	2 hrs.	4 hrs./+200°F
Mix Ratio								
By Weight	100:9	100:10.9	100:14.3	100:4.1	100:13	100:16	100:21	100:6.1
By Volume	4.5:1	3.6:1	2.8:1	9.7:1	4.5:1	3.5:1	2.8:1	9.3:1
Color								
Resin	black	black	black	black	black	black	black	black
Hardener	clear	amber	amber	clear	clear	clear	clear	clear
Mixed	black	black	black	black	black	black	black	black
Specific Gravity								
Resin	2.40	2.40	2.40	2.40	1.68	1.68	1.68	1.68
Hardener	0.99	0.96	0.97	0.96	0.99	0.96	0.97	0.96
Mixed	1.54	1.53	1.50	1.62	1.52	1.53	1.50	1.62
Typical Cured Properties								
Hardness, Shore D								
	90	90	85	90	80	75	55	85
Tg, °C								
	42	30	29	84	25	20	15	28
CTE above Tg, mm/mm°C								
	97.2x10e-6	96.1x10e-6	106x10e-6	87.7x10e-6	138x10e-6	140x10e-6	147x10e-6	109x10e-6
CTE below Tg, mm/mm°C								
	28.2x10e-6	33.5x10e-6	51.9x10e-6	26.9x10e-6	39x10e-6	67.1x10e-6	93.4x10e-6	42.1x10e-6
Thermal Conductivity Watts/Meter°C								
	1.40	1.40	1.27	1.14	0.41	-	-	-
Typical Electrical Properties								
Dielectric Constant								
0.1 kHz	4.87	5.28	5.51	5.65	4.24	4.29	5.31	4.26
1.0 kHz	4.83	5.20	5.35	5.57	4.12	4.03	4.87	4.17
10.0 kHz	4.78	5.12	5.21	5.46	4.03	3.84	4.52	4.10
100.0 kHz	4.72	5.02	5.06	5.34	3.96	3.70	4.23	4.05
Dissipation Factor								
0.1 kHz	0.01	0.01	0.02	0.01	0.02	0.04	0.06	0.01
1.0 kHz	0.01	0.01	0.02	0.01	0.02	0.04	0.06	0.01
10.0 kHz	0.01	0.01	0.02	0.01	0.01	0.03	0.05	0.01
100.0 kHz	0.01	0.01	0.02	0.01	0.01	0.02	0.04	0.01
Insulation Resistance ohms								
	5.31x10e+13	3.65x10e+13	2.75x10e+12	4.09x10e+13	1.79x10e+13	1.60x10e+12	4.23x10e+10	3.14x10e+13
Volume Resistivity ohms/cm								
	3.47x10e+15	2.55x10e+15	1.65x10e+14	2.61x10e+15	7.97x10e+14	1.05x10e+14	2.85x10e+12	1.84x10e+15
Dielectric Strength Volts/mil								
	345	355	345	335	375	360	365	340
Flammability Rating UL File No. E106917								
	-	-	-	-	UL 94V-0 at 1/8"	-	-	-

Refer to page 44 for Hysol® package sizes and ordering information.

LOCTITE® BRAND HYSOL® PACKAGE SIZES AND ORDERING INFORMATION

Product No.	1 quart	1 gallon	5 gallon ¹	55 gallon ¹
Hysol® Epoxy Resins				
3140™	–	39944	39945	–
3141™	–	39947	39948	–
3142™	–	39950	39951	39952
3144™	–	39953	39954	–
Hysol® Epoxy Hardeners				
3162™	39960	39961	39962	–
3163™	39964	39965	39966	–
3164™	–	39969	39970	–
3165™	39395*	39973	–	–

¹ 5 gal. & 55 gal. are made-to-order items.

* 1 pint fill.

Product No.	1 quart	1 gallon	5 gallon ¹	55 gallon ¹
Hysol® Polyurethane Resins				
3173™	39984	39985	39986	–
Hysol® Polyurethane Hardeners				
3182™	–	39995	39996	39997
3183™	–	39998	39999	–
3184™	–	39398	39397	–

HOT MELT ADHESIVES

In addition to structural bonding, Loctite® brand 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*EVA Based*

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.

LOCTITE® BRAND HYSOL® HOT MELT ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Viscosity (cP) at Dispense Temperature	Tensile Strength (psi)	Open Time	Temperature Resistance	% Elongation	Hardness (Shore A)	Key Specifications
1942™ Hysol®	83266 83267 83268 83269 83271 83272 83273 83274 83275 83276 83277	5 lb. sample bag pellets 40 lb. carton pellets Maxistick™ sample 7 oz. bag Maxistick™ 35 lb. carton PT™ stick 35 lb. carton Ministick™ 35 lb. carton Superstick™ sample 10" 5 oz. bag Superstick™ 10" 25 lb. carton Superstick™ 4" 25 lb. carton Polyshot™ sample 12 oz. bag Polyshot™ 35 lb. carton	Tan	5,000	250	30 seconds	142°F	500	–	FDA CFR175.105
3650™ Hysol®	31302 31297	22 lb. pellets 44 lb. pellets	Light beige	2,900	305	60-80 seconds	176°F	43	87	–
3651™ Hysol®	31303	26.4 lb. squares	Beige	10,000	334	80-100 seconds	266°F	790	55	–
7809FR™ Hysol®	83388 83390 83391	5 lb. bag sample pellets Superstick™ sample 10" 13 oz. bag Polyshot™ 13 oz. bag	Amber	7,000	363	35 seconds	240°F	373	85	UL Classified for U.S.
7811™ Hysol®	83337 83339	5 lb. bag sample pellets Polyshot™ sample 13 oz. bag	Amber	6,400	400	35 seconds	266°F	1,200	–	–
7901™ Hysol®	83341 83342 83343 83344	5 lb. bag sample pellets 40 lb. carton pellets Polyshot™ sample 13 oz. bag Polyshot™ 25 lb. pail	Amber	750	260	35 seconds	300°F	80	84	–

Refer to page 27 for related Hot Melt Stick size/diameter chart.

SILICONE POTTING COMPOUNDS

Loctite® brand silicones are single-component, tough protective potting and encapsulating compounds that seal components against moisture, solvents, and environmental conditions. Loctite® brand Nuva-Sil® products cure in as little as 30 seconds to depths of .150" when exposed to UV light, while Loctite® brand RTV silicones cure in 24 hours at room temperature when exposed to atmospheric moisture.



NEW

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 shallow potting, coating, and sealing applications. Provides high adhesion for difficult-to-bond substrates.

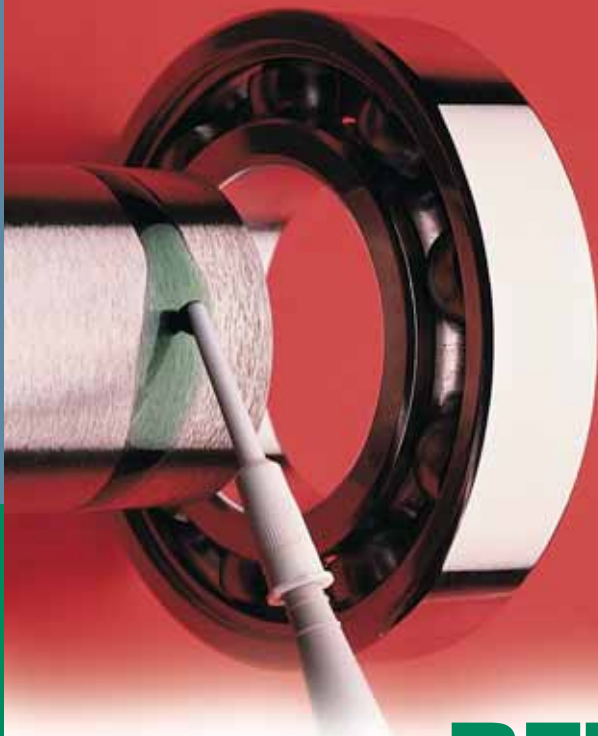
LOCTITE® BRAND SILICONE POTTING
COMPOUNDS PROPERTIES CHART

PRODUCT	Item Number	Container	Cure Schedule (Cure/Alt. Cure)	Viscosity, cP (mixed)	Gel Time	Hardness	Agency Approvals
5031™ Nuva-Sil® 	40086 40087	300 ml cartridge 40 lb. pail	UV/visible light/moisture 60 sec. at 40mW/cm ²	5,500	Seconds	34 shore A	-
5091™ Nuva-Sil® 	17412 18074	300 ml cartridge 40 lb. pail	UV/moisture 60 sec. at 40mW/cm ²	5,500	Seconds	34 shore A	UL Classified for U.S.

 Indicates worldwide availability.

For technical information and/or product
availability, call 1-800-LOCTITE or on the web

Visit  www.loctite.com



Loctite Corporation, now Henkel Corporation, the pioneer of anaerobic adhesives, has applied this technology to create retaining compounds that increase the shear strength of cylindrical, non-threaded assemblies. Finding wide acceptance as a standard method for assembling press and slip-fitted parts, Loctite® brand retaining compounds fill the “inner space” between components and cure to form a strong precision assembly. Formulated in a selection of viscosities, gap filling ability, flexibility, and strength characteristics, Loctite® brand retaining compounds can be applied with automated process equipment or dispensed manually.

RETAINING

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® 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.

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® 640™ Retaining Compound

Press Fit/High Strength/ High Temperature

A medium viscosity retaining compound that resists temperatures to 400°F.

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.

New semi-solid retaining QuickStix™ are available! See pages 94 & 95 for more details.

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.

Loctite® 660™ Quick Metal® Retaining Compound

Press Fit Repair

A creamy, non-running adhesive/sealant. Repairs worn machine parts. Restores correct fit to mating assemblies. Fills gaps up to 0.020" diametral clearance.

Loctite® 661™ Retaining Compound

Slip Fit/UV Dual Cure

Fast curing, high strength retaining compound. Achieves fixture strength in 5 minutes or in 15 seconds by exposing edge fillets to high intensity long wavelength UV light.

Loctite® 675™ Retaining Compound

Press Fit/Medium Strength








A low viscosity retaining compound that augments press fit assemblies. Slow cure speed permits readjustment of parts during assembly.

Loctite® 680™ Retaining Compound

Slip Fit/High Strength

A high viscosity retaining compound for joining fitted cylindrical parts. Fixtures in 10 minutes and provides a shear strength up to 4,000 psi on steel after 24 hours. Fills diametral gap distances up to 0.015".

LOCTITE® BRAND RETAINING
COMPOUNDS PROPERTIES CHART

PRODUCT	Item Number	Container	Typical Use	Color	Max. Gap Fill (Diametral)	Viscosity, cP	Shear Strength Steel/Steel, psi*	Temperature Range	Cure Speed, Steel at 25°C	Recommended Primer	Specific Gravity	Agency Approvals
603™ 	21440 21441 21442	10 ml bottle 50 ml bottle 250 ml bottle	For close fitting parts with light contamination	Green	.005"	125	3,770	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	N™ or T™	1.10	-
609™	60905 60921 60931 60941 60943	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	1st generation to augment press fits	Green	.005"	125	2,300 (min.)	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	N™ or T™	1.10	MIL-R-46082B for existing designs, ASTM D-5363 for new designs, CFIA
620™ 	62005 62015 62040 62070 62085	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	For high temperature applications	Green	.015"	8,500	3,800	-65°F to 450°F	Fixture - 30 min. Full - 24 hrs.	N™ or T™	1.16	CFIA, ABS
635™	63531 63541	50 ml bottle 250 ml bottle	1st generation high strength for slip fits	Green	.010"	2,000	4,500	-65°F to 300°F	Fixture - 1 hr. Full - 24 hrs.	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 fitted parts	Green	.015"	2,500	4,500	-65°F to 300°F	Fixture - 5 min. Full - 24 hrs.	N™ or T™	1.09	CFIA
640™	64031 64041	50 ml bottle 250 ml bottle	For high temperature applications	Green	.007"	600	3,000	-65°F to 400°F	Fixture - 1 hr. Full - 24 hrs.	N™ or T™	1.12	MIL-R-46082B for existing designs, ASTM D-5363**
641™ 	28802 21458	10 ml bottle 50 ml bottle	Medium strength for easier disassembly	Yellow	.008"	525/1,950 Thixotropic	1,700	-65°F to 300°F	Fixture - 20 min. Full - 24 hrs.	N™ or T™	1.07	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	.006"	500	3,900	-65°F to 350°F	Fixture - 5 min. Full - 24 hrs.	N™ or T™	1.13	-
660™ Quick Metal® 	66010 66040 30287	6 ml tube 50 ml tube 250 ml tube	For repair of worn machinery parts	Silver	.020"	250,000/ 1,500,000 Thixotropic	3,335	-65°F to 300°F	Fixture - 20 min. Full - 24 hrs.	N™ or T™	1.13	CFIA
661™ 	66141	250 ml bottle	Fast UV anaerobic curing	Amber	.006"	500	3,500	-65°F to 350°F	Fixture - 5 min. Full - 24 hrs.	N™ or T™	1.11	-
675™	67541	250 ml bottle	1st generation for close fitting parts	Green	.005"	125	3,000	-65°F to 300°F	Fixture - 20 min. Full - 24 hrs.	N™ or T™	1.09	MIL-R-46082B for existing designs, ASTM D-5363**
680™	68005 68015 68035 68060 68090	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength for slip fitted parts	Green	.015"	1,250	2,800	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	N™ or T™	1.11	NSF/ANSI 61, ABS

* Varies with substrates. ** For new designs.  Indicates worldwide availability.



Henkel Corporation offers a complete line of Loctite® brand surface preparation products to ensure the maximum performance of Loctite® brand adhesives and sealants.

Loctite® brand 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® brand primers are used to ensure cure on inactive surfaces and speed the cure of machinery adhesives.

All Loctite® brand surface preparation products are available in ozone-safe (non-CFC), solvent-based and solventless formulations.

SURFACE PREPARATION

ACCELERATORS

Loctite® 7452™ Tak Pak® Accelerator

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

Loctite® 7113™ Accelerator

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

Loctite® 7387™ Depend® Activator

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

PRIMERS

Loctite® 7471™ Primer T™

A solvent-based primer that speeds the cure of all Loctite® brand 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® brand anaerobic products and ensure proper cure on inactive metals. Ideal for cure conditions below room temperature.

Loctite® 770™ Prism® Primer









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

Q. When should I use a primer?




A. 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. See chart.

ACTIVE METALS		INACTIVE METALS	
Iron	Bronze	Plated Parts	Cadmium
Plain Steel	Nickel	Anodized Aluminum	Magnesium
Copper	Manganese	(Alodine, Iridite)	Natural or Chemical Black Oxide
Brass	Monel	Titanium	Magnetite Steel
Commercial Aluminum	Kovar	Stainless Steel	Iconel
(with copper content, e.g. 6061)		Galvanized Steel	Silver
		Zinc	Gold
		Pure Aluminum	Plastics

LOCTITE® BRAND ACCELERATORS/PRIMERS PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Viscosity, cP	Base	On-Part Life	Dry Time	Application	Agency Approvals
712™ Tak Pak® 	20352 18636 18390	1.75 fl. oz. bottle 0.7 fl. oz. metered mist 1 gal. can	Clear/amber	1	Isopropanol	1 min.	<30 sec.	All cyanoacrylates	MIL-46050C for existing designs, CFIA
770™ Prism® 	18396 18397	1.75 fl. oz. bottle 16 fl. oz. can	Colorless	1.25	Heptane	8 hrs.	30 sec.	All cyanoacrylates	CFIA
793™ Prism® 	18650 20246	1.75 fl. oz. bottle 16 fl. oz. bottle	Clear/light amber	3	Propylene based glycol ether/water	<2 hrs.	<10 min.	All cyanoacrylates	-
7090™ 	19368 12695	1 fl. oz. bottle 1 liter bottle	Light amber	3	No solvent	1 hr.	<10 min.	Anaerobics	-
7109™ Tak Pak II®	22440 23034	1.75 fl. oz. bottle 1 qt. bottle	Clear/amber	3	Perfluorocarbon	1 min.	<5 sec.	All cyanoacrylates	-
7113™ 	19605 19606	1.75 fl. oz. bottle 1 gal. can	Clear	0.4	Heptane	24 hrs.	1 min.	All cyanoacrylates	-
7452™ Tak Pak® 	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 qt. can 1 gal. can	Clear/amber	0.4	Acetone	1 min.	<30 sec.	All cyanoacrylates	MIL-46050C for existing designs
7453™ Tak Pak®	20282	1.75 fl. oz. bottle	Clear/amber	0.4	Acetone (electronic grade)	1 min.	<30 sec.	All cyanoacrylates	-
7471™ Primer T™ 	19267 22477 19268	1.75 fl. oz. bottle 4.5 oz. aerosol can 1 gallon can	Amber	2	Acetone/Isopropanol	7 days	30-70 sec.	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs
7649™ Primer N™ 	19269 38402 21347 21348 19266	1.75 fl. oz. glass bottle 1.75 fl. oz. aluminum bottle 25 gm aerosol can 4.5 oz. aerosol can 1 gallon can	Clear/green	2	Acetone	30 days	30-70 sec.	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs, NSF/ANSI 61, NSF P1, CFIA

LOCTITE® BRAND ACTIVATORS PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Viscosity, cP	Base	On-Part Life	Dry Time	Application
7075™ 	21349 22671	1 qt. can 4.5 oz. aerosol can	Amber	2	Acetone	2 hrs.	3 minutes	324, 325
7380™ Depend® 	19822 19824 19907	1 liter can 1.75 fl. oz. bottle 1 gallon can	Light brown	43	Monomer	2 hrs.	None	Structurals
7387™ Depend® 	18861 18862 21088	1.75 fl. oz. bottle 1 qt. can 4.5 oz. aerosol can	Light brown	1.5	Heptane/Isopropanol	2 hrs.	None	Structurals
25062	25062	1 liter bottle	Thin green/fluorescent	1.03	Methacrylate	1 hr.	None	Anaerobics on dichromate surfaces

 Indicates worldwide availability.



Invented by Loctite Corporation, now Henkel Corporation, as a revolutionary method to lock and seal threaded fasteners, Loctite® brand liquid threadlockers have found wide acceptance in a range of applications – from delicate electronic components to heavy construction equipment.

Loctite® brand threadlockers are available in varying viscosities and strengths for virtually any application, including exposure to extreme environments.

THREADLOCKING

LIQUID THREADLOCKERS

Loctite® 222MS™ Threadlocker

Low Strength/Small Screw

Ideal for fastener diameters of ¼" (6 mm) and smaller. Controlled lubricity for accurate clamp loads. Parts can be separated using hand tools.

Loctite® 242® Threadlocker

Medium Strength

A general purpose, removable threadlocker for fasteners between ¼" and ¾" (6 to 20 mm) diameters. Controlled lubricity for accurate clamp loads. Parts can be separated using hand tools.

Loctite® 243™ Threadlocker

Medium Strength/Oil Resistant

A general purpose, medium strength threadlocker with improved oil tolerance. For fasteners between ¼" and ¾" (6 to 20 mm) diameters.

Loctite® 246™ Threadlocker

Medium Strength/High Temperature

This threadlocker resists oil and mild surface contamination at continuous temperatures to 450°F. Suitable for fasteners between ¼" and ¾" (6 to 20 mm) diameters.

Loctite® 262™ Threadlocker

Medium to High Strength

A permanent threadlocker for fasteners up to ¾" (20 mm) diameter. High lubrication for easy assembly. Excellent for preventing rust and corrosion in extreme chemical/environmental conditions.

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 ¾" (20 mm) in diameter.

New Innovative Technology!
See pages 96 & 97 for details
on the new semi-solid
threadlocking QuickStix™.

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 1½" (36 mm) in diameter. Heat and hand tools are required for disassembly.

Loctite® 277™ Threadlocker*High Strength*

Locks fasteners up to 1½" (36 mm). Protects threads from rust and corrosion. Removable with heat and hand tools.

Loctite® 290™ Threadlocker*Wicking Grade*

A medium strength threadlocker for pre-assembled bolts up to ½" (12 mm). Penetrates threads by capillary action. 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.

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.

Loctite® 2432™ Threadlocker*Low Halogen/Low Sulfur*

This medium strength threadlocker was especially 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, thereby reducing or eliminating the need for primers. Performs well on all substrates. It develops useable strength (100 in.-lbs.) within one hour. Parts can be separated using hand tools.

Loctite® 2760™ Threadlocker*Primerless/High Strength*

This threadlocker is particularly fast curing, thereby reducing or eliminating the need for primers. Particularly suitable for heavy duty applications where resistance to heavy shock, vibration, and stress levels are required.








For technical information and/or product availability, call:

1-800-LOCTITE (562-8483)
or visit us on the web at:

www.loctite.com



**LOCTITE® BRAND
LIQUID THREADLOCKERS
PROPERTIES CHART**

PRODUCT	Item Number	Container	Typical Use	Color	Viscosity, cP	Torque in. lbs. (M10 Steel Nuts & Bolts) Break/Prevail	Temperature Range	Cure Speed, Steel at 25°C	Oil Tolerant	Recommended Primer	Specific Gravity	Agency Approvals
220™	37388 39186 22041	10 ml bottle 50 ml bottle 250 ml bottle	Wicking grade for small, pre-assembled fasteners under 1/4"	Blue	20	85/170	-65°F to 300°F	Fixture - 6 min. Full - 24 hrs.	No	N™ or T™	1.08	MIL-S-46163A for existing designs, ASTM D-5363,** CFIA
222™ 	21463 21464	10 ml bottle 50 ml bottle	Small screws under 1/4"	Purple	1,200/ 5,000 Thixotropic	53/30	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	N™ or T™	1.05	-
222MS™	22205 22221 22231 22241	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle	Easy removal small screws under 1/4"	Purple	1,200/ 5,000 Thixotropic	53/30	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	N™ or T™	1.05	MIL-S-46163A for existing designs, ASTM D-5363,** NSF P1, CFIA
242* 	24205 24221 24231 24241 24243	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Removable grade up to 1/4" to 3/4" bolts	Blue	1,200/ 5,000 Thixotropic	110/43	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	N™ or T™	1.07	MIL-S-46163A for existing designs, ASTM D-5363,** NSF/ANSI 61, NSF P1, ABS, CFIA
243™ 	23977 24077 24078 24079 21433	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	For 1/4" to 3/4" bolts. Provides fast cure on steel without primer	Blue	2,250/ 12,000 Thixotropic	180/62	-65°F to 300°F	Fixture - 5 min. Full - 24 hrs.	-	N™ or T™	1.08	NSF/ANSI 61, CFIA
246™	29513 29514 29515	10 ml bottle 50 ml bottle 250 ml bottle	High temperature med. strength	Blue	2,600	170/48*	-65°F to 450°F	Fixture - 20 min. Full - 24 hrs.	Yes	N™ or T™	1.15	-
262™ 	26205 26221 26231 26241 26243	.5 ml capsule 10 ml tube 50 ml bottle 250 ml bottle 1 liter bottle	High strength locking up to 3/4" bolts	Red	1,800/ 5,000 Thixotropic	189/ 275	-65°F to 300°F	Fixture - 5 min. Full - 24 hrs.	-	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	High strength high temperature	Red-orange	3,750- 9,000	270/75	-65°F to 450°F	Fixture - 10 min. Full - 24 hrs.	Yes	N™ or T™	1.19	CFIA
271™	27105 27121 27131 27141 27143	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength for fasteners up to 1" diam.	Red	500	250/ 275	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	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	High temperature applications	Red	9,500	200/ 220	-65°F to 450°F	Fixture - 30 min. Full - 24 hrs.	-	N™ or T™	1.11	CFIA
277™ 	21434 27731 27741 27743	10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength for large bolts	Red	7,000	275/ 275	-65°F to 300°F	Fixture - 60 min. Full - 24 hrs.	-	N™ or T™	1.12	MIL-S-46163A for existing designs, ASTM D-5363**
290™ 	29005 29021 29031 29041 29043	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Wicking grade for preassembled parts	Green	12	85/ 250	-65°F to 300°F	Fixture - 6 min. Full - 24 hrs.	-	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	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle	High temperature, wicking grade	Green	34	289/ 237	-65°F to 450°F	Fixture - 6 min. Full - 24 hrs.	Yes	N™ or T™	1.13	-
425™ Assure™	42540 42561	20 gm bottle 1 lb. bottle	For small metal and plastic fasteners and tamper-proofing	Blue	80	4/2	-65°F to 180°F	Fixture - 1.5 min. Full - 24 hrs.	-	-	1.10	-
2432™	25523	50 ml bottle	Low halogen, low sulfur, med. strength	Blue	300	150/ 53	-65°F to 300°F	Fixture - 30 min. Full - 24 hrs.	-	-	1.08	-
2440™	33946 33947 33948	10 ml bottle 50 ml bottle 250 ml bottle	Primerless, medium strength	Blue	1,800/ 6,800 Thixotropic	215/ 53*	-65°F to 300°F	Fixture - 3 min. Full - 24 hrs.	-	N™ or T™	1.10	-
2760™	32526 32525 32527 32528	10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Primerless, high strength	Red	2,900/ 10,000 Thixotropic	325/ 320*	-65°F to 300°F	Fixture - 4 min. Full - 24 hrs.	-	N™ or T™	1.15	CFIA

* Break/loose value. Brookfield RVT spindle 3.20 RPM/25 RPM. ** For new designs.



Indicates worldwide availability.

CHOOSING THE RIGHT LOCTITE® BRAND THREADLOCKER FOR THE APPLICATION

Choosing the right Loctite® brand threadlocker for the application is simple. Just answer these questions.

1. Do you need a threadlocker that can be removed or one that is permanent?

Loctite® brand threadlockers are available in removable or permanent formulations.

2. What size thread are you locking?

Loctite® brand threadlockers are available in a variety of strengths to lock any size fastener.

3. Is the application a blind hole or a thru-hole?

The application method for blind hole assemblies differs from standard thru-hole assemblies.

4. Are there threadlockers for pre-assembled bolts?

Henkel offers Loctite® brand wicking grade threadlockers that secure set screws and other assemblies after settings are completed.

5. What kind of metal(s) will be used?

On two inactive metals such as stainless steel, zinc, magnesium, black oxide, cadmium, anodized aluminum, passivated, titanium, and others, a primer is needed to cure Loctite® brand threadlockers. If only one inactive metal, no primer is needed.

6. What other environmental conditions exist?

Loctite® brand threadlockers are formulated to meet any application need – high temperature, severe vibration, and chemical resistance.

7. Will your application have to meet any agency approval?

The Loctite® brand offers the broadest line of products approved by some of the most demanding regulatory agencies – NSF*, UL*, Military.

ANSWERS TO THE MOST FREQUENTLY ASKED QUESTIONS (FAQ) ABOUT USING LOCTITE® BRAND THREADLOCKERS

Q. How do I disassemble parts? What is the procedure?

A. Use standard hand tools for disassembly of low and medium strength threadlockers. For high strength threadlockers, apply localized heat to nut or stud for 5 minutes at 450°F. Disassemble while hot.

Q. When should I use a primer with threadlockers and when is it not necessary?

A. Always use a primer when two inactive metals are involved, or when you need to speed up the curing process for faster return to service. See Surface Preparation section for a list of active and inactive surfaces.

Q. Can I use threadlockers on plastic threads?

A. This is not recommended as softening and/or stress cracking can occur.

Q. I have excess squeeze-out of threadlocker product. Why hasn't it cured?

A. The anaerobic chemistry will cure only between metal surfaces when deprived of air.

Q. I used a permanent threadlocker on a blind hole application and the fastener still backed out with vibration. Why?

A. The application method for blind hole assemblies requires that product be applied to both parts. If product is only applied to the fastener, air pressure will force the liquid threadlocker to escape as you torque it down. Lack of uniform coverage creates air pockets, causing incomplete cures which result in failures.

LOW STRENGTH THREADLOCKERS



- Removable with hand tools
- Adjustment screws
- Calibration screws
- Meters and gauges
- Up to 1/4" diameters

MEDIUM STRENGTH THREADLOCKERS



- Removable with hand tools
- Machine tools and presses
- Pumps and compressors
- Mounting bolts
- Gear boxes
- Up to 3/4" 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
- Preassembled fasteners
- Instrumentation screws
- Electrical connectors
- Carburetors
- Up to 1/2" diameters

* NSF = National Sanitation Foundation. UL = Underwriter's Laboratories.

Loctite® brand 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.

THREAD SEALING

LIQUID THREAD SEALANTS

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

A liquid sealant for locking and sealing high pressure, fluid power systems with tapered fittings. Contains no fillers and will not foul valves or fluid filtering systems.

Loctite® 564™ Thread Sealant

General Purpose

Ideal for large threads where easier disassembly is required.

Loctite® 565™ PST® Thread Sealant

Controlled Strength

A general purpose instant sealant for tapered and straight/tapered fittings. Controlled strength for ease of disassembly.

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.

For the name and number of your nearest distributor, call: 1-800-LOCTITE (562-8483)

or use the "Distributor Locator" on our web site at www.loctite.com/distributor

New semi-solid thread sealing QuickStix™ are available! See pages 98 & 99 for more details.

Loctite® 567™ PST® Thread Sealant

High Temperature

Withstands temperatures to 400°F with excellent solvent resistance. Locks and seals tapered pipe threads and fittings, including high pressure applications. Disassembles with hand tools.

Loctite® 572™ Thread Sealant

Low Strength

Low strength sealant with moderate fixture speed for use on coarse threads.

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 and withstands temperatures to 300°F (149°C). Sealing is effective on threaded joints up to 2" in diameter. Lower locking strength secures elbows in any position but permits easy disassembly.

Loctite® 580™ PST® Thread Sealant

Low Halogen/Low Sulfur

For threaded fittings in fossil fuel, solar and hydro plant piping systems.

Loctite® 592™ PST® Thread Sealant

Slow Cure

Locks and seals threaded fittings. Parts may be repositioned up to 24 hours after application.

Loctite® 5772™ Thread Sealant

Low Halogen/Low Sulfur






A medium strength thread sealant with fast curing properties. Especially developed for use on sensitive metals, like Titanium, used in the Nuclear Industry. Parts can be separated using hand tools.

For technical information and/or product availability, call 1-800-LOCTITE or on the web

Visit www.loctite.com



LOCTITE® BRAND LIQUID
THREAD SEALANTS
PROPERTIES CHART

PRODUCT	Item Number	Container	Typical Use	Color	Viscosity, cP	Temperature Range	Recommended Primer	Specific Gravity	Agency Approvals
542™ 	21453 37795	50 ml bottle 250 ml bottle	Fine threads	Brown	525/1,850 Thixotropic	-65°F to 300°F	N™ or T™	1.06	-
545™ 	54505 32429 54531 54541	.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	N™ or T™	1.02	ABS, CFIA
554™	25882 55441	10 ml bottle 250 ml bottle	Refrigerant sealant, high strength	Red	2,500	-65°F to 300°F	N™ or T™	1.02	CFIA
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	N™ or T™	1.17	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 cartdg. 1 liter bottle 10 liter bottle	Controlled strength	White	300,000	-65°F to 300°F	N™ or T™	1.10	CSA International, UL Classified for U.S., ULC Classified for Canada, NSF/ANSI 61, CFIA
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	N™ or T™	1.14	CSA International, UL Classified for U.S., ULC Classified for Canada, 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	N™ or T™	1.05	CFIA
571™	57141	250 ml bottle	Excellent solvent resistance and high strength	Brown	2,000	-65°F to 300°F	N™ or T™	1.10	MIL-S-22473E for existing designs, ASTM D5363 for new designs
572™ 	21454	50 ml tube	Slow cure, low strength	White	17,000/ 50,000 Thixotropic	-65°F to 300°F	N™ or T™	1.25	-
577™ 	21456 21457	50 ml tube 250 ml tube	Medium strength, coarse threads	Yellow	24,000/ 80,000 Thixotropic	-65°F to 300°F	N™ or T™	1.09	-
579™	57941	250 ml tube	Low strength, instant seal	Silver/ brown	20,000	-65°F to 300°F	N™ or T™	1.10	-
580™ PST®	58031	50 ml tube	Low halogen, low sulfur, PTFE free	White	600,000	-65°F to 300°F	-	1.08	-
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	NF™	1.21	UL Classified for U.S., ULC Classified for Canada, CFIA
5772™	25524	50 ml bottle	Low halogen, low sulfur, medium strength, fast cure	Yellow	7,500	-65°F to 300°F	-	1.09	-

 Indicates worldwide availability.

LOCTITE® BRAND DISPENSING EQUIPMENT

A complete line of off-the-shelf equipment systems for dispensing Loctite® brand thread sealants is available from Henkel. These manual and semi-automatic equipment systems are designed to reduce waste and operator contact.

For more information, refer to the Equipment Section of this catalog.



Loctite® Dial-A-Seal® Applicator,
Item 998400

Dispenses 50 ml tubes, 250 ml tubes, and 1 liter bottles.



Loctite® Bond-A-Matic® 3000 Dispenser,

Items 982719 (0-15 psi), 982722 (0-100 psi)

Dispenses liquid thread sealants packaged in 250 ml tubes, 250 ml bottles, and 1 liter bottles.



NEW

Loctite® 50 ml Hand Pump, Item 98414

Dispenser for 50 ml bottles.



Loctite® 250 ml Hand Pump, Item 97001

Dispenser for 250 ml bottles.



Loctite® Pneumatic Cartridge Dispenser,
Item 97002

Use with 250 ml squeeze tubes or 300 ml cartridges.

In addition to our standard line of equipment, Henkel offers a number of resources to support your dispensing needs:

- **Custom Equipment Systems** – Modify any Loctite® brand standard system or customize a system to meet your specific assembly needs.
- **Equipment Rental Program** – Evaluate the performance of our equipment before making a capital investment.
- **Equipment Web Site** – Locate details on Loctite® brand standard and custom equipment; parts and accessories; and equipment services. To learn more about our equipment, or to find the name and phone number of your nearest authorized distributor, visit www.loctite.com.
- **Adhesives and Sealants Specialists** – Henkel Adhesives and Sealants Specialists are available across the continent to personally assist you with new assembly challenges or to help you re-engineer an existing application for improved performance and cost savings using Loctite® brand products.

To take advantage of our complete equipment and service offerings, simply contact us at **1-800-LOCTITE (562-8483)** or visit www.loctite.com/equipment.

Henkel offers the most comprehensive line of Loctite® brand 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.

BONDING

MEDICAL DEVICE ADHESIVES

LIGHT CURE ACRYLIC ADHESIVES

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® 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® 3971™, 3972™ Light Cure Adhesives

Plasticized Substrates

Rapid curing, UV/visible, fluorescing adhesives that bond highly plasticized materials, including PVC and polyurethane.

Loctite® 3201™, 3211™ Light Cure Adhesives

Polycarbonate/Thermoplastics

A high viscosity, UV/visible adhesive that forms very flexible joints with minimal stress cracking. Ideal for bonding polycarbonate and other thermoplastics.

Loctite® 3301™, 3311™, 3321™ Light Cure Adhesives

Plastic/Metal

A low viscosity, slightly flexible, UV/visible adhesive. 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.

EPOXY AND URETHANE ADHESIVES

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-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.

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.

CYANOACRYLATE ADHESIVES

Loctite® 4011™ Prism® Medical Device Adhesive

A low viscosity, instant adhesive ideally suited for dry environments, as well as for bonding acidic and porous surfaces.

Loctite® 4851™ Prism® Instant Adhesive

Flexible

A medium viscosity, single component material for porous or absorbent substrates.

Loctite® 4861™ Prism® Instant Adhesive

Flexible

A high viscosity, single component, general-purpose material for gaps up to .008".

LIGHT CURE CYANOACRYLATE ADHESIVES

Loctite® 4306™/4307™ Flashcure® Light Cure Adhesives

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

SILICONE ADHESIVES


Loctite® 5248™ Nuva-Sil® Medical Device Sealant

A self-leveling, UV silicone ideal for sealing and bonding extruded and moldable silicones, glass, and metals.

View our selector guide on-line, visit us on the web at:

www.loctite.com



PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP	Temperature Range	Agency Approvals
						Brookfield, 25°C		
LOCTITE® BRAND LIGHT CURE ADHESIVES – ACRYLIC								
3201™	19727 19728	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	4,000	-65°F to 300°F	ISO-10993 compliant
3211™	19730 19731*	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	10,000 Thixotropic	-65°F to 300°F	ISO-10993 compliant
3301™	19733 19734	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	150	-65°F to 300°F	ISO-10993 compliant
3311™	19736 19737	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	300	-65°F to 300°F	ISO-10993 compliant
3321™	19739 19740	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	5,000	-65°F to 300°F	ISO-10993 compliant
3341™	23792 23440	25 ml syringe 1 liter bottle	Clear/straw/ fluorescent	Ultraviolet, visible	Thermoplastics, polyvinylchloride	450	-65°F to 300°F	ISO-10993 compliant
3345™	33417 30688*	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet	Glass, metal	1,500	-65°F to 300°F	ISO-10993 compliant
3381™	25785 24690*	25 ml syringe 1 liter bottle	Translucent/ colorless	Ultraviolet	Thermoplastic, thermoset plastic	5,000	-65°F to 300°F	ISO-10993 compliant
3911™	36536 36537*	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic	100	-65°F to 300°F	ISO-10993 compliant
3912™	36539 36540	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic	6,300	-65°F to 300°F	ISO-10993 compliant
3913™	36791 36804	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet	Glass, metal, thermoplastic	8,500	-65°F to 300°F	ISO-10993 compliant
3921™	36484 36485	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	150	-65°F to 300°F	ISO-10993 compliant
3922™	32083 32047*	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	300	-65°F to 300°F	ISO-10993 compliant
3924™	36488 36489	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	1,100	-65°F to 300°F	ISO-10993 compliant
3926™	36492 36493	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	4,500	-65°F to 300°F	ISO-10993 compliant
3933™	32084 32040*	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	3,250	-65°F to 300°F	ISO-10993 compliant
3936™	32304 32037*	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	10,000	-65°F to 300°F	ISO-10993 compliant
3941™	36437 36476	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, thermoset plastic	480	-65°F to 300°F	ISO-10993 compliant
3942™	36483 36481	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, thermoset plastic	1,200	-65°F to 300°F	ISO-10993 compliant
3943™	36480 36478	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Glass, metal, thermoplastic, thermoset plastic	6,000	-65°F to 300°F	ISO-10993 compliant
3944™ 	38210 38212*	25 ml syringe 1 liter bottle	Fluorescent/ pale yellow	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	5,000	-65°F to 300°F	ISO-10993 compliant
3971™	36792 36805	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Metal, thermoplastic, polyvinylchloride, polyurethane	320	-65°F to 300°F	ISO-10993 compliant
3972™	36294 36295	25 ml syringe 1 liter bottle	Transparent to hazy/fluorescent	Ultraviolet, visible	Metal, thermoplastic, polyvinylchloride, polyurethane	4,500	-65°F to 300°F	ISO-10993 compliant

LOCTITE® BRAND FLASHCURE® LIGHT CURE ADHESIVES – CYANOACRYLATE

4304™ Flashcure®	32254 32407	1 oz. bottle 1 lb. bottle	Clear/ pale green	Ultraviolet, visible, moisture	Thermoplastic, polycarbonate, elastomer, metal	20	-65°F to 180°F	ISO-10993 compliant
4305™ Flashcure®	32268 32409	1 oz. bottle 1 lb. bottle	Clear/ pale green	Ultraviolet, visible, moisture	Thermoplastic, polycarbonate, elastomer, metal	900	-65°F to 180°F	ISO-10993 compliant
4306™ Flashcure®	37439 37442*	1 oz. bottle 1 lb. bottle	Clear/pale green/fluorescent	Ultraviolet, visible, moisture	Thermoplastic, polycarbonate, elastomer, metal	20	-65°F to 180°F	ISO-10993 compliant
4307™ Flashcure®	37441 37443*	1 oz. bottle 1 lb. bottle	Clear/pale green/fluorescent	Ultraviolet, visible, moisture	Thermoplastic, polycarbonate, elastomer, metal	900	-65°F to 180°F	ISO-10993 compliant

* Made-to-order item.

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP	Temperature Range	Agency Approvals
						Brookfield, 25°C		

LOCTITE® BRAND MEDICAL DEVICE ADHESIVES – CYANOACRYLATE

4011™ Prism®	18680 18681	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	100	-65°F to 180°F	ISO-10993 compliant
4013™ Prism®	20268 18013	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	500	-65°F to 180°F	ISO-10993 compliant
4014™ Prism®	20269 18014	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	3	-65°F to 220°F	ISO-10993 compliant
4031™ Prism®	18682 18683	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	1,300	-65°F to 160°F	ISO-10993 compliant
4061™ Prism®	18686 18687	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	20	-65°F to 180°F	ISO-10993 compliant
4081™ Prism®	18688 18689	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	5	-65°F to 150°F	ISO-10993 compliant
4161™ Super Bonder®	19743 19744	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	1,500	-65°F to 180°F	ISO-10993 compliant
4206™ Prism®	28628 18629*	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	375	-65°F to 250°F	ISO-10993 compliant
4541™ Prism®	18690 18691	20 gm bottle 200 gm bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	Gel	-65°F to 180°F	ISO-10993 compliant
4601™ Prism®	18692 18693	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	50	-65°F to 160°F	ISO-10993 compliant
4851™ Prism®	37732 37733	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	400	-65°F to 125°F	ISO-10993 compliant
4861™ Prism®	37708 37711	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	4,000	-65°F to 125°F	ISO-10993 compliant
4981™ Super Bonder®	18694 18695	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	500	-65°F to 220°F	ISO-10993 compliant

LOCTITE® BRAND HYSOL® ADHESIVES – EPOXY AND URETHANE

3981™ Hysol®	36766 37297	30 ml syringe 1 liter bottle	Transparent yellow	Heat cure epoxy	Thermoset plastic, metal, glass, ceramic	5,300	-65°F to 300°F	ISO-10993 compliant
3982™ Hysol®	36767 37298	30 ml syringe 1 liter bottle	Off white	Heat cure epoxy	Thermoset plastic, metal, glass, ceramic	8,000	-65°F to 300°	ISO-10993 compliant
3984™ Hysol®	36768 37299*	30 ml syringe 1 liter bottle	Light grey	Heat cure epoxy	Thermoset plastic, metal, glass, ceramic	25,500	-65°F to 300°F	ISO-10993 compliant
M-11FL™ Hysol®	30678	50 ml dual cartrdg.	Ultra clear	Room temperature urethane	Thermoplastic, thermoset plastic, polycarbonate, elastomer, metal, glass, ceramic	3,800	-65°F to 250°F	ISO-10993 compliant
M-21HP™ Hysol®	30671	50 ml dual cartrdg.	Off white	Room temperature epoxy	Thermoplastic, thermoset plastic, elastomer, metal, glass, ceramic	37,000	-65°F to 300°F	ISO-10993 compliant
M-31CL™ Hysol®	30673 30674*	50 ml dual cartrdg. 200 ml dual cartrdg.	Ultra clear	Room temperature epoxy	Thermoplastic, thermoset plastic, polycarbonate, metal, glass, ceramic	6,000	-65°F to 300°F	ISO-10993 compliant
M-121HP™ Hysol®	30680	50 ml dual cartrdg.	Amber	Room temperature epoxy	Thermoplastic, polycarbonate, polyvinylchloride, metal, glass, ceramic	11,000	-65°F to 300°F	ISO-10993 compliant

LOCTITE® BRAND NUVA-SIL® ADHESIVE – SILICONE

5248™ Nuva-Sil®	19987	300 ml cartridge	Translucent/ straw	UV, moisture	Elastomer, metal, glass	50,000	-65°F to 400°F	ISO-10993 compliant
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LOCTITE® BRAND PRISM® ACCELERATOR & PRIMER

713™ Prism® Accelerator	19889	1.75 fl. oz. bottle	Clear	-	Accelerator for cyanoacrylates	1	-	ISO-10993 compliant
7701™ Prism® Primer	19886 19887	1.75 fl. oz. bottle 16 fl. oz. can	Clear	-	Adhesion promoter for low energy surface plastics	3	-	ISO-10993 compliant

* Made-to-order item.



Whether a liquid, foam, aerosol, or gel, you'll find the right product for your bonding need in the extensive family of Loctite® brand adhesives. These instant, acrylic and rubber-based adhesives provide an endless combination of cure speed, impact resistance, strength, temperature range, and solvent resistance to meet tough on-the-job requirements.

ADHESIVES

Loctite® 330™ Depend® Adhesive

No Mix

Sets in just minutes to a tough acrylic adhesive with high peel and impact strength. Bonds almost all combinations of materials, including glass. No mix kit includes activator and adhesive.

Loctite® 380™ Black Max® Instant Adhesive

Toughened

For parts that encounter shock, vibration, or thermal cycling, Loctite® 380™ Black Max® is the instant adhesive choice. This black, toughened cyanoacrylate adhesive uses elastomers to withstand impact and challenging environmental conditions. Seals as well as bonds.

Loctite® 404™ Quick Set™ Instant Adhesive

This general purpose instant adhesive liquid is the one everyone needs in their toolbox for general maintenance and repair. It sets instantly. No clamping, no mixing, no waiting. Keep it handy to bond just about anything in an instant.

NEW

Loctite® Quicktite® Instant Adhesive Gel

A general purpose instant adhesive featuring an innovative, precision flow control applicator. This new, patented, "squeeze grip" applicator allows for pinpoint control on the exact amount and placement of the adhesive. It is also designed to be clog-free, so the adhesive is always ready-to-use.

Loctite® Black Contact Adhesive

A professional contact adhesive that blends with black colored moldings and weatherstripping materials. Withstands temperature extremes and is resistant to gasoline, kerosene, and other solvents. Fast drying, waterproof.

Loctite® Contact Adhesive

Fast drying, neoprene-based adhesive bonds rubber, insulation, weatherstripping, and other porous materials. Sets to a tack-free surface in 3-4 minutes. Allows repositioning of parts after initial contact. Withstands freezing temperatures.

Loctite® All-Purpose Spray Adhesive

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

Loctite® Maximum Strength Headliner Adhesive

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

LOCTITE® BRAND ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Temperature Resistance	Adhesive Appearance	Common Surfaces Adhesive Will Bond	Bond Time*	Agency Approvals
330™ Depend® Adhesive	20251 20252	Kit - 25 ml syr. applicator 25 gm aerosol activator Kit - 250 ml tube 4.5 oz. aerosol activator	-60 to 250°F (-51 to 121°C)	Amber liquid	Glass, wood, metal, concrete, ceramic, rubber	Set-up - 1-2 minutes Full Strength - 24 hours	-
380™ Black Max® Instant Adhesive	38004 38050	3 gm net wt. tube 1 oz. net wt. bottle	-65 to 225°F (-54 to 107°C)	Black liquid	Metal, plastic, rubber	Set-up - 90-150 seconds Full Strength - 24 hours	-
404™ Quick Set™ Instant Adhesive	46551 46548	1/3 oz. net wt. bottle 4 oz. net wt. bottle	-65 to 180°F (-54 to 106°C)	Clear liquid	Metal, plastic, rubber	Set-up - 20-40 seconds Full Strength - 24 hours	ABS, CFIA, Commercial item std. A-A-3097
Quicktite® Instant Adhesive Gel NEW	39202	0.14 oz. net wt. bottle	-65 to 180°F (-54 to 106°C)	Clear gel	Metal, plastic, rubber, cork, cardboard, leather	5-30 seconds	-
Contact Adhesive	30537	5 fl. oz. tube, box	180°F	Thick yellow liquid	Weatherstripping, vinyl, rubber, wood, metal	Let dry 3-4 min. before assembly. Sets on contact.	CFIA
Black Contact Adhesive	30540	5 fl. oz. tube, box	180°F	Thick black liquid	Weatherstripping, vinyl, rubber, wood, metal	Let dry 3-4 min. before assembly. Sets on contact.	CFIA
All-Purpose Spray Adhesive	30544	10.5 oz. net wt. aerosol	100 to 120°F (38 to 49°C)	Clear-drying semi-translucent foam	Lightweight porous and non-porous materials	Let dry 15-20 min. before assembly. Sets on contact.	-
Maximum Strength Headliner Adhesive	37312	16.75 oz. net wt. aerosol	100 to 170°F (38 to 77°C)	Clear-drying semi-translucent foam	Foam, carpet, fabrics, plastics, rubber	Let dry 15-20 min. before assembly. Sets on contact.	-

* Times are based on bonding steel to steel parts.

For technical information and/or product availability, call: 1-800-LOCTITE (562-8483) or visit us on the web at:

www.loctite.com





Loctite® brand anti-seize compounds are a group of premium quality products, developed to protect metal parts from rust, corrosion, galling, and seizing. They ease assembly and disassembly of slip-fit, press-fit, and threaded joints and reduce friction and wear on critical operating equipment. Formulated for severe industrial environments, these products protect against high temperatures, heavy loads, chemicals, pounding, and vibration.

ANTI-SEIZE

Loctite® C5-A® Copper Based 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). Tested to MIL-PRF-907E.

NEW

Loctite® QuickStix™ C5-A® Copper Anti-Seize

The same trusted performance characteristics as the Loctite® C5-A® Copper Based Anti-Seize paste in a convenient semi-solid stick form. Stick package offers more portability and less mess. Qualified to performance requirements of MIL-PRF-907E and CFIA approved.



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). Tested to MIL-PRF-907E. Approved by the American Bureau of Shipping and CFIA.

NEW

Loctite® QuickStix™ Silver Grade Anti-Seize

New semi-solid stick offers the same performance characteristics as the Loctite® Silver Grade Anti-Seize paste in a convenient semi-solid stick form. Stick package offers more portability and less mess. Qualified to performance requirements of MIL-PRF-907E and CFIA approved.

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). Approved by the American Bureau of Shipping.

Loctite® Heavy Duty Anti-Seize

Metal-Free

Excellent lubricity. Provides outstanding lubrication to all metals including stainless steel, aluminum, and soft metals up to 2400°F (1315°C).

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® Marine Grade Anti-Seize

Metal-Free

Formulated 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 wash-out and water spray resistance, and prevents galvanic corrosion. Protects in temperatures from -20°F to 2400°F (-29°C to 1315°C). Approved by the American Bureau of Shipping.

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-50™ Anti-Seize

Metal-Free

General purpose, thread lubricant. Temperature resistant to 750°F (400°C). Provides excellent lubricity. Meets the performance requirements of MIL-PRF-83483.

Loctite® Zinc Anti-Seize

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

Loctite® Food Grade Anti-Seize

Metal-Free

Prevents seizure, galling, and friction in stainless steel and other metal parts up to 750°F (400°C). NSF H1 approved for incidental food contact.

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).

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

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

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® White Hi-Temp Anti-Seize

Metal-Free

A 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.



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 which 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 2/3 (or 67%) of the torque coefficient.

LOCTITE® BRAND ANTI-SEIZE PROPERTIES CHART

PRODUCT	Item Number	Container	Temperature Resistance	Color	K Value
C5-A® Copper Based Anti-Seize Lubricant	51299	2 gm pouch	1800°F (982°C)	Copper	0.16
	51277	7 gm pouch			
	51001	1 oz. tube			
	51002	4 oz. tube			
	51144	4 oz. brush-top can			
	51147	8 oz. brush-top can			
	39647	8 oz. brush-top metal can			
	51005	10 oz. brush-top can			
	51003	12 oz. aerosol			
	51004	13 oz. cartridge			
	51006	1 lb. can			
	51007	1 lb. brush-top can			
	39643	1 lb. brush-top metal can			
	51008	2.5 lb. can			
	51009	8 lb. can			
38584	25 lb. pail				
51011	42 lb. pail				
51146	425 lb. drum				
NEW QuickStix™ C5-A® Copper Anti-Seize	37229 39222	20 gm stick 40 gm stick	1800°F (982°C)	Copper	0.16
Silver Grade Anti-Seize	38181 80209 76732 76759 76764 80206 76775	7 gm pouch 4 oz. brush-top can 8 oz. brush-top can 12 oz. aerosol 1 lb. brush-top can 1 gal. can 5 gal. pail	1600°F (871°C)	Silver	0.18
NEW QuickStix™ Silver Grade Anti-Seize	37230 39223	20 gm stick 40 gm stick	1600°F (871°C)	Silver	0.18
Nickel Anti-Seize	77124 51286 51102 77164 51152 77175	8 oz. brush-top can 12 oz. aerosol 1 lb. can 1 lb. brush-top can 8 lb. can 5 gal. pail	2400°F (1315°C)	Silver	0.13
Moly-50™ Anti-Seize	51094	1 lb. can	750°F (400°C)	Black	0.13
Zinc Anti-Seize	39901	1 lb. can	750°F (400°C)	Grey	0.15
Graphite-50™ Anti-Seize	51084	1 lb. can	900°F (482°C)	Black	0.13
Heavy Duty Anti-Seize	51609 51605 51606 51607 36354 51608	1 oz. tube 9 oz. brush-top can 1.2 lb. brush-top can 2.3 lb. can 8 lb. can 45 lb. pail	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
Moly Paste	51050 51048 51049 51145	12 oz. aerosol 8 oz. brush-top can 1 lb. brush-top can 15 lb. can	750°F (400°C)	Black	0.11
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
White Hi-Temp Anti-Seize	34517 34518	8 oz. brush-top can 16 oz. brush-top can	2000°F (1093°C)	White	0.16
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
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-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

LOCTITE® BRAND ANTI-SEIZE APPLICATION SELECTION GUIDE

PRODUCT	Maximum Anti-Seize Properties	General Purpose Anti-Seize	Extreme High Temperature Resistance (to 2000°F-2400°F)	High Temperature Resistance (to 1600°F-1800°F)	Extreme Chemical Resistance	For Maximum Lubricity	Electrically Conductive	For Aluminum/Soft Metals	For Stainless Steel	Copper-Free Formulation	For Low Speeds, High Loads	High Purity	Metal-Free	Water Applications
C5-A® Copper Based Anti-Seize Lubricant	●	●		●			●	●	●					
Silver Grade Anti-Seize	●	●		●			●	●	●					
Nickel Anti-Seize	●		●		●		●		●	●				
Moly-50™ Anti-Seize	○					●			●	●	●		●	
Zinc Anti-Seize	○						○	●	●					
Graphite-50™ Anti-Seize	○	○			●		●	●		●			●	
Heavy Duty Anti-Seize	●		●		●		●	●	●	●			●	
Marine Grade Anti-Seize	●		●						●	●			●	●
Moly Paste	○					●			●	●	●		●	
Food Grade Anti-Seize	○							●	●	●			●	
White Hi-Temp Anti-Seize	●	●	●					●	●	●			●	
N-1000™ High Purity Anti-Seize	●						●		●			●		
N-5000™ High Purity Anti-Seize	●		●		●		●		●	●		●		
High Performance N-5000™ High Purity Anti-Seize	●		●		●	●	●		●	●		●		
N-7000™ High Purity Anti-Seize	●		●		●		●		●	●		●	●	

● Preferred Choice ● Good Choice ○ Acceptable Choice

Loctite® brand Metal-Free Anti-Seize products





Loctite® brand Big Foot™ Epoxy Flooring Products provide tough, long-lasting anti-skid surfaces for added safety. Easily applied to potentially hazardous surfaces, Loctite® brand Big Foot™ coatings stand up to heavy traffic and harsh environments.

ANTI-SLIP COATINGS

Loctite® Big Foot™ Heavy Duty Pedestrian Grade

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

Loctite® Big Foot™ Acrylic Pedestrian Grade

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

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™ Metal Primer

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

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 Primer

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

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.

LOCTITE® BRAND BIG FOOT™ ANTI-SLIP COATINGS PROPERTIES CHART

PRODUCT	Item Number	Container	Coverage	Color	Maximum Temperature, °F	Working Time, Minutes	Functional Cure, Hours*	Agency Approvals
Big Foot™ Heavy Duty Pedestrian Grade	96211 96261 96265	1 gal. can 1 gal. can 5 gal. pail	50 ft ² per gallon	Black Grey Grey	140	N/A	12/72	CFIA
Big Foot™ Acrylic Pedestrian Grade	95591	1 gal. pail	70 ft ²	Grey	140	N/A	4/24	CFIA
Big Foot™ Vehicular Grade	96221 96251 96255	1 gal. kit 1 gal. kit 5 gal. kit	40 ft ² per gallon	Black Grey Grey	140	120	12/72	CFIA
Big Foot™ Zero V.O.C.	39915	1 gal. kit	35 ft ² per gallon	Grey	140	60	24/72	CFIA
Big Foot™ Metal Primer	96132	1 gal. kit	250 ft ²	Grey	140	240	12	-
Big Foot™ Acrylic Primer	95581	1 gal. pail	250 ft ²	Clear	140	N/A	1-2	-
Big Foot™ Water Based Primer/Sealer	94142	1 gal. kit	320 ft ²	Clear	140	120	3-6	-

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

LOCTITE® BRAND BIG FOOT™ ANTI-SLIP COATINGS APPLICATION SELECTION GUIDE

PRODUCT	Asphalt	Wood	Concrete	Metal	Flexible Coating	Weather Resistant	Water-Based	Chemical Resistant	Anti-slip Pedestrian	Anti-Slip Vehicular	Anti-Slip Zero V.O.C.
Big Foot™ Heavy Duty Pedestrian Grade		●	●	●				●	●	◐	
Big Foot™ Acrylic Pedestrian Grade	●	●	●	●	●	●			●		
Big Foot™ Vehicular Grade		●	●	●				●	◐	●	
Big Foot™ Zero V.O.C.		●	●	●				●	◐	◐	●

● Preferred choice ◐ Good choice

LOCTITE® BRAND BIG FOOT™ ACCESSORIES SELECTION GUIDE

PRODUCT	Item Number	Quantity	
Phenolic Rollers	96121	4/case	For use with Loctite® Big Foot™ Heavy Duty, Vehicular and Zero V.O.C. Grades
Bristle Rollers	96153	2/case	For use with Loctite® Big Foot™, Acrylic Pedestrian Grade, Acrylic Primer, Metal Primer and Water Based Primer/Sealer
Mixer Blades	96131	1/case	For use with all Loctite® Big Foot™ Coatings (1 gallon kits only)





Loctite® brand Fixmaster® Belt Repair Products are tough urethanes designed to repair conveyor belts and other damaged rubber equipment quickly and easily. Durable, flexible repairs can be performed using formulas for temporary or lasting wear.

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. 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/ URETHANES

Loctite® Fixmaster® Rapid Rubber Repair

Urethane
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® Instant Belt Repair

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

Loctite® Fixmaster® Flex™ Conveyor Belt Repair Kit

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

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® BRAND ACCESSORIES CHART

PRODUCT	Item Number	Container	Coverage	Color
Flex™ Metal Primer Promotes adhesion to metal parts	98471	3.3 fl. oz. can	Approx. 1 can of each product for 2 lbs. of urethane	Clear
Etching Agent Enhances bonds to rubber	99626	3 fl. oz. bottle		Clear
Flex™ Accelerator Speeds the cure of Flex™ urethanes	97273	3.5 fl. oz. can		Clear
Flex™ Cleaner Cleans and primes surfaces	39636	4 fl. oz. can	N/A	Clear

LOCTITE® BRAND FIXMASTER®
BELT REPAIR/URETHANE
PROPERTIES CHART

PRODUCT	Item Number	Container	Coverage, in. ² @ 1/4" Thickness	Color	Maximum Operating Temperature, °F	Adhesive Tensile Strength, psi	% Elongation	Hardness (Shore A)	Working Time, Minutes	Functional Cure, Hours	Mix Ratio by Volume, r : h	Mix Ratio by Weight, r : h	Agency Approvals
Fixmaster® Rapid Rubber Repair	96677	400 ml kit	88	Black	180	1,300	360	82	1	2	1:1	N/A	-
	96675	400 ml cartridge	33										
Fixmaster® Instant Belt Repair	37719	1 lb.	115	Yellow	150	400	650	65	N/A	30 min.	N/A	N/A	-
Fixmaster® Flex™ Conveyor Belt Repair Kit	98693	1 lb. kit	94	Black	180	1,500	350	87	10	8	100:40	72:28	-
Fixmaster® Flex 80™ Liquid	97413	1 lb. kit	27 in. ³ 162 in. ³	Black	180	1,800	350	87	20	8	100:13.3	77:23	-
	97412	6 lb. kit											
Fixmaster® Flex 80™ Putty	97423	1 lb. kit	94 564	Black	180	1,500	350	87	10	8	100:40	72:28	ABS
	97422	6 lb. kit											
Fixmaster® Rapid Rubber Repair Dispenser	39635	Required for use with 400 ml 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 400 ml cartridge											

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

LOCTITE® BRAND FIXMASTER®
BELT REPAIR/URETHANE
APPLICATION
SELECTION GUIDE

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® Instant Belt Repair			●					
Fixmaster® Flex™ Conveyor Belt Repair Kit		●						
Fixmaster® Flex 80™ Liquid	●			●				●
Fixmaster® Flex 80™ Putty	●				●	●	●	

● Preferred Choice ● Good Choice





The Loctite® brand offers a complete line of highly effective general purpose or application-specific cleaners and degreasers. Included are both aqueous and solvent-based products, all of which are free of Class I ozone-depleting chemicals (ODCs).

CLEANERS

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, non-flammable and non-toxic. Contains no ozone-depleting chemicals (ODCs).

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).

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® 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® Non-Chlorinated Parts Cleaner

Penetrates, dissolves, and removes dirt and oil from metal parts. Leaves no residue. Does not contain 1,1,1-trichloroethane; helps manage EPA halide limits.

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.

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® Chisel® Gasket Remover (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.

Loctite® Chisel® MC-Free Gasket Remover

Free of Methylene Chloride, Loctite® Chisel® MC-Free Gasket Remover has a foaming action that lifts off gaskets from any type of assembly in minutes. Performs better than Methylene Chloride formulations on silicone gaskets and removes most spray paints from steel panels in less than 30 seconds. Convenient spray liquid penetrates and cleans intricate shapes and will not run off, even on vertical surfaces. Suitable for wood and plaster. Not for use on plastics, linoleum, or synthetic fibers.

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, non-corrosive.



Loctite® Non-Flammable Electrical Contact Cleaner

Used as an electrical contact cleaner to remove grease, dirt, oil, and other surface contaminants from sensitive electrical/electronic parts. Non-flammable, fast evaporating and leaves no residue. Contains no HCFCs or CFCs.

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® Electrical Contact Cleaner

Non-Flammable

Removes grease, oil, and other contaminants from electrical parts to prevent contact failure. Dries residue-free in seconds. Non-conductive, non-corrosive, non-flammable. Contains no CFCs or Class I ODCs. Contains HCFC-141b. May attack some sensitive plastics.

Loctite® Industrial Strength Paint Stripper

Quickly strips and removes paint. Eliminates sanding and scraping. Works in 10-15 minutes at temperatures from -40°F to 100°F. Contains no ozone-depleting chemicals (ODCs).

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 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.



LOCTITE® BRAND CLEANER PRODUCTS
APPLICATION CHART

P R O D U C T	Function	Application
Natural Blue® Biodegradable Cleaner & Degreaser	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.
Natural Blue® Biodegradable Cleaner & Degreaser (Fragrance-Free)	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.
Aqua Power® Biodegradable Cleaner & Degreaser	Biodegradable cleaner for removing oil, grease, and asphalt.	All-purpose metal parts cleaner.
ODC-Free Cleaner & Degreaser	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.
Non-Chlorinated Parts Cleaner	Cleaner for removing oil, grease, and asphalt with no chlorinated solvent run-off.	All-purpose metal parts cleaner. Ideal for aluminum surfaces.
Pro Strength Degreaser	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.
Pro Strength Parts Cleaner	Removes oil, grease, brake fluids, oxidized oils (gum), and asphalt. Penetrates through dirt and corrosion and flushes them away.	All-purpose metal parts cleaner.
Pro Strength Varnish Remover	Dissolves and cleans residue deposited during normal operation of gasoline engine powered equipment.	Carburetors, chokes, linkages, heat risers, PCV valves, metal parts, industrial equipment.
Electrical Contact & Parts Cleaner	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.
Multi-Purpose Glass Cleaner	Deodorizes and cleans window film.	Glass, chrome, aluminum, stainless steel and enamel finishes, plastics.
Electrical Contact Cleaner	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. Non-flammable.	Switches, relays, motor controls, pc boards, connectors, tape heads, sensors, control panels, electrically driven equipment.
Non-Flammable  Electrical Contact Cleaner	Removes grease, dirt, oil, and flux from sensitive electrical/electronic devices.	Cleans motorized instruments, control panels, electrically driven equipment, motors and other electronic devices.
Industrial Strength Paint Stripper	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.
Chisel® Gasket Remover	Removes pre-cut conventional gasket cements as well as formed-in-place chemical gaskets.	Removing silicones, baked-on gaskets, gaskets from aluminum and small, difficult-to-reach components, weatherstrip adhesive, dried oil, grease, paint, varnish.
Chisel® MC-Free Gasket Remover	Removes pre-cut conventional gasket cements as well as formed-in-place chemical gaskets.	Removing silicones, baked-on gaskets, gaskets from aluminum and small, difficult-to-reach components, weatherstrip adhesive, dried oil, grease, paint, varnish.
Industrial Hand Wipes	Removes grease, grime, oil, soot, paints, and ink.	Removes grease, grime, oil, soot, paints, and ink from surfaces. Removes grease and grime from hands.

LOCTITE® BRAND CLEANER PRODUCTS
 PROPERTIES CHART

PRODUCT	Item Number	Container	Drying Time	Residue/Rinsibility	Odor
Natural Blue® Biodegradable Cleaner & Degreaser	82244 82249 82251 82253 82254 82255	4 fl. oz. bottle 24 fl. oz. spray bottle 1 gal. bottle 5 gal. pail 15 gal. pail 55 gal. 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 gal. bottle 55 gal. 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	5-15 minutes	No rinse and no residue	Mild solvent
ODC-Free Cleaner & Degreaser	22355 20162 20260	15 oz. net wt. aerosol 16 fl. oz. pump spray 1 gal. can	5-20 minutes (without wipe) 1-2 minutes (with wipe)	No rinse and no residue	Mild citrus
Non-Chlorinated Parts Cleaner	30545	14.75 oz. net wt. aerosol	5-15 minutes	No rinse and no residue	Mild solvent
Pro Strength Degreaser	30521	15 oz. net wt. aerosol	Leave on surface 10 minutes	Rinses clean	Mild solvent
Pro Strength Parts Cleaner	30548	19 oz. net wt. aerosol	5-15 minutes	No rinse and no residue	Mild solvent
Pro Strength Varnish Remover	30529	12 oz. net wt. aerosol	5 minutes	No rinse and no residue	Aromatic
Electrical Contact & Parts Cleaner	25791	11 oz. net wt. aerosol	<30 seconds	No rinse and no residue	Mild solvent
Multi-Purpose Glass Cleaner	30546	18.75 oz. net wt. aerosol	Wipes dry	No residue, wipes clean	Orange scent
Electrical Contact Cleaner	24379	15 oz. net wt. aerosol	<30 seconds	No rinse and no residue	Mild solvent
Non-Flammable  Electrical Contact Cleaner	36646	14 oz. net wt. aerosol	<30 seconds	No rinse and no residue	Solvent
Industrial Strength Paint Stripper	81716	18 oz. net wt. aerosol	10 minutes	Rinses residue-free with water	Acrid
Chisel® Gasket Remover	79040	18 oz. net wt. aerosol	Leave on surface 10-15 minutes. Wipe/scrape clean	Waxy residue	Mild solvent
Chisel® MC-Free Gasket Remover	34663	15.25 oz. net wt. aerosol	Leave on surface 5-10 minutes. Wipe/scrape clean	Oily residue	Solvent
Industrial Hand Wipes	34943 34944	75 count canister 130 count bucket	1-5 minutes	No rinse and no residue	Mild citrus



Henkel offers a variety of Loctite® brand 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.

COATINGS

Loctite® Color Guard®

Tough Rubber Coating
 Inhibits rust and corrosion; seals, insulates, and identifies almost any material in minutes. Creates a non-slip gripping surface. Rubber coating won't crack or chip. Acid and alkali resistant. Lasts for years. Use to 200°F. Dip, spray, or brush to apply. Suggested applications include: tools, metal, electrical connections, masonry, wood, conveyors, glass, rope, fabric. Now toluene-free.

Loctite® Belt Dressing & Conditioner

Extends belt life. Penetrates the cord fibers of "V" belts to restore pliability and flexibility. Prevents belt slippage due to heat, cold, dampness, and dust. Eliminates squeaking and glazing.

Loctite® Extend® Rust Treatment

One-step rust treatment goes on white and converts rust to a durable, black, metal-protective coating in 10 minutes. Wirebrush parts and apply with brush or spray. Surface rust must be present. Use as a primer or finish coat. Resists temperatures to 250°F intermittent, 200°F continuous.

Loctite® Heavy-Duty Rubberized Undercoating

This 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 which seals out moisture, air, acid, and other corrosive elements. Great for protecting parts in storage. Removable.

Loctite® Cold Galvanizing Compound

Sprays on metal surfaces to prevent corrosion even when 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® BRAND COATINGS
PROPERTIES CHART

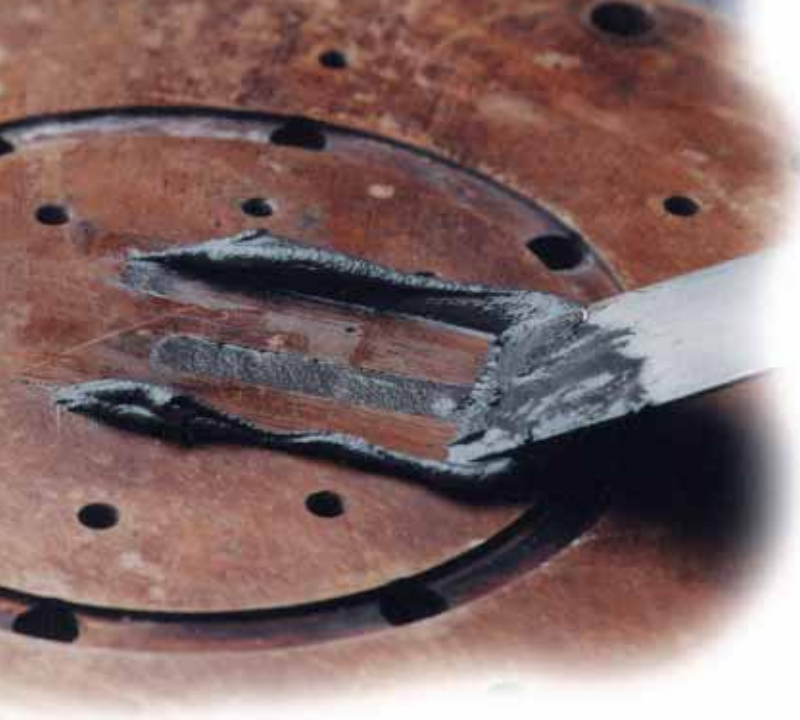
PRODUCT	Item Number	Container	Coating Appearance	Coating Thickness	Dry Time	Temperature Resistance	Moisture Resistance	Salt Spray Test	Accelerated Weather Test	Agency Approvals
Color Guard®	34894	11 oz. aerosol	Black	1 dip:	4 hours (allow 30 minutes between coats)	-30°F to 200°F	Excellent/ASTM E-96	Passed 1000 hours/ASTM B-117	10 years with slight loss of thickness/ASTM G-53-84	CFIA
	34979	14.5 fl. oz. can	Black	8-10 mil						
	34980	1 gal. can	Black							
	34981*	54 gal. drum	Black	1 Spray:						
	34895	11 oz. aerosol	Blue	3-5 mil						
	34982	14.5 fl. oz. can	Blue							
	34983	1 gal. can	Blue							
	34984*	54 gal. drum	Blue							
	34896	11 oz. aerosol	Red							
	34985	14.5 fl. oz. can	Red							
	34986	1 gal. can	Red							
	34987*	54 gal. drum	Red							
	34897	11 oz. aerosol	Yellow							
34988	14.5 fl. oz. can	Yellow								
34989	1 gal. can	Yellow								
34991*	54 gal. drum	Yellow								
Primer for Color Guard®	34994	1 gal. can	Grey	.5-1 mil	10-15 minutes	-	-	-	-	-
Thinner for Color Guard®	34995	1 gal. can	-	-	-	-	-	-	-	-

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

LOCTITE® BRAND COATINGS
PROPERTIES CHART

PRODUCT	Item Number	Container	Coating Appearance	Dry Time	Temperature Resistance	Agency Approvals
Belt Dressing & Conditioner	30527	12 oz. net wt. aerosol	White	N/A	Up to 200°F (93°C)	CFIA
Extend® Rust Treatment	30539	10.25 oz. net wt. aerosol	Converts from a white liquid to a black coating	30 minutes to touch	Up to 250°F (121°C)	ABS, CFIA
	75430	1 qt. bottle				
	75448	1 gal. bottle				
	75465	5 gal. pail				
Heavy-Duty Rubberized Undercoating	30538	16 oz. net wt. aerosol	Brown to black film	20 minutes to touch	Up to 200°F (93°C)	-
Maxi-Coat™	51211	12 oz. net wt. aerosol	Brown	N/A	Up to 200°F (93°C)	-
	51213	1 gal. can				
Cold Galvanizing Compound	82039	15 oz. net wt. aerosol	Low gloss grey	15 minutes to touch	Up to 400°F continuous; 600°F intermittent	CFIA





Loctite® brand Fixmaster® Filled and General Purpose Epoxies repair, rebuild, and restore damaged parts to quickly return equipment to service. Cured epoxies can be drilled, tapped, and machined – just like the original metal. These non-shrinking products are available in a range of performance characteristics for specific applications. Each epoxy is capable of bonding to metal, ceramic, wood, glass, and some plastics.

EPOXIES

FIXMASTER® EPOXIES

Loctite® Fixmaster® 4 Minute Epoxy

Translucent, gel-like adhesive. Sets up in 4-6 minutes. Temperature resistant up to 160°F. Ideal for emergency repairs or where reduced fixturing time is desirable. Cartridge requires manual cartridge dispenser gun (Item number 983531).

Loctite® Fixmaster® Poxy Pak™

Fast Cure Epoxy
This fast cure, high strength, thick liquid reaches handling strength in 4-6 minutes. Bonds virtually any material to repair, fill, and seal holes, cracks, and worn surfaces.

Loctite® Fixmaster® Fast Cure Epoxy

Mixer Cups
Premeasured epoxy mixer cups. Bonds in 5-15 minutes. Excellent chemical resistance. Fills porosities and can be used to build up worn parts. Ideal for bonding glass, hard plastics, rubber, and metal.

Loctite® Fixmaster® General Purpose Epoxy

Mixer Cups
Premeasured epoxy mixer cups. One hour working time. Fills porosities and can be used to build up worn parts. Ideal for bonding glass, hard plastics, rubber, and metal.

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. It is hand kneadable and fully cures in 1 hour.

Loctite® Fixmaster® High Performance Epoxy

Fiberglass reinforcement gives this adhesive outstanding tensile, shear strength, and shock resistance up to 180°F. Recommended for forming permanent, water-resistant bonds in production and maintenance applications. Cartridge requires manual cartridge dispenser gun.



Loctite® Fixmaster® Concrete Repair Epoxy

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

FIXMASTER® METAL FILLED EPOXIES

Loctite® Fixmaster® Fast Set Steel Epoxy

Steel filled. Reaches functional cure in 10 minutes. Temperature resistant up to 200°F. Recommended for repairing pipes and other equipment that must be back in service in minutes. Cartridge requires manual cartridge dispenser gun.

Loctite® Fixmaster® Static Mixers

Mixing nozzles for use with Fixmaster® 50 ml epoxy cartridges. (Not for use with Rapid Rubber Repair).

Loctite® Fixmaster® Aluminum Liquid

Two-part, pourable epoxy system heavily reinforced with aluminum powder. For casting and repairing of aluminum parts, and for making molds and fixtures.

Loctite® Fixmaster® Aluminum Putty

Aluminum filled epoxy rebuilds and repairs aluminum equipment, forming a non-rusting finish.

Loctite® Fixmaster® Fast Set Steel Putty

Steel filled, non-sagging epoxy for filling and repairing damaged metal parts quickly. Functional cure in about 10 minutes.

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. Certified and approved for use with drinking water system components.

Loctite® Fixmaster® Stainless Steel Putty

Stainless steel filled. Forms a non-rusting, very hard, durable finish on damaged stainless steel surfaces.

Loctite® Fixmaster® Steel Liquid

Steel filled. Pourable and self-leveling. Epoxy is recommended for casting into hard-to-reach areas, anchoring and leveling, and forming molds and fixtures.

Loctite® Fixmaster® Steel Putty

Steel filled, non-sagging, two-part epoxy that cures to a metal-like finish for rebuilding or repairing metal parts.

Loctite® Fixmaster® Superior Metal

Ideal for renewing or protecting surfaces subject to corrosion, abrasion, and harsh environments. Ferro-silicon-filled epoxy has outstanding compressive strength, chemical resistance. Non-rusting.

Loctite® Fixmaster® Wear Resistant Putty

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

Loctite® Fixmaster® Wet Surface Repair Putty

Use this unique, trowelable epoxy to repair and rebuild wet, even underwater, surfaces. Bonds to wood, concrete, steel, iron, aluminum, brass, and some plastics.



LOCTITE® BRAND
FIXMASTER® EPOXY
PROPERTIES CHART

PRODUCT	Item Number	Container	Color (cured)	Temperature Resistance, °F	Adhesive Tensile Shear, psi	Working Time, Minutes	Fixture Time †	Full Cure	Agency Approvals
Fixmaster® Poxy Pak™	81120	1 oz. syringe	Clear	300	2,300	1	4-6 min.	1 hour	ABS, CFIA
Fixmaster® High Performance Epoxy	99393 99394 99392	1 oz. syringe 50 ml cartridge 2 gallon kit	Tan	180	3,800	30	8 hrs.	24 hours	CFIA
Fixmaster® 4 Minute Epoxy	97434	50 ml cartridge	Translucent	160	2,000	3-4	10 min.	1 hour	-
Fixmaster® Underwater Repair Epoxy	82093	4 oz. stick	White	300	900	15	30 min.	1 hour	CFIA
Fixmaster® Fast Cure Epoxy (Mixer Cups)	21425 21426 39088	10 - .12 fl. oz. cups 10 - 1 oz. cups 4 - .12 fl. oz. cups	Grey	180	2,000	5	10 min.	12 hours	CFIA
Fixmaster® General Purpose Epoxy (Mixer Cups)	21427	10 - .12 fl. oz. cups	Translucent	180	2,000	60	1.5 hrs.	24 hours	CFIA
Fixmaster® Concrete Repair Epoxy NEW	39366	4 oz. stick	Grey	250	600	4-7	5-10 min.	1 hour	-
Manual Cartridge Applicator	983531	Required for use with 50 ml Loctite® Fixmaster® Epoxies.							
Fixmaster® Static Mixers	983441	Packaged 10/bag - for mixing and dispensing epoxies in 50 ml containers.							

Properties based on ultimate cure.

Epoxy properties based on mixing 20 g mass at 77°F.

† Time to reach handling strength.

LOCTITE® BRAND
FIXMASTER®
EPOXY BONDING
CHARACTERISTICS

PRODUCT	Gap Filling	Fast Cure Time	Ferrous Metal Repair	Toughened Formulation	Shock Resistance	Water Resistance	Plastic Bonding	Rubber Bonding	Metal Bonding	Sandable Finish	Paintable Finish
Fixmaster® Poxy Pak™		●					◐		◐	●	●
Fixmaster® High Performance Epoxy	●		○	●	●	●	◐	○	●	●	●
Fixmaster® 4 Minute Epoxy	●	●	○		○	○	○		◐	●	●
Fixmaster® Underwater Repair Epoxy	●	●			●	●	◐		●	●	●
Fixmaster® Fast Cure Epoxy (Mixer Cups)	◐	◐					○	○	◐	●	○
Fixmaster® General Purpose Epoxy (Mixer Cups)	◐						○	○	◐	●	○
Fixmaster® Concrete Repair Epoxy	●	●		◐	○	●	○		●	●	●

● Preferred choice ◐ Good choice ○ Acceptable choice

LOCTITE® BRAND FIXMASTER®
METAL-FILLED EPOXIES
PROPERTIES CHART

PRODUCT	Item Number	Container	Coverage, ft. ² at 1/4" Thickness	Color	Maximum Operating Temperature, °F	Compressive Strength, psi †	Tensile Strength, psi †	Hardness (Shore D)	Working Time, Minutes	Functional Cure, Hours	Mix Ratio by Volume, r : h	Mix Ratio by Weight, r : h	Agency Approvals
Fixmaster® Superior Metal	97473	1 lb. kit	0.25	Dark Grey	250	18,000	5,500	90	20	6	4:1	7.25:1	CFIA
Fixmaster® Steel Putty	99913 99914 99912	1 lb. kit 4 lb. kit 25 lb. kit	0.3 1.2 7.5	Grey	225	11,100	4,900	85	30	6	2.5:1	6.25:1	ABS, CFIA
Fixmaster® Fast Set Steel Putty	39917	1 lb. kit	0.4	Grey	200	10,800	4,600	80	3	10 min.	1:1	1.8:1	ABS, CFIA
Fixmaster® Fast Set Steel Epoxy	96604	50 ml cartridge	3.2 in. ³	Grey	200	11,000	2,600	80	3	10 min.	1:1	100:73	CFIA
Fixmaster® Aluminum Putty	97463	1 lb. kit	0.5	Alumin.	200	11,300	4,000	87	20	6	4:1	6.3:1	ABS, CFIA
Fixmaster® Wear Resistant Putty	98742 98743	1 lb. kit 3 lb. kit	0.36 1.1	Grey	225	11,600	4,900	89	30	6	2:1	2:1	ABS, CFIA
Fixmaster® Wet Surface Repair Putty	96583	1 lb. kit	.05	Grey	150	12,500	3,500	85	30	18	1:1	10:9	ABS
Fixmaster® Metal Magic Steel™	98853	4 oz. stick	7 in. ²	Grey	250	12,000	2,500	80	3	10 min.	N/A	N/A	-
Fixmaster® Stainless Steel Putty	97443	1 lb. kit	0.25	Grey	225	12,000	4,600	85	20	6	4:1	9:1	ABS, CFIA
Fixmaster® Steel Liquid	97483 97484	1 lb. kit 4 lb. kit	13 in. ³ 52 in. ³	Grey	225	13,500	6,000	86	25	6	4:1	9.5:1	ABS, CFIA
Fixmaster® Aluminum Liquid	97453	1 lb. kit	17 in. ³	Alumin.	200	17,000	6,000	85	20	6	5:1	9:1	ABS, CFIA

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

LOCTITE® BRAND FIXMASTER®
METAL-FILLED
EPOXY APPLICATION
SELECTION GUIDE

PRODUCT	Emergency Metal Repairs	Corrosion Protection	Repairing Pipes, Tanks	Rebuilding Shafts, Keyways, Bearings	Repairing Threaded Parts	Restoring Tube Sheets	Pump Repair	Repairing Engine Blocks	Fixtures and Prototypes	Rebuilding Impellers, Valves	Repairing Aluminum Parts	Repairing Stainless Steel Parts	Forming Molds, Fixtures	Wet Surface Repairs
Fixmaster® Superior Metal		●		●	●	●	●	●		●				
Fixmaster® Steel Putty			●					●		●			●	
Fixmaster® Fast Set Steel Putty	●		●					●						
Fixmaster® Fast Set Steel Epoxy	●		●		●							●		
Fixmaster® Aluminum Putty		●								●	●	●		
Fixmaster® Wear Resistant Putty		●		●		●	●	●		●				
Fixmaster® Wet Surface Repair Putty		●	●											●
Fixmaster® Metal Magic Steel™	●		●						●				●	●
Fixmaster® Stainless Steel Putty		●								●	●	●		
Fixmaster® Steel Liquid			●		●				●				●	
Fixmaster® Aluminum Liquid									●	●	●	●	●	

● Preferred Choice ● Good Choice



Loctite® brand Fixmaster® Flooring Products are specialty repair materials that fill or level industrial surfaces. A cost-effective, high-performance alternative to conventional flooring systems, these epoxies are non-shrinking and have good chemical and corrosion resistance, and high compression strength.

FLOORING & GROUT

**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®
Super Grout**

Fixmaster® Super Grout aggregate-filled epoxy system is 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). Loctite® Fixmaster® Super Grout is a 100% solids epoxy system that is non-shrinking, chemical and corrosion resistant, stronger than concrete, and withstands high torque loading.

**Loctite® Fixmaster®
Fast Set Grout**

Self-leveling, non-shrinking grout for installing machinery, 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®
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

Trowelable. For repairing and resurfacing cracks in concrete floors. Bonds to old and new concrete and provides greater strength and chemical resistance.



**Loctite® Fixmaster® Concrete
Repair Epoxy**

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

**Loctite® Fixmaster®
Magna-Crete**

A two-component, rapid setting concrete repair and grouting system. Chemically resistant to most common liquids and chemicals. Bonds to concrete, wood, glass, steel, and other construction materials.

**Loctite® Fixmaster®
Marine Chocking**

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

LOCTITE® BRAND FIXMASTER®
FLOORING & GROUT PROPERTIES CHART

PRODUCT			Coverage	Color	Mixed Viscosity, cP	Maximum Temperature, °F	Compressive Strength, psi	Working Time, Minutes	Functional Cure, Hours	Mix Ratio by Volume, r : h	Mix Ratio by Weight, r : h	Agency Approvals	
Grouts	Fixmaster® Deep Pour Grout	99545	5 gal. kit	660 in. ³	Black	Pourable	225	14,500	30	24	-	-	CFIA
	Fixmaster® Fast Set Grout	39637	2 gal. kit	347 in. ³	Red	5,500	200	14,500	10	12	100:11.7	100:6.5	CFIA
	Fixmaster® Super Grout	33510	5 gal. kit	620 in. ³	Red	Pourable	225	12,900	285	24	-	-	-
Floor Repair and Resurface	Fixmaster® Floor Fill	99361 99365	10 lb. kit 40 lb. kit	133 in. ³ 532 in. ³	Grey	Semi-Pourable	225	15,000	40	24	-	-	CFIA
	Fixmaster® High Performance Quartz	96495	42 lb. kit	15 ft. ² *	Grey	Paste	150	12,000	45 Primer 60 Topcoat	24	-	-	CFIA
	Fixmaster® Magna-Crete	95551 95555	1 gal. kit 5 gal. kit	4.8 ft. ² * 21.6 ft. ² *	Grey	-	2000	13,000	5-20	1-2	-	-	CFIA
	Fixmaster® Magna-Crete Activator	36334	10 lb. bottle	-	-	-	-	-	-	-	-	-	-
	Fixmaster® Concrete Repair Epoxy	39366	4 oz. stick	-	Grey	Putty	250	12,000	4-7	1	-	-	-
Chocking Compound	Fixmaster® Marine Chocking	39136 97572 96102 37316	1 gal. kit 2 gal. kit 2 gal. kit 1 gal. kit	167 in. ³ 370 in. ³ 370 in. ³ 167 in. ³	Green Green Orange Orange	15,000	250	22,000	10	24	100:11.6	100:6.9	ABS, CFIA

* Coverage at 1/4" thickness.

LOCTITE® BRAND FIXMASTER®
FLOORING & GROUT APPLICATION
SELECTION GUIDE

PRODUCT		Anchor Bolt Fastening	Chocking (ships)	Concrete Floor 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, Loading Docks	Highways, Roadways	Leveling Floors
Grouts	Fixmaster® Deep Pour Grout				●	●		●	●				
	Fixmaster® Fast Set Grout	●			●	●		●	●				
	Fixmaster® Super Grout				●	●	●	●					
Floor Repair and Resurface	Fixmaster® Floor Fill			●	●					●			
	Fixmaster® High Performance Quartz			●						●			
	Fixmaster® Magna-Crete			●		●		●			●	●	●
	Fixmaster® Concrete Repair Epoxy	●		●					●	●	●		
Chocking Compound	Fixmaster® Marine Chocking		●		●			●	●				

● Preferred choice ● Good choice





Loctite® brand gasketing products offer innovative, precise and reliable sealing. They can be applied manually or — for high volume assembly — can be applied by automated methods, such as tracing, stenciling, and screen printing.

A leader in form-in-place gasket makers, gasket dressings, and general purpose sealants, The Loctite® brand offers a choice of anaerobics, RTV silicones, or solvent-based products to meet broad gasketing and sealing needs.

GASKETING & SEALING

Loctite® 510™ Gasket Eliminator® Flange Sealant

A high temperature sealant engineered for making or dressing gaskets in rigid assemblies. Withstands temperatures to 400°F (204°C). Fills gaps up to 0.010" (0.254 mm) and permits clamping loads to be maintained for strong, leakproof assemblies.

Loctite® 518™ Gasket Eliminator® Flange Sealant

Ideal for on-the-spot and emergency repairs, or when a conventional gasket is out of stock. Seals to 300°F (149°C) and fills gaps to 0.050" (1.27 mm) with primer. Can be used on a variety of metal surfaces, including aluminum. Forms a flexible, solvent resistant seal that will not tear or decay. Parts disassemble easily.



Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant

Patented semi-solid 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, to form a flexible, solvent resistant seal. Seals to 300°F (149°C) and fills gaps to 0.010".



Loctite® Gasket Sealant 1

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

Loctite® Instant Gasket

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

Loctite® 598™ Black*High Performance RTV Silicone Gasket Maker*

Retains high flexibility and oil resistance for longer gasket life. Temperature range -75°F to 625°F (-59°C to 329°C) intermittent. Low odor, non-corrosive, low volatility. Resistant to most chemicals and solvents. Fills gaps to .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, non-corrosive, low volatility. Withstands temperatures to 500°F (260°C) intermittent. Resistant to most chemicals and solvents. Fills gaps to .25".

Loctite® 5699™ Grey*High Performance RTV Silicone Gasket Maker*

Remains flexible and withstands high vibration. Designed for high-torque applications. Withstands temperatures from -75°F to 625°F (-59°C to 329°C) intermittent. Outstanding oil and shop fluid resistance. Non-corrosive, low odor.

Loctite® 5920™ Copper*High Performance RTV Silicone Gasket Maker*

Premium silicone that can withstand operating environments to 700°F (371°C) intermittent. Superior oil resistance. Low odor, non-corrosive, low volatility, non-conductive. Resistant to most chemicals and solvents. Fills gaps to .25".

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 -65°F to 500°F (-54°C to 260°C) intermittent. Low volatility. Fills gaps to .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 .25".

Loctite® Superflex® Non-Corrosive RTV*Clear Silicone Adhesive Sealant*

Neutral curing and non-corrosive. 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.





Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing

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



Loctite® High Temperature Gasket Maker

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

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 -50°F to 500°F (-45°C to 260°C). Resists 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 sealer for close-fitting parts. Use to 400°F. Resistant to gasoline and other solvents.


LOCTITE® BRAND GASKET ELIMINATOR® FLANGE SEALANTS PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Viscosity cP/Consistency	Cured State	Temperature Range	Sealing Time	Gap Fill	Recommended Primer	Agency Approvals
510™ Gasket Eliminator®	51031	50 ml tube	Red	188,000/500,000 thixotropic paste	Rigid	-65 to 400°F (-54 to 204°C)	30 mins.-4 hrs. w/primer 4-24 hrs. without primer	.020" w/primer .010" w/o primer	7649™ Primer N™	UL Classified for U.S.
518™ Gasket Eliminator®	51817 51831	6 ml tube 50 ml tube	Red	800,000/3,750,000 thixotropic paste	Flexible	-65 to 300°F (-54 to 149°C)	30 mins.-4 hrs. w/primer 4-24 hrs. without primer	.050" w/primer .010" w/o primer	7649™ Primer N™	CFIA, NSF/ANSI 61
QuickStix™ 548™ Gasket Eliminator®	39151 39152 39153	9 gm stick 18 gm stick 37 gm stick	Orange	Semi-solid paste	Flexible	-65 to 300°F (-54 to 149°C)	>3 hours with or without primer	0.010"	7649™ Primer N™	-



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

LOCTITE® BRAND GASKETING AND SEALING PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Oil Resistance	Non-Corrosive	Temperature Range (Intermittent)	Sealing Time	Agency Approvals
Instant Gasket	30684 30509 30507	4 oz. can 5 oz. cartridge 7 oz. can	Black	Increased oil resistance	Non-corrosive	-75 to 500°F (-59 to 260°C)	Operating strength 15 psi -1 min.	GM 998-5990 Type I, Ford WSE-M4G323-A6, DaimlerChrysler MS-GF44 Grade A, CFIA
Superflex® RTV	59330 59375 30563 59530 59575 30562 59430 59475 82518	80 ml tube 300 ml cartridge 8 oz. can 80 ml tube 300 ml cartridge 8 oz. can 80 ml tube 300 ml cartridge 8 oz. can	Black Black Black Clear Clear Clear White White White	-	-	-65 to 450°F (-54 to 232°C)	Tack free - 30 min. Full strength - 24 hrs.	UL Classified for U.S., ULC Classified for Canada, NSF/ANSI 51, CFIA
Superflex® Blue RTV	30560 30533 30541 30518	80 ml tube 300 ml cartridge 8 oz. can 12 oz. tube	Blue	-	-	-65 to 500°F (-54 to 260°C)	Tack free - 30 min. Full strength - 24 hrs.	-
Superflex® Red High Temp RTV	59630 59675 30564 82279	80 ml tube 300 ml cartridge 8 oz. can 12 oz. tube	Red	-	-	-75 to 600°F (-59 to 316°C)	Tack free - 30 min. Full strength - 24 hrs.	CFIA
Superflex® Non-Corrosive RTV	51387 51388	80 ml tube 300 ml cartridge	Clear	Oil resistant	-	-75 to 500°F (-59 to 260°C)	Tack free - 25 min. Full strength - 24 hrs.	UL Classified for U.S.,
598™ Black	34018 59830 59875 59866 59891	0.5 oz. tube 70 ml tube 300 ml cartridge 8.75 oz. can 49 lb. pail	Black	Excellent oil resistance	Non-corrosive	-75 to 625°F (-59 to 329°C)	Tack free - 30 min. Full strength - 24 hrs.	ABS, CFIA
587™ Blue	58730 58775 30567 58791	70 ml tube 300 ml cartridge 8.75 oz. can 17 liter pail	Blue	Increased oil resistance	Non-corrosive	-75 to 500°F (-59 to 260°C)	Tack free - 30 min. Full strength - 24 hrs.	UL Classified for U.S., NSF P1, CFIA, ABS
5920™ Copper	30542 82046	70 ml tube 300 ml cartridge	Copper	Increased oil resistance	Non-corrosive	-65 to 700°F (-54 to 371°C)	Tack free - 60 min. Full strength - 24 hrs.	-
5699™ Grey	18718 18581	70 ml tube 300 ml cartridge	Grey	Increased oil resistance	Non-corrosive	-75 to 625°F (-59 to 329°C)	Tack free - 30 min. Full strength - 24 hrs.	-
Aviation Gasket Sealant	30517 30516	0.25 pt. brush can 1 pt. brush can	Dark reddish brown	Oil resistant	Non-corrosive	-65 to 400°F (-54 to 204°C)	Full strength - 12 hrs.	CFIA
Gasket Sealant 1	30510 30511 30512	1.5 oz. tube 3 oz. tube 7 fl. oz. tube	Reddish brown	Oil resistant	Non-corrosive	-65 to 400°F (-54 to 204°C)	Full strength - 24 hrs.	CFIA
Gasket Sealant 2	30513 30514 30515 80964	1.5 oz. tube 3 oz. tube 7 fl. oz. tube 5 gal. can	Black	Oil resistant	Non-corrosive	-65 to 400°F (-54 to 204°C)	Remains tacky	-
Hi-Tack Gasket Sealant	30524 30525 30526	0.25 pt. brush can 1 pt. brush can 9 oz. aerosol	Red	Increased oil resistance	Non-corrosive	-65 to 500°F (-54 to 260°C) Aerosol to 600°F	5 min. to set	-
QuickStix™ 534™ Hi-Tack Gasket Dressing 	39155 39156 39157	9 gm stick 19 gm stick 38 gm stick	Purple	Oil resistant	Non-corrosive	-65 to 300°F (-54 to 149°C)	5 min. to set	-
Copper Gasket Adhesive	30535	9 oz. aerosol	Copper	Oil resistant	Non-corrosive	-50 to 500°F (-45 to 260°C)	Remains tacky	-
High Temperature Gasket Maker	30558	7 fl. oz. tube	Black	Oil resistant	Non-corrosive	-50 to 600°F (-45 to 315°C)	3-5 hours to set	CFIA



A variety of penetrants, greases, and oils are available for lasting, general-purpose lubrication or specific applications.

Loctite® brand ViperLube® Synthetic-Based Lubricants provide superior protection for equipment exposed to a wide range of operating temperatures and environments and are NSF H1 rated for incidental food contact.

Formulated in partnership, Loctite® DuPont® Krytox® RFE Lubricants are, quite simply, the most advanced lubricants in the world. Featuring astonishing lubricity, extreme temperature resistance, nonflammability, and chemical inertness; Krytox® RFE Lubricants are the cost-effective solution to a broad range of challenging lubrication problems in a variety of industries.

LUBRICANTS

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. Non-flammable. Contains no ODCs. NLGI #2 grade grease. Opaque white in color.

Loctite® ViperLube® High Performance Synthetic Lubricant

Gear Oils – 90W, 140W
 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 Oils – 10W, 15W, 20W
 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.

Krytox® RFE PFPE Lubricant

This grease lubricant has excellent lubrication properties over a broad temperature range, will not cause cracking or swelling, and contains a corrosion inhibitor protecting against undue wear. Eliminates sticking and aids in disassembly. Non-flammable, chemically inert. Compatible with chlorine. See product description sheet for test results.

Krytox® RFE PFPE High Performance Lubricant

Specially-formulated, synthetic grease designed to provide long-lasting lubrication for all types of moving and/or sliding parts. This lubricant provides corrosion protection and wear resistance over a broad temperature range.

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 won't attract dirt or dust.

Krytox® RFE Cleaner

A multipurpose cleaner formulated to remove Krytox® RFE Lubricants. It will also remove standard hydrocarbon and synthetic-based lubricants. Krytox RFE® Cleaner is fast drying, residue-free, and formulated for tough industrial use. Cleans bearings, o-rings, seals, flanges, motors, sliding mechanisms, pumps, bushings, and more.

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® 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, resists water washout. Maintains pumpability at low temperatures; will not take a hard set after cooling.

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.

Loctite® Gear, Chain and Cable Lubricant

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

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® 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 ODCs.

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® Penetrating Oil

Penetrates, lubricates, and displaces moisture. Protects against rust and corrosion. Contains no ODCs.

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.

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 ODCs. CFIA approved.

Loctite® White Lithium Grease

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

**LOCTITE® BRAND
VIPERLUBE® SYNTHETIC LUBRICANTS
PROPERTIES CHART**

PRODUCT	Item Number	Weight	Container	Temperature Resistance	Type of Lubricant	Viscosity Grade	Pour Point (ASTM D 97)	Four Ball Test	NLGI Rating	Drop Point	Salt Spray Test (ASTM B 117)	Agency Approvals
ViperLube® High Performance Synthetic Grease	36780	-	1 cc tube	400°F (204°C) continuous 500°F (260°C) intermittent	Synthetic hydrocarbon (polyalphaolefin based)	240 CST	-	0.45 mm (ASTM D 2266)	2	500°F (260°C) (ASTM D 556)	Pass	NSF H1, CFIA
	36781	-	3 oz. tube									
	36782	-	14 oz. cartridge									
	36783	-	400 gm can									
	36784	-	0.42 oz. tube									
	36786	-	10.1 oz. aerosol can									
	37061	-	30 lb. pail									
	37710	-	120 lb. drum									
39146	-	55 gallon drum										
ViperLube® Clear High Performance Synthetic Grease NEW	39341	-	3 oz. tube	420°F (216°C) continuous 520°F (271°C) intermittent	Synthetic hydrocarbon (polyalphaolefin based)	-	-	0-60 mm (ASTM D 2266)	2	<590°F (<310°C) (ASTM D 2265)	-	NSF H1
	39342	-	400 gm cartridge									
	39364	-	30 lb. pail									
	39363	-	120 lb. keg									
ViperLube® High Performance Synthetic Lubricant Gear Oils NEW	36787	90W	1 gallon	450°F (232°C)	Synthetic hydrocarbon (polyalphaolefin based)	220 ISO	-30°C	0.48 mm (ASTM D 4172)	-	-	Pass	NSF H1, CFIA
	38350	90W	5 gallon									
	38351	90W	55 gallon									
	38878	140W	1 gallon									
	38879	140W	5 gallon									
	38880	140W	55 gallon									
ViperLube® High Performance Synthetic Lubricant Lightweight Oils NEW	36788	10W	1 gallon	450°F (232°C)	Synthetic hydrocarbon (polyalphaolefin based)	32 ISO	-75°C	0.40 mm (ASTM D 4172)	-	-	Pass	NSF H1, CFIA
	38352	10W	5 gallon									
	38353	10W	55 gallon									
	38872	15W	1 gallon									
	38873	15W	5 gallon									
	38874	15W	55 gallon									
	38875	20W	1 gallon									
	38876	20W	5 gallon									
	38877	20W	55 gallon									

**LOCTITE® BRAND
KRYTOX® RFE LUBRICANTS
PROPERTIES CHART**

PRODUCT	Item Number	Container	Temperature Resistance	Non-Flammable	High Load Capability	Corrosion Inhibitors	Compatible with all Plastics, Metals, Elastomers	Chemically-Resistant	Oxygen Compatible*	Thermally Stable	Water/Steam Resistant	NLGI Grade
Krytox® RFE PFPE Lubricant	29710	2 oz. tube	-15°F to 500°F (-26°C to 260°C)	●	●	-	●	●	●	●	●	2
	31361	16 oz. net wt. cartridge										
	31360	16 lb. pail										
Krytox® RFE PFPE High Performance Lubricant	29711 29709	2 oz. tube 16 oz. net wt. cartridge	-15°F to 500°F (-26°C to 260°C)	●	●	●	All plastics & 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	-
Krytox® RFE Cleaner	30615	10 oz. net wt. aerosol	-	-	-	-	-	-	-	-	-	-

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



LOCTITE® BRAND LUBRICANTS
 PROPERTIES CHART/APPLICATION
 SELECTION GUIDE

PRODUCT	Item Number	Container	Temperature Resistance	Food Processing Equipment	Close Fitting Parts	High Temperature	Electrically Conductive	Electrical Equipment	Gears, Bearings, Cable, Conveyors	Hydraulic Units (not brakes)	For High Speed Bearings	For Low Speeds, High Loads	Chain-Driven Equipment	Solid Film
C-200® High Temperature Solid Film Lubricant	39893 39894	1.3 lb. can 10 lb. can	2400°F (1315°C)			●	○					○		●
Dielectric Grease	30536	0.33 oz. tube	400°F (204°C)			○	○	○						
Extreme Pressure Grease	51242	14.5 oz. cartridge	450°F (232°C)			○					●			
Food Grade Grease	51252	14.5 oz. cartridge	450°F (232°C)	●		○					●			
Gear, Chain and Cable Lubricant	81251	12 oz. aerosol	-						●				●	
Hydraulic Jack Oil	30522 30523	1 qt. can 1 gal. can	120°F (48°C)							●				
Maintain® Lubricant Penetrant	81204	16 oz. aerosol	-		●			●						
Moly Dry Film Lubricant	39895 39896 39897	12 oz. aerosol 1.3 lb. can 10 lb. can	750°F (400°C)			○	○	●				○	●	●
Penetrating Oil	80032 51221	1 pt. spout can 12 oz. aerosol	100°F (38°C)		○									
Silicone Lubricant	81246 51360	13 oz. aerosol 5.3 oz. tube	400°F (204°C)	●		○			○				○	
Solvo-Rust® Super Penetrating Oil	81252	12.25 oz. aerosol	-		○									
White Lithium Grease	30530 30543	1.5 oz. tube 10.75 oz. aerosol	380°F (193°C) (dropping point)						○				○	
ViperLube® High Performance Synthetic Grease	36780 36781 36782 36783 36784 36786 37061 37710 39146	1 cc tube 3 oz. tube 14 oz. cartridge 400 gm can 0.42 oz. tube 10.1 oz. aerosol can 30 lb. pail 120 lb. barrel 55 gallon drum	400°F (204°C) continuous 500°F (260°C) intermittent	●	●	●	○	○	●		●	●	●	
ViperLube® Clear Synthetic Grease	39341 39342 39364 39363	3 oz. tube 400 gm cartridge 30 lb. pail 120 lb. keg	420°F (216°C) continuous 520°F (271°C) intermittent	●		●		●	●		●	●	●	
ViperLube® High Performance Synthetic Lubricant Gear Oils	36787 38350 38351 38878 38879 38880	1 gallon, 90 W 5 gallon, 90 W 55 gallon, 90 W 1 gallon, 140 W 5 gallon, 140 W 55 gallon, 140 W	450°F (232°C)	●	●	○			●				○	
ViperLube® High Performance Synthetic Lubricant Lightweight Oils	36788 38352 38353 38872 38873 38874 38875 38876 38877	1 gallon, 10 W 5 gallon, 10 W 55 gallon, 10 W 1 gallon, 15 W 5 gallon, 15 W 55 gallon, 15 W 1 gallon, 20 W 5 gallon, 20 W 55 gallon, 20 W	450°F (232°C)	●	●				●	●			○	

● Preferred Choice ○ Good Choice ○ Acceptable Choice





Loctite® brand Clover® Compounds have been in demand for over 80 years for cutting, smoothing, and polishing metal surfaces. Clover® compounds allow final finishing of metal surfaces not practical with mechanical methods alone. Available in petroleum and water-based carriers. Common applications include: producing an ultra-flat surface such as the lapping of gauges, valve seats, and mechanical seal faces; smoothing shaft surfaces and bearing races; creating perfectly-mated parts for running-in gears and finishing industrial valves; cleaning surfaces and removing material too difficult to remove by other methods, as in finishing hardened tool steel.

MACHINING 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

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



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

LOCTITE® BRAND CLOVER® ITEMS

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



Use Loctite® brand liquid, paste, or semi-solid retaining compounds to bond non-threaded, cylindrical metal assemblies. Fill the inner voids in close-fitting press fits, keyways, and splines. Mount bearings and bushings, and make press fits even stronger.

RETAINING

**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, fast curing adhesive used for bonding rigid metal assemblies. Ideal for gap distances up to 0.005" (0.13 mm). Loctite® 609™ fixtures in just 10 minutes and provides shear strength of 3,000 psi after 24 hours. It easily joins dissimilar metals and withstands temperatures up to 300°F (149°C).

**Loctite® 620™
Retaining Compound**

Slip Fit/High Temperature
A high temperature adhesive that has the capability to operate at 450°F (232°C) for long periods. Loctite® 620™ fixtures in 30 minutes at room temperature, but requires a secondary heat cure to generate the high temperature resistance. Used to bond cylindrical parts with gaps up to 0.015" (0.35 mm). Loctite® 620™ provides a shear strength of 3,800 psi on steel after 24 hours.

**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® QuickStix™ 668™
Retaining Compound,
High Temperature**

General Purpose
A high temperature retaining compound in a revolutionary semi-solid 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).



**Loctite® 680™
Retaining Compound**

Slip Fit/High Strength

A high strength, 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.

For technical information and/or product availability, call 1-800-LOCTITE or on the web

Visit www.loctite.com

LOCTITE® BRAND
RETAINING COMPOUNDS
PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance	Maximum Gap Fill (Diametral)	Shear Strength Steel/Steel (psi)*	Temperature Range	Set-Up Time	Recommended Primer	Agency Approvals
603™	21440 21441 21442	10 ml bottle 50 ml bottle 250 ml bottle	Green liquid	.005"	3,770 psi	-65 to 300°F (-54 to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	-
609™	60921 60931 60941	10 ml bottle 50 ml bottle 250 ml bottle	Green liquid	.005"	2,300 psi minimum	-65 to 300°F (-54 to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	CFIA, Conforms to MIL-R-46082B for existing designs, ASTM D-5363 for new designs
620™	62015 62040 62070	10 ml bottle 50 ml bottle 250 ml bottle	Green liquid	.015"	3,800 psi	-65 to 450°F (-54 to 232°C)	Set-up: 30 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	ABS, CFIA
660™ Quick Metal®	66010 66040	6 ml tube 50 ml tube	Silver paste	.020"	3,335 psi	-65 to 300°F (-54 to 149°C)	Set-up: 20 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	CFIA
QuickStix™ 668™	39147 39148 39149	9 gm stick 19 gm stick 38 gm stick	Green stick	.005"	1,870 psi	-65 to 400°F (-54 to 204°C)	Set-up: 30 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	-
680™	68015 68035 68060	10 ml bottle 50 ml bottle 250 ml bottle	Green liquid	.015"	2,800 psi minimum	-65 to 300°F (-54 to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	ABS, NSF/ANSI 61

*Varies with substrates.

ADDITIONAL OFFERINGS

Loctite® Hand Pumps are ideal for dispensing liquid from all 50 ml and 250 ml anaerobic bottles. See page 106 for more information.





From the creator of liquid threadlocking, choose the strength, temperature range, and cure speed you need to prevent loosening from shock and vibration, and stop rust and corrosion of threaded metal fasteners. Removable to permanent strength threadlockers are available to fit a variety of thread sizes and conditions.

The Loctite® brand now offers the same trusted threadlocking performance in a patented new semi-solid stick. Available in both medium and high strength formulas, Loctite® QuickStix™ are convenient, portable and less messy, making them perfect for tough applications, especially overhead. Loctite® QuickStix™ are easy to store in a toolbox, tool belt, or pocket making them the perfect complement to the trusted Henkel line of Loctite® branded products.

THREADLOCKING

Loctite® 220™ Threadlocker

Low Strength/Wicking/Blue
A low viscosity threadlocking adhesive that allows the product to wick along the threads of preassembled fasteners. Perfect for fasteners up to 1/4" diameter (6 mm).

Loctite® 222MS™ Threadlocker

Low Strength/Purple
Perfect for small fasteners up to 1/4" diameter (6 mm), long engagement length fasteners, and components requiring occasional adjustment. Apply to threaded parts before assembly. Parts can be disassembled with hand tools. Approved for use in or around food processing areas.

Loctite® 242® Threadlocker

Medium Strength/Removable/Blue
Removable strength, general purpose threadlocking adhesive especially 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® QuickStix™ 248™ Threadlocker

Medium Strength/Removable/Blue
New, patented semi-solid 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 semi-solid formula also means it won't spill or leak.

Loctite® 262™ Threadlocker

High Strength/Red
A high strength product that is applied to fasteners up to 3/4" (20 mm) in size before assembly. 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® 7649™ Primer N™

Decreases the set-up time of Loctite® brand threadlockers and increases breakaway torque on most fastener surfaces. Allows cold weather application. Contains no ozone-depleting compounds.



Loctite® QuickStix™ 268™ Threadlocker

High Strength/Red
Revolutionary semi-solid stick formula is high strength and best suited for fasteners up to 3/4" (20 mm). Semi-solid formula offers added convenience and portability. Localized heat and hand tools are required to separate parts.

Loctite® 290™ Threadlocker

Wicking/Green
A low viscosity, threadlocking liquid, that wicks along the threads of pre-assembled fasteners to secure them in place. Seals porosities in welds and metal parts. Ideal for fasteners ranging from #2 to 1/2" (2.2 to 12 mm) in size. Localized heat and hand tools are needed for disassembly. Approved for use in or around food processing areas.

LOCTITE® BRAND THREADLOCKERS
PROPERTIES CHART

PRODUCT	Item Number	Container	Color	Fastener Size	Break/Prevail Torque*	Temperature Range	Cure Speed, Steel @ 25C	Recommended Primer	Agency Approvals
220™	37388 39186 22041	10 ml bottle 50 ml bottle 250 ml bottle	Blue	Under 1/4"	85/170	-65 to 300°F (-54 to 149°C)	Fixture - 6 minutes Full strength - 24 hrs.	7649™ Primer N™**	MIL-S-46163A for existing designs, ASTM D-5363†, CFIA
222MS™	22221 22231 22241	10 ml bottle 50 ml bottle 250 ml bottle	Purple	#2 to 1/4" (2.2 mm to 6 mm)	53/30	-65 to 300°F (-54 to 149°C)	Fixture - 10 minutes (5 minutes w/primer) Full strength - 24 hrs.	7649™ Primer N™**	MIL-S-46163A for existing designs, ASTM D-5363†, NSF P1, CFIA
242®	24221 24231 24241	10 ml bottle 50 ml bottle 250 ml bottle	Blue	1/4" to 3/4" (6 mm to 20 mm)	110/43	-65 to 300°F (-54 to 149°C)	Fixture - 10 minutes (3 minutes w/primer) Full strength - 24 hrs.	7649™ Primer N™**	MIL-S-46163A for existing designs, ASTM D-5363†, NSF/ANSI 61, NSF P1, CFIA, ABS
QuickStix™ 248™	37684 37087	9 gm stick 19 gm stick	Blue	1/4" to 3/4" (6 mm to 20 mm)	110/43	-65 to 300°F (-54 to 149°C)	Fixture - 10 minutes (3 minutes w/primer) Full strength - 24 hrs.	7649™ Primer N™**	NSF/ANSI 61, CFIA
262™	26221 26231 26241	10 ml bottle 50 ml bottle 250 ml bottle	Red	Up to 3/4" (up to 20 mm)	189/275	-65 to 300°F (-54 to 149°C)	Fixture - 5 minutes (5 minutes w/primer) Full strength - 24 hrs.	7649™ Primer N™**	MIL-S-46163A for existing designs, ASTM D-5363†, NSF P1, CFIA, ABS
QuickStix™ 268™	37685 37686	9 gm stick 19 gm stick	Red	Up to 3/4" (up to 20 mm)	202/4	-65 to 300°F (-54 to 149°C)	Fixture - 20 minutes (5 minutes w/primer) Full strength - 24 hrs.	7649™ Primer N™**	CFIA
290™	29021 29031 29041	10 ml bottle 50 ml bottle 250 ml bottle	Green	#2 to 1/2" (2.2 mm to 12 mm)	85/250	-65 to 300°F (-54 to 149°C)	Fixture - 20 minutes (5 minutes w/primer) Full strength - 24 hrs.	7649™ Primer N™**	MIL-S-46163A for existing designs, NSF/ANSI 61, ASTM D-5363†, NSF P1, CFIA
7649™ Primer N™	21347 21348 38402	25 gm aerosol 4.5 oz. aerosol 1.75 fl. oz. aluminum bottle	-	-	-	-	-	-	MIL-S-22473E for existing designs, ASTM D-5363†, NSF/ANSI 61, NSF P1, CFIA

* Break & Prevail Torque values cited are for M10 steel nuts and bolts.
** Loctite® 7471™ Primer T™ is also an acceptable alternative. See pages 48 and 49 for more information.
† For new designs.

LOW STRENGTH

Apply 222MS™

LOCTITE® 222MS™ THREADLOCKER

- Set screws
- Adjustment screws
- Calibration screws
- Meters and gauges

REMOVABLE

Apply 242® or 248™

LOCTITE® 242® LIQUID OR 248™ STICK THREADLOCKER

- Machine tools and presses
- Pumps and compressors
- Mounting bolts
- Gear boxes

HIGH STRENGTH

Apply 262™

LOCTITE® 262™ THREADLOCKER

- Heavy equipment
- Suspension bolts
- Motor and pump mounts
- Bearing cap bolts and studs

WICKING

Apply 290™

LOCTITE® 290™ THREADLOCKER

- Preassembled fasteners
- Instrumentation screws
- Electrical connectors
- Carburetors

ADDITIONAL OFFERINGS

Loctite® Hand Pumps are ideal for dispensing liquid from all 50 ml and 250 ml anaerobic bottles. See page 106 for more information.





Loctite® brand thread sealants seal and secure plastic and metal pipes and fittings. By filling the space between threaded metal parts, thread sealants harden to prevent leaking. Designed for low and high pressure applications, thread sealants seal instantly for low pressure testing. When fully cured, they seal to the burst strength of most piping systems. For repairs, parts may be disassembled with basic hand tools.

THREAD SEALING

NEW

Loctite® QuickStix™ 561™ PST® Pipe Sealant

New, patented, semi-solid 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 semi-solid formula also means it won't spill or leak, making it great for overhead applications or carrying in a pocket or toolbox.



Loctite® 545™ Thread Sealant

Hydraulic/Pneumatic Fittings

Contains no fillers or particles which could contaminate system fluids, foul valves, or clog fine filters and screens. Suitable for fittings up to 2" (50 mm) in diameter, Loctite® 545™ has excellent solvent resistance.

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") diameter pipes. Loctite® 564™ 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. Loctite® 565™ PST® can be used on fittings up to 2" (50 mm) in diameter.

Loctite® 567™ PST® Thread Sealant

High Temperature

A high performance sealant that locks and seals metal, tapered pipe threads and fittings. Ideal for stainless steel, aluminum, galvanized metal, and other inert metals. This product has excellent solvent resistance, allows easy assembly, and prevents galling. Excellent for high pressure applications.

Loctite® 55™ Pipe Sealing Cord

A general purpose threaded pipe and fitting sealant. Loctite® 55™ Pipe Sealing Cord is a non-curing, coated multifilament cord that seals out air and other common gases and fluids. Built-in cutter to easily apply the proper amount of cord. Recommended for sealing metal and plastic tapered pipe threads and fittings up to 4" NPT. Allows for post assembly adjustments.



Loctite® H.V.A.C. Blue Pipe Joint Compound

Tough, pliable sealant specially formulated for heating, air conditioning, and refrigeration applications. Sets up quickly to allow 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.

Loctite® No More Leaks™

Plastic Pipe Sealant

Seals plastic pipes and allows easy disassembly. Specially formulated without the added lubricity of PTFE to avoid cracked fittings caused by over-tightened plastic joints.

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 won't shred like tape and allows easy disassembly. Resists common shop fluids.

Loctite® Thread Seal Tape with PTFE

1/2" x 520" tape with plastic spool and shell. Can be used on temperatures up to 500°F. Oxygen service compatible.



LOCTITE® BRAND
THREAD SEALANTS
PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance	Pressure Resistance (psi)	Viscosity cPs	Temperature Range	Seal to Operating Pressure	Recommended Primer	Agency Approvals
545™	32429 54531 54541	10 ml bottle 50 ml bottle 250 ml bottle	Purple liquid	10,000	14,000	-65 to 300°F (-54 to 149°C)	4 hours	7649™ Primer N™ or 7471™ Primer T™	CFIA, ABS
NEW QuickStix™ 561™ PST®	37127	19 gram stick	White paste	10,000	Semi-solid paste	-65 to 300°F (-54 to 149°C)	4 hours	7649™ Primer N™ or 7471™ Primer T™	ULC Classified for Canada, UL Classified for U.S., CSA International, NSF/ANSI 61, CFIA
564™	28753 28754 28755 34759	6 ml tube 50 ml tube 250 ml tube 350 ml brush can	White paste	10,000	90,500	-65 to 300°F (-54 to 149°C)	4 hours	7649™ Primer N™ or 7471™ Primer T™	ULC Classified for Canada, CSA International, NSF/ANSI 61, CFIA
565™ PST®	56507 56531 56541 56571	6 ml tube 50 ml tube 250 ml tube 300 ml cartridge	White paste	10,000	300,000	-65 to 300°F (-54 to 149°C)	4 hours	7649™ Primer N™ or 7471™ Primer T™	ULC Classified for Canada, UL Classified for U.S., CSA International, NSF/ANSI 61, CFIA, AGA
567™ PST®	56707 56747 56765 33241	6 ml tube 50 ml tube 250 ml tube 16 oz. brush can	White paste	10,000	540,000	-65 to 400°F (-54 to 204°C)	4 hours	7649™ Primer N™ or 7471™ Primer T™	UL Classified for U.S., ULC Classified for Canada, CSA International, CFIA, ABS
55™ Pipe Sealing Cord	35082 39036	5,700 inches 1,968 inches	White coated cord	10,000	N/A	Up to 300°F (150°C)	Instant	-	UL Listed, CSA International, NSF/ANSI 61
H.V.A.C. Blue Pipe Joint Compound	82480 82481	0.25 pt. brush can 1 pt. brush can	Blue paste	5,000	20,000- 30,000	-65 to 400°F (-54 to 204°C)	Instant	-	CFIA
No More Leaks™	80725 80724 80726	2 fl. oz. tube 7 fl. oz. tube 1 pt. brush can	White paste	5,000	90,000- 110,000	-65 to 400°F (-54 to 204°C)	Instant	-	NSF/ANSI 61, CFIA
Pipe Joint Compound	30556 30557	0.25 pt. brush can 1 pt. brush can	Black paste	5,000	35,000- 45,000	-65 to 400°F (-54 to 204°C)	Instant	-	-
Thread Seal Tape with PTFE	39904	1/2" x 520" x .003"	White tape	Pressure rating of pipe	N/A	Up to 500°F	Instant	-	Conforms to MIL-T-27730
Thread Sealant with PTFE	30534 30561	0.25 pt. brush can 1 pt. brush can	White paste	5,000	50,000- 60,000	-60 to 300°F (-51 to 149°C)	Instant	-	CFIA



Loctite® brand Nordbak® Wearing Compounds combine the superior wear properties of ceramic and the convenience of two-part epoxies to protect equipment from corrosion, abrasion, and other wear encountered in harsh industrial environments. Available in trowelable and brushable formulations with special fillers for tough conditions.

WEARING COMPOUNDS

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® Fast Cure Wearing Compound

A faster version of 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® 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® High Impact Wearing Compound

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

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® Pneu-Wear

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

Brushes on to form a smooth, corrosion-resistant coating. Protects against turbulence, abrasion, and cavitation. Can also be used as a top coat over Loctite® Nordbak® wearing compounds for surface rebuilding and lasting protection. Resists temperatures 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.

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.

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.

LOCTITE® BRAND NORDBAK® WEARING COMPOUNDS PROPERTIES CHART

PRODUCT		Item Number	Container	Coverage, ft. ² @ 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
Standard	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	-
	Nordbak® Fast Cure Wearing Compound	96373	6 lb. kit	2.1	Blue	225	10,000	90	10	3	2:1	2:1	-
	Nordbak® High Temperature Wearing Compound	99112	25 lb. kit	9	Grey	450	15,000	85	30	▲	4:1	3.9:1	-
	Nordbak® Ultra High Temperature Wearing Compound	96392	25 lb. kit	9	Red	550	-	90	30	▲	2.44:1	2.85:1	-
Fine Particle	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
	Nordbak® Fast Cure Pneu-Wear	96363	6 lb. kit	2.1	Blue	225	12,000	90	10	3	2:1	2:1	-
	Nordbak® High Temperature Pneu-Wear	98372	25 lb. kit	8.8	Grey	450	15,000	90	30	▲	4:1	4:1	-
	Nordbak® Ultra High Temperature Pneu-Wear	96332	25 lb. kit	8.8	Red	550	-	90	30	▲	2:1	2.27:1	-
Specialty	Nordbak® High Impact Wearing Compound	39918	25 lb. kit	8.75	Grey	250	15,000	85	30	6	2:1	2:1	-
	Nordbak® Castable Wearing Compound	98992	25 lb. kit	277 in. ³	Grey	225	18,500	90	30	6	2:1	6.8:1	-
	Nordbak® Combo Bead Wearing Compound	96303	6 lb. kit	2.3	Grey	250	13,000	90	25	8	2:1	2:1	-
Brushable Coatings	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
	Nordbak® Brushable Ceramic - White	96443	2 lb. kit	12*	White	200	12,500	85	15	5	2.8:1	4.5:1	-
	Nordbak® High Temperature Brushable Ceramic	96433	2 lb. kit	12*	Red	550	16,000	90	120	▲	2.6:1	4.25:1	-
	Nordbak® Chemical Resistant Coating	96092	12 lb. kit	74*	Grey	150	10,000	83	20	16	2.3:1	3.4:1	-
Wear Tiles	Nordbak® Ceramic Tile Adhesive	97762	20 lb. kit	12	Beige	200	14,000	88	60	12	1:1	3.7:1	-

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

*20 mil thickness.

▲ Requires heat cure. See Technical Data Sheet.

LOCTITE® BRAND NORDBAK® WEARING COMPOUNDS APPLICATION SELECTION GUIDE

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
Standard	Nordbak® Wearing Compound									●	●	●	●	●
	Nordbak® Fast Cure Wearing Compound						●			●	●	●	●	●
	Nordbak® High Temperature Wearing Compound					●				●	●	●	●	●
	Nordbak® Ultra High Temperature Wearing Compound					●				●	●	●	●	●
Fine Particle	Nordbak® Pneu-Wear	●	●							●	●	●	●	●
	Nordbak® Fast Cure Pneu-Wear	●	●				●			●	●	●	●	●
	Nordbak® High Temperature Pneu-Wear	●	●			●				●	●	●	●	●
	Nordbak® Ultra High Temperature Pneu-Wear	●	●			●				●	●	●	●	●
Specialty	Nordbak® High Impact Wearing Compound			●										
	Nordbak® Castable Wearing Compound										●		●	
	Nordbak® Combo Bead Wearing Compound	●	●								●	●	●	●
Brushable Coatings	Nordbak® Brushable Ceramic - Grey				●			●		●				
	Nordbak® Brushable Ceramic - White				●			●		●				
	Nordbak® High Temperature Brushable Ceramic				●	●		●		●				
	Nordbak® Chemical Resistant Coating				●			●						
Wear Tiles	Nordbak® Ceramic Tile Adhesive			●				●						

● Preferred choice ● Good choice

Loctite® brand Nordbak® Epoxies — Tackle the toughest industrial repair jobs with the #1 name in wearing compounds.





These special support products provide uniquely designed, long-lasting solutions to the most common maintenance problems.



SPECIAL PRODUCTS

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

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.

Loctite® Fixmaster® 2000° Putty

Single-component putty seals and repairs damaged metal in operating environments up to 2000°F. Non-toxic, water-based and solvent-free.

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 and gloves. Cures in 30 minutes.

Loctite® Pro Lock™ Tight®

Multi-Purpose 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.

Loctite® Maintenance Tacklebox

Designed to fit in a mechanics tool chest, this kit contains ten great Loctite® branded products and a Loctite® "Do-it-Right" Users Guide.

Loctite® Quick Service Toolkit

The "original" Loctite® kit containing eight of the most common Loctite® branded products.



Loctite® Toolbox

Containing fifteen of the latest and best Loctite® brand technologies to solve the most common mechanical failures, this kit contains everything a professional needs to increase reliability at the base component level.

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.



Loctite® Manufacturing Reliability Toolbox





Contains twelve Loctite® branded items and is used during Loctite® Manufacturing Reliability Training.



Loctite® Reliability Tacklebox

An alternative to the Manufacturing Reliability Toolbox, this kit contains thirteen Loctite® branded products for use during Manufacturing Reliability Training.

LOCTITE® BRAND
SPECIAL PRODUCTS ORDERING INFORMATION

PRODUCT	Item Number	Container	Maximum Temperature Resistance	Adhesive Appearance	Agency Approvals
Fixmaster® 2000° Putty	95724	8 oz. can	2000°F	Grey paste	-
Form-A-Thread® Stripped Thread Repair Kit	28654	4.8 ml kit	300°F	Grey (mixed)	CFIA
Pipe Repair Kit	96321 96322	2" x 6' tape 4" x 12' tape	250°F	Yellow	CFIA
Pro Lock™ Tight®	51604 51642	50 ml tube 250 ml tube	300°F	Blue gel	-
Urethane Sealant	39916 36132*	10.2 oz. cartridge 10.2 oz. cartridge	180°F 180°F	Limestone Black	CFIA
Loctite® O-Ring Making Kit	00112	1 oz. waterproofing solution, part number 74126 1 oz. clean-up solvent, part number 75326 1/3 oz. 404™ Quick Set™ instant adhesive Cord - 3/32", 1/8", 3/16", 1/4" Fixture and cutting blade	N/A	Clear	CFIA
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 gm 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	-	-
Loctite® Maintenance Tacklebox 	33486	242® Threadlocker, Medium Strength, 50 ml QuickStix™ 248™ Threadlocker, Medium Strength, 9 gm 262™ Threadlocker, High Strength, 50 ml QuickStix™ 268™ Threadlocker, High Strength, 9 gm 609™ Retaining Compound, 10 ml 660™ Quick Metal® Retaining Compound, 50 ml QuickStix™ 561™ PST® Pipe Sealant, 19 gm 518™ Gasket Eliminator® Flange Sealant, 50 ml 598™ Black High Performance Silicone, 70 ml 7649™ Primer N™, 25 gm aerosol can	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 gm QuickStix™ 268™ Threadlocker, High Strength, 9 gm 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 gm 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 gm 7649™ Primer N™, 1.75 oz. aerosol can	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 gm 262™ Threadlocker, High Strength, 50 ml 290™ Threadlocker, Wicking Grade, 50 ml 518™ Gasket Eliminator® Flange Sealant, 50 ml 545™ Thread Sealant, Hydraulic/Pneumatic, 50 ml 565™ PST® Thread Sealant, 50 ml 609™ Retaining Compound, 10 ml 660™ Quick Metal® Retaining Compound, 50 ml 7649™ Primer N™, 25 gm aerosol can Instant Gasket, 7 oz. can	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 gm QuickStix™ 268™ Threadlocker Stick, High Strength, 19 gm 515™ Gasket Eliminator® Flange Sealant, 50 ml QuickStix™ 561™ PST® Pipe Sealant, 19 gm 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. aerosol can Instant Gasket, 7 oz. can QuickStix™ Silver Grade Anti-Seize, 20 gm	N/A	-	-

* Made-to-order item. May require up to a 7 week lead time.

Dispensing

Hand Held Applicators

Loctite® brand Hand Held 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, hand held dispensing of fluids to reduce waste and operator contact over other methods. Selection of a Loctite® brand Hand Held Applicator is based on product type, package configuration, and process requirements.

**Loctite®
50 ml/250 ml
Hand Pump**



**Loctite®
10 ml/30 ml Syringe
Manual Plungers**



**Loctite®
30 ml Manual
Syringe Applicator**



**Loctite®
1 Liter Collapsible
Bottle Holder**



**Loctite® Caulking
Gun Conversion Kit
for 50 ml Cartridges**



**Loctite®
Soft Squeeze
Bottles***



	Loctite® 50 ml/250 ml Hand Pump	Loctite® 10 ml/30 ml Syringe Manual Plungers	Loctite® 30 ml Manual Syringe Applicator	Loctite® 1 Liter Collapsible Bottle Holder	Loctite® Caulking Gun Conversion Kit for 50 ml Cartridges	Loctite® Soft Squeeze Bottles*
Item #	98414/97001	98192/98193	98026	98311	983445/98415	98345/98346/98347
Adhesive Components	1	1	1	1	2	1
Used To Dispense	TL, RC	ALL	ALL	TL, RC	E, U, M	All
Viscosity Range	Low to Medium	Low to High	Low to High	Low to Medium	High to Paste	Low to Medium
Type	Manual	Manual	Manual	Manual	Manual	Manual
Mix Ratio	–	–	–	–	1:1, 2:1 / 10:1	–

*Optional Bottle Caps (50 per pack)

Dunce Cap with Red Sealer Cap – For 2 oz. bottle: Item 98348, for 4 and 8 oz. bottles: Item 98349.

Luer-Slip Cap – For 2 oz. bottle: Item 98350, for 4 and 8 oz. bottles: Item 98351.

**Loctite®
50 ml Manual
Applicator**



**Loctite® 50 ml
Dual Cartridge
Pneumatic Applicator**



**Loctite® 200 ml/400 ml
Dual Cartridge
Manual Applicators**



**Loctite® 200 ml/400 ml
Dual Cartridge
Pneumatic Applicators**



**Loctite® Universal
Metal Dispenser for
200/400 ml Cartridges**



**Loctite® Fixmaster®
Rapid Rubber
Repair Dispenser**



	Loctite® 50 ml Manual Applicator	Loctite® 50 ml Dual Cartridge Pneumatic Applicator	Loctite® 200 ml/400 ml Dual Cartridge Manual Applicators	Loctite® 200 ml/400 ml Dual Cartridge Pneumatic Applicators	Loctite® Universal Metal Dispenser for 200/400 ml Cartridges	Loctite® Fixmaster® Rapid Rubber Repair Dispenser
Item #	983531	97042	983436/983438/ 985246	983437/983439/ 985249	985245	39635
Adhesive Components	2	2	2	2	2	2
Used To Dispense	E, U, M	E, U, M	E, U, M	E, U, M	E, U, M	RR
Viscosity Range	High to Paste	High to Paste	High to Paste	High to Paste	High to Paste	Medium to High
Type	Manual	Pneumatic	Manual	Pneumatic	Manual	Manual

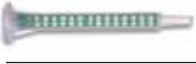










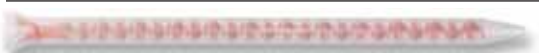









ALL = All Fluids in Approved Packages
E = Two-Component Epoxies
G = Gasketing Products

M = Two-Component Methacrylates
RR = Rapid Rubber Repair Urethane

RC = Retaining Compounds
S = Silicones

TL = Threadlockers
U = Two-Component Urethanes

Loctite® Brand Static Mix Nozzles and Accessories

PRODUCT	ITEM #	DESCRIPTION
	98444 98364	50 ml Square Mix Nozzle, Luer/Stepped Combo Tip, 3.25" Overall Length, 5.3 mm sq., 16 elements, 1:1, 2:1 mix ratios. (98444: 10 pk, 98364: 1000 pk)
	984569	50 ml Square Mix Nozzle, Luer/Stepped Combo Tip, 4.5" Overall Length, 5.3 mm sq., 24 elements, 1:1, 2:1, 4:1 mix ratios. (10 pk)
	98373 98374	200/400 ml Square Mix Nozzle, Luer/Stepped Combo Tip, 5.0" Overall Length, 5.3 mm sq., 24 elements, 1:1, 2:1, 4:1 mix ratios. (98373: 10 pk, 98374: 1000 pk)
	983440	50 ml Mix Nozzle, Luer Tip, 6.0" Overall Length, 6.3 mm dia., 20 elements, 1:1, 2:1, 4:1 mix ratios. (10 pk)
	983441 985599	50 ml Mix Nozzle, Stepped Tip, 6.0" Overall Length, 6.3 mm dia., 20 elements, 1:1, 2:1, 4:1 mix ratios. (983441: 10 pk, 985599: 4000 pk)
	986087	50 ml Mix Nozzle, Stepped Tip, Keyed, 5.9" Overall Length, 5.4 mm dia., 28 elements, 10:1 mix ratio. (10 pk)
	984570	200/400 ml Square Mix Nozzle, Stepped Tip, 5.1" Overall Length, 7.5 mm sq., 24 elements, 1:1, 2:1 mix ratios. (10 pk)
	983442	200/400 ml Mix Nozzle, Stepped Tip, 7.3" Overall Length, 6.3 mm dia., 24 elements, 1:1, 2:1 mix ratios. (10 pk)
	983443 987527	200/400 ml Mix Nozzle, Stepped Tip, 8.8" Overall Length, 8 mm dia., 24 elements, 1:1, 2:1 mix ratios. (983443: 10 pk, 987527: 1500 pk)
	985247	200/400 ml Mix Nozzle, Stepped Tip, 10.8" Overall Length, 10 mm dia., 24 elements, 1:1, 2:1 mix ratios. (10 pk)
	985248	200/400 ml Mix Nozzle, Stepped Tip, Keyed, 9.1" Overall Length, 8 mm dia., 24 elements, 4:1, 10:1 mix ratios. (10 pk)
	985545 98409	200/400 ml Mix Nozzle, Stepped Tip, Keyed, 10.8" Overall Length, 10 mm dia., 24 elements, 4:1, 10:1 mix ratios. (985545: 10 pk, 98409: 1000 pk)
	98430	200/400 ml Mix Nozzle, Stepped Tip, 14.2" Overall Length, 9.3 mm dia., 40 elements, 1:1, 2:1 mix ratios. (500 pk)
	983444	Luer-Lok Adapter for 6.3 and 8 mm stepped tip Mix Nozzles, Allows for Dispense Needle Attachment, (10 pk), Mix Nozzles and Dispense Needles sold separately.
	98344	Ribbon Tip Adapter, allows Ribbon Tip use with 10 mm 1:1, 2:1, 4:1 and 10:1, Mix Nozzles sold separately. (10 pk)
	985658 98410	12 mm Ribbon Tip. Tip Orifice: 12 mm x 2.4 mm. For use with Snap Tip Mix Nozzles. (985658: 10 pk, 98410: 500 pk)
	985659 98411	25 mm Ribbon Tip. Tip Orifice: 25 mm x 2.4 mm. For use with Snap Tip Mix Nozzles. (985659: 10 pk, 98411: 500 pk)
	985660 98412	43 mm Ribbon Tip. Tip Orifice: 43 mm x 2.4 mm. For use with Snap Tip Mix Nozzles. (985660: 10 pk, 98412: 500 pk)
	985661	200/400 ml Snap Tip Mix Nozzle, 8 mm diameter, 8.9" overall length, 24 elements, 1:1, 2:1 mix ratios. For use with Ribbon Tips. (10 pk)
	985662 98367	200/400 ml Snap Tip Mix Nozzle, 9.3 mm dia., 9.3" overall length, 24 elements, 1:1, 2:1 mix ratios. For use with Ribbon Tips. (985662: 10 pk, 98367: 1000 pk)
	985709	Snap Tip Mix Nozzle and Ribbon Tip Sample Kit. Contains: 6 pcs. each of: 12, 25, and 43 mm Ribbon Tips 3 pcs. each of: 8 and 9.3 mm diameter Snap Tip Mix Nozzles

Dispensing

Hot Melt Applicators

Loctite® brand Hysol™ 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.

**Loctite® Hysol™
Reactive Urethane
Cartridge Dispenser**



**Loctite® Hysol™
050-LITE**



**Loctite® Hysol™ 050/
Hysol™ 050-HT**



**Loctite® Hysol™
050-GAS**



**Loctite® Hysol™ 075/
Hysol™ 075-LT**



Loctite® Hysol™ 175



	Loctite® Hysol™ Reactive Urethane Cartridge Dispenser	Loctite® Hysol™ 050-LITE	Loctite® Hysol™ 050/ Hysol™ 050-HT	Loctite® Hysol™ 050-GAS	Loctite® Hysol™ 075/ Hysol™ 075-LT	Loctite® Hysol™ 175
Item #	98011	98029	98030/98031	98032	98033/98034	98035
Nominal Stick Diameter	N/A	0.50" (Superstick™)	0.50" (Superstick™)	0.50" (Superstick™)	0.75" (Maxistick™)	1.75" (Polyshot™ sticks)
Dispense Melt Rate (lbs./hr.)	>3	1.0	3.0 / 4.0	3.0	9.0/5.0	6.6
Applicator Adh. Capacity (lbs.)	300 ml	0.04	0.04	0.04	0.12	0.125
Heat Source	Electric	Electric	Electric	Butane	Electric	Electric
Dispense Power	Air	Manual	Manual	Manual	Manual	Manual
Dispense Temp. (°C)	121	200	195/215	195	182/121	195 & 215*
Hot Melt Chemistry	Reactive Urethane	EVA/ Polyolifin	EVA/ Polyamide/ Polyolifin	EVA/ Polyolifin	EVA/ EVA CoolMelt™	EVA & Polyamide

**Loctite® Hysol™
175-AIR**



**Loctite® Hysol™
175-AIR HT**



**Loctite® Hysol™
175-SPRAY**



**Loctite® Hysol™
175-SPRAY HT**



**Loctite® Hysol™
Wheelcoater**



**Loctite® Bench Mount
Kit & Pneumatic Timer**



	Loctite® Hysol™ 175-AIR	Loctite® Hysol™ 175-AIR HT	Loctite® Hysol™ 175-SPRAY	Loctite® Hysol™ 175-SPRAY HT	Loctite® Hysol™ Wheelcoater	Loctite® Bench Mount Kit & Pneumatic Timer
Item #	98036	98040	98037	98041	98038	98042/98043
Nominal Stick Diameter	1.75" (Polyshot™ sticks)	1.75" (Polyshot™ sticks)	1.75" (SprayPac® Polyshot™ sticks)	1.75" (SprayPac® Polyshot™ sticks)	Bulk	–
Dispense Melt Rate (lbs./hr.)	8.8	8.8	8.0	8.0	–	–
Applicator Adh. Capacity (lbs.)	0.125	0.125	0.125	0.125	3	–
Heat Source	Electric	Electric	Electric	Electric	Electric	–
Dispense Power	Air	Air	Air	Air	Electric	–
Dispense Temp. (°C)	195	215	180	195	190	–
Hot Melt Chemistry	EVA	Polyamide	EVA Spray Adhesive	Polyamide Spray Adhesive	EVA Bulk Pellets	EVA/ Polyamide

*The Loctite® Hysol™ 175 applicator (manual electric) is supplied with both temperature modules.

Loctite® Brand Hot Melt Nozzles & Accessories

Product	Item #	Description	Used With
	985225	Standard 1-Hole Nozzle, 0.08" Diameter Cone Tip, 5 pk	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985110	2-Hole Nozzle, .06" dia. x .39" spacing	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985111	3-Hole Nozzle, .06" dia. x .20" spacing	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985112	Diagonal Extension Nozzle, Tip = .14" dia. x 1.23" long	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985113	Needle Extension Nozzle, Tip = .05" dia. x 1.32" long	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985114	Spreader Extension Nozzle, Tip = (.09" x .25") sq. x 1.32" long	98030, 98031, 98032, 98033, 98034, 98035, 98036, 98040
	985115	L-Nozzle, .06" dia. x .85" offset	98033, 98034, 98035, 98036, 98040
	985116	T-Nozzle, .06" dia. x 1.5" spacing	98033, 98034, 98035, 98036, 98040
	985088	Standard Adapter/Check Valve for Nozzles	98030, 98031, 98032, 98035, 98036, 98040
	ANZ023N01	Standard Adapter/Check Valve/Jam Nut for Nozzles	98033, 98034
	985216	Ultra Wide Spray Nozzle, 1.5" - 6.0" dia. pattern	98037, 98041
	985211	Narrow Spray Nozzle, .05" - 1.25" dia. pattern	98037, 98041
	985122	Standard Wide Spray Nozzle, 1.25" - 5.0" dia. pattern	98037, 98041
	984999	Standard 1-Hole Nozzle, with Integral Check Valve, Tip = .10" dia. x .16" long	98029
	985002	Pencil Point Nozzle, with Integral Check Valve, Tip = .08" dia. x .24" long	98029
	985003	Precision Nozzle, with Integral Check Valve, Tip = .05" dia. x .20" long	98029
	985004	Extension Nozzle, with Integral Check Valve, Tip = .10" dia. x .50" long	98029
	985001	Spreader Nozzle, with Integral Check Valve, Tip = (0.08" x 0.25") sq. x 0.47" long	98029

Product	Item #	Description	Used With
	98012	Cartridge Pre-Heater, holds (2) 300 ml Cartridges	98011
	984261	Standard Adapter for 300 ml Cartridges	98011
	984262	Standard 1-Hole Nozzle, 0.098" dia. Cone Tip, with Integral Check Valve (includes protective cap)	98011
	984272	Injection Needle Nozzle, with Integral Check Valve, Tip = .059" dia. x .197" long	98011
	984263	Adapter/Check Valve for Specialty Nozzles	98011
	984264	Needle Jet Nozzle, Tip = .051" dia. x 1.26" long (requires 984263 adapter)	98011
	984265	Diagonal Extension Nozzle, Tip = .123" dia. x 1.276" long (requires 984263 adapter)	98011
	984266	Flat Spreader Nozzle, Tip = (.084" x .177") sq. x 1.237 long (requires 984263 adapter)	98011
	984267	2-Hole Nozzle, .06" dia. x .39" spacing (requires 984263 adapter)	98011
	984268	3-Hole Nozzle, .06" dia. x .20" spacing (requires 984263 adapter)	98011
	985243	Tool Hanger/Balancer	All Hot Melt Hand Held Applicators
	985397	Air Line Filter, Regulator, Gauge 0-150 psi	All Pneumatic Applicators
	985087	Heavy Duty Bench Top Metal Stand	98030, 98031, 98032, 98035, 98036, 98037, 98040, 98041

For custom Loctite® brand hot melt dispense nozzles, contact the Henkel Special Equipment Group at 1-800-LOCTITE (562-8483).

Dispensing

Bulk Hot Melt Systems

Henkel's Loctite® brand Hysol™ Bulk Hot Melt Dispensers offer high performance control and reliability for all of your hot melt dispensing needs. You can rely on Henkel to supply you with performance hot melt adhesives as well as an array of standard high volume hot melt dispensing equipment. Henkel offers true one stop shopping for your complete adhesive solution.

These Hysol™ Bulk Hot Melt Systems come in three compact and economical sizes: 12, 14 and 34 lb. tank capacity (expandable to up to 78 lbs. with optional tank hopper). All units feature internal system diagnostics which monitor the temperatures and system settings.

In any adhesive application, the accuracy of your dispense equipment can define the level of success of the process. Henkel offers a variety of hand held or mountable applicators for the accurate dispensing of your spray or extrusion application. In addition, the appropriate dispensing controllers, timers, hosing, and nozzle accessories are available to complete your system.

For additional information on these items, please call our Technical Information group. In the U.S.A., call 1.800.LOCTITE (562.8483). In Canada, call 1.800.263.5043.

You can also visit us online at www.loctite.com.

- Request our complete Loctite® Hysol™ Hot Melt Adhesive & Equipment literature piece LT-3768.
- Request a copy of our *Equipment Sourcebook*.
- Or link to our equipment web site at <http://equipment.loctite.com/standardequipment.cfm>. Check out or purchase all of your needed Bulk Hot Melt equipment choices.

**Loctite® Hysol™
Bulk-12 System
115 VAC**



**Loctite® Hysol™
Bulk-12 System
230 VAC**



**Loctite® Hysol™
Bulk-14 System
115 VAC**



**Loctite® Hysol™
Bulk-14 System
230 VAC**



**Loctite® Hysol™
Bulk-34 System
230 VAC**



	Loctite® Hysol™ Bulk-12 System 115 VAC	Loctite® Hysol™ Bulk-12 System 230 VAC	Loctite® Hysol™ Bulk-14 System 115 VAC	Loctite® Hysol™ Bulk-14 System 230 VAC	Loctite® Hysol™ Bulk-34 System 230 VAC
Item Number	98131	98132	98133	98134	98135
Max. Dispense Rate	28 lbs./hr. (12.7 kg/hr.)	28 lbs./hr. (12.7 kg/hr.)	70 lbs./hr. (31.7 kg/hr.)	70 lbs./hr. (31.7 kg/hr.)	100 lbs./hr. (45.3 kg/hr.)
Max. Number of Hoses	1	1	2	2	4
Max. Length of all Hoses	16'	24'	32'	48'	72'
Standard Tank Capacity	12 lbs. (5.4 kg)	12 lbs. (5.4 kg)	14 lbs. (6.4 kg)	14 lbs. (6.4 kg)	34 lbs. (15.4 kg)
Optional Expanded Capacity with Hopper Upgrade	–	–	40 lbs. (18.2 kg)	40 lbs. (18.2 kg)	78 lbs. (35.4 kg)
Max. Melt Rate	12 lbs./hr. (5.4 kg/hr.)	12 lbs./hr. (5.4 kg/hr.)	28 lbs./hr. (12.7 kg/hr.)	28 lbs./hr. (12.7 kg/hr.)	75 lbs./hr. (34.1 kg/hr.)
Max. Temp Setting for Tank	395°F (202°C)	395°F (202°C)	395°F (202°C)	395°F (202°C)	395°F (202°C)
Max. Dispense Temperature	410°F (210°C)	410°F (210°C)	425°F (218°C)	425°F (218°C)	425°F (218°C)
Temperature Control Zones	3	3	5	5	9
Controls	Analog	Analog	Digital	Digital	Digital
Available Dispense Patterns	Extrude, Swirl Spray, Fan Spray, Cone Spray	Extrude, Swirl Spray, Fan Spray, Cone Spray	Extrude, Swirl Spray, Fan Spray, Cone Spray	Extrude, Swirl Spray, Fan Spray, Cone Spray	Extrude, Swirl Spray, Fan Spray, Cone Spray
Compatible Loctite® Hysol® Adhesives	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin	EVA, Polyamide, Polyolefin
Pump Pressure	0-300 psi	0-300 psi	0-300 psi	0-300 psi	0-300 psi
Dimensions, inches (cm) L x W x H (with open lid)	15.5 x 10.5 x 20 (40 x 27 x 50)	15.5 x 10.5 x 20 (40 x 27 x 50)	20.1 x 12.1 x 23 (51.25 x 31 x 58.5)	20.1 x 12.1 x 23 (51.25 x 31 x 58.5)	22 x 14.25 x 27.5 (56 x 36.25 x 70)
Weight Empty	41 lbs. (18.6 kg)	41 lbs. (18.6 kg)	51 lbs. (23.2 kg)	51 lbs. (23.2 kg)	86 lbs. (39.0 kg)
System Power Consumption	1700 Watts	2780 Watts	2220 Watts	3860 Watts	6600 Watts
Melt Tank Power Consumption	900 Watts	1700 Watts	900 Watts	1700 Watts	3400 Watts

Dispensing Cartridge Systems

Loctite® brand Cartridge Dispensing Equipment provides effective dispensing for a wide range of products packaged in 300 ml cartridges. Whether hand held or mounted, manual or pneumatic, these dispensers are designed to simplify your application of adhesive or lubricant with minimal waste. Selection of a Loctite® brand Cartridge Dispenser is based on product type, viscosity, and process requirements.



Loctite® 300 ml Pneumatic Cartridge Dispenser **Loctite® 300 ml Cartridge Pusher** **Loctite® 300 ml Pneumatic Cartridge Dispensing Retainer** **Loctite® Industrial Manual Grease Dispenser** **Loctite® Industrial Pneumatic Grease Dispenser** **Loctite® Industrial Cordless Electric Grease Dispenser**

						
Item #	97002	98022	98319	98431	98432	98433
Used to Dispense	G, AG, LC	G, AG, LC, S	G, AG, LC, S	GL	GL	GL
Package Types & Sizes	300 ml cartridges 250 ml tubes	300 ml cartridges 250 ml tubes	300 ml cartridges	300 ml cartridges and all bulk containers	300 ml cartridges and all bulk containers	300 ml cartridges and all bulk containers
Viscosity Range	Medium to High	Medium to High	Low to Medium	High	High	High
Type	Pneumatic	Pneumatic with Level Sensor	Pneumatic	Manual	Pneumatic	12 Volt





AG = Anaerobic Gasketing
G = Gel Cyanoacrylates

LC = Light Cure/Acrylics
S = Silicones

GL = Grease/Lubricants










Loctite® Brand Cartridge Accessories

Product	Item #	Description
	98446 98448	Roller Assembly, 1" wide band Roller Assembly, 2" wide band
	98447 98449	Replacement Rollers, 1" wide (3 pk) Replacement Rollers, 2" wide (3 pk)
	98128	Cartridge Dispense Tip. (10 pk)
	98371	Cartridge-Needle Adapter: Luer-Lok adapter for dispense needle attachment - see page 118, sold separately. (5 pk)

Product	Item #	Description
	97215	Cartridge-Syringe Adapter: Downloading adapter for 10, 30 or 55 ml syringe barrels. (3 pk)
	98181	Cartridge-Tube Fitting Adapter: Used for connecting tube fittings to cartridges (984832 or 984833 also required and sold separately). (3 pk)
	984832	Tube Fitting: 1/4" male NPT x 1/4" feed tube. (10 pk)
	984833	Tube Fitting: 1/4" male NPT x 3/8" feed tube. (10 pk)

Dispensing Dispense Systems

Loctite® brand Dispense Systems provide effective dispensing of a wide range of adhesive products in various package sizes. With robust and innovative designs, you can depend on these systems for accurate dispensing and long term reliability to meet your demanding manufacturing needs. Selection of the proper system is based on the product being used, package size, and process requirements.

	Complete Bottle Reservoir Dispense Systems			Thread Sealant and Anaerobic Gasketing Delivery Systems			Syringe Dispensing Systems		
	Equipped with all components needed to dispense a wide range of products in a variety of adhesive bottle sizes.			These unique Loctite® brand systems are both versatile and robustly engineered. Positive displacement pumps or pneumatic air designs are utilized to ensure consistent application of high viscosity thread sealant on pipe threads and anaerobic gasket flange applications.			Pneumatic air pressure systems that effectively dispense fine drop or beads of adhesives packaged in syringe barrels. Optional air line accessories and components required are based on specific syringe barrel size in use. See page 113.		
	Loctite® Bond-A-Matic® Dispenser 0-15 psi	Loctite® Bond-A-Matic® Dispenser 0-100 psi	Loctite® Shot Miser™ Dispense System	Loctite® Dial-A-Seal® Applicator	Loctite® Pump-A-Bead™ II Dispenser	Loctite® Press-Pak™ 1000 Dispenser	Loctite® Analog Syringe Dispensing System	Loctite® Digital Syringe Dispensing System	Loctite® Foot Pedal Dispenser
									
Item #	982719	982722	98116	998400	986000	98006	98417*	97006*	98049/ 98050
Dispense Patterns	DT, DR, B	DT, DR, B	DT, DR, B	N/A	B	B	DT, DR, B	DT, DR, B	DT, DR, B
Used To Dispense	G, IA, LC, RC, TL	G, IA, LC, RC, TL	G, IA, LC, RC, TL	PS	AG	AG, RC, TL	G, IA, LC, RC, TL	G, IA, LC, RC, TL	G, IA, LC
Package Types and Sizes	250 ml bottle, 1 lb. bottle, 1 L bottle, 2 kg bottle, 200 g squeeze tube	250 ml bottle, 1 lb. bottle, 1 L bottle, 2 kg bottle, 200 g squeeze tube	250 ml bottle, 1 lb. bottle, 200 g squeeze tube	50 ml & 250 ml tubes & 1L bottle	850 ml cartridges	1 liter Press-Pak™ containers	10 ml, 30 ml, 55 ml syringes*	10 ml, 30 ml, 55 ml syringes*	10 ml, 30 ml, 55 ml syringes*
Viscosity Range	Low	Medium to High	Low to Medium	Medium to High	High	Medium to High	Low to Paste	Low to Paste	Low to Paste

AG = Anaerobic Gasketing
B = Beads
DR = Drops
DT = Dots
G = Gel Adhesives

IA = Instant Adhesives
LC = Light Cure/Acrylics
PS = Pipe Sealants
RC = Retaining Compounds
TL = Threadlockers

*Syringe Air Line Adapter sold separately. See page 113 for more information.

Loctite® Brand Syringe Accessories

PRODUCT	ITEM #	DESCRIPTION	CONTENTS
	97208	10 ml Syringe Air Line Adapter	2 Air Line Adapters (syringe barrel sold separately)
	97245	30 and 55 ml Syringe Air Line Adapter	2 Air Line Adapters (syringe barrel sold separately)
	98117	3 ml Syringe Air Line Adapter and Filter	Adapter and Filter
	98118	10 ml Syringe Air Line Adapter and Filter	Adapter and Filter
	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
	984650	Air Line Filter for Syringe Dispensing to prevent product back flow	1 Filter Assembly with 2 Hose Crimps
	97215	Cartridge-Syringe Adapter, for downloading adhesive from 300 ml cartridges into syringe barrels	3 Syringe Filler Adapters 1 Tube of Silicone Grease
	984625	Syringe Stand for 10 and 30 ml syringe barrels	1 Stand (syringe barrel and air line adapter sold separately)

Dispensing 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. Loctite® brand Valves and Pumps are sold separately.

**Loctite®
Integrated Semi-Automatic
Controller 0-100 psi**



Item # 97007/97017*

Dispense
Patterns
DT, DR, B

Used To
Dispense
G, IA, LC, RC, TL

Package
Types and
Sizes
250 ml bottle, 1 lb. bottle,
1 L bottle, 2 kg bottle,
200 g squeeze tube

Viscosity Use (cP) Medium to High

**Loctite®
Integrated Semi-Automatic
Controller 0-15 psi**



Item # 97010/97020*

Dispense
Patterns
DT, DR, B

Used To
Dispense
G, IA, LC, RC, TL

Package
Types and
Sizes
250 ml bottle, 1 lb. bottle,
1 L bottle, 2 kg bottle,
200 g squeeze tube

Viscosity Use (cP) Low to Medium

**Loctite®
Bond-A-Matic® 3000
Reservoir 0-15 psi**



Item # 982720*/982726

Dispense
Patterns
DT, DR, B

Used To
Dispense
G, IA, LC, RC, TL

Package
Types and
Sizes
250 ml bottle, 1 lb. bottle,
1 L bottle, 2 kg bottle,
200 g squeeze tube

Viscosity Use (cP) Low to Medium

**Loctite®
Bond-A-Matic® 3000
Reservoir 0-100 psi**



Item # 982723*/982727

Dispense
Patterns
DT, DR, B

Used To
Dispense
G, IA, LC, RC, TL

Package
Types and
Sizes
250 ml bottle, 1 lb. bottle,
1 L bottle, 2 kg bottle,
200 g squeeze tube

Viscosity Use (cP) Medium to High

* With Low Level Sensor.

**Loctite®
2.25 gal Bottle
Reservoir**



Item # 98359

Used To
Dispense
G, IA, LC, RC, TL

Package
Types and
Sizes
250 ml, 1 lb., 1 L,
2 kg bottles,
200 g
squeeze tube

Viscosity
Use (cP) Low to
High

**Loctite®
Shot Miser™
Reservoir**



Item # 98090

Used To
Dispense
G, IA, LC,
RC, TL

Package
Types and
Sizes
250 ml bottle,
1 lb. bottle,
200 g
squeeze tube

Viscosity
Use (cP) Low to
High

**Loctite®
4 Liter Gravity
Feed Reservoir**



Item # 982880

Used To
Dispense
RC, TL

Package
Types and
Sizes
-

Viscosity
Use (cP) Low to
Medium

**Loctite®
Digital
Dispense
Controller**



Item # 98023

Independent
Channels
1

Number of
Dispense Valves
1

Advancing
Slide
-

Rotospray
-

**Loctite®
Single Channel
Automatic
Controller**



Item # 97123

Independent
Channels
1

Number of
Dispense Valves
2 (dependent)

Advancing
Slide
97118 - 50 mm
97119 - 100 mm

Rotospray
97115

**Loctite® Digital
Multi-Function
Controller**



Item # 98024

Independent
Channels
3

Number of
Dispense Valves
3 (independent)

Advancing
Slide
984691 - 50 mm

Rotospray
In conjunction with
Positive Displacement
Pump - 983330

**Loctite®
Shot Miser™
Valve
Controller**



Item # 98079

Independent
Channels
1

Number of
Dispense Valves
1

Advancing
Slide
-

Rotospray
-

AG = Anaerobic Gasketing
B = Beads

DR = Drops
DT = Dots

G = Gel Adhesives
IA = Instant Adhesives

LC = Light Cure/Acrylics
PS = Pipe Sealants

RC = Retaining Compounds
TL = Threadlockers

Dispensing

Valves - Hand Held

Loctite® brand Hand Held Dispensing Valves are used where ergonomic design for hand dispensing of fluids is desired. Designed for use with Loctite® brand Controllers and Reservoirs, these hand held valves utilize passive wetted components for universal compatibility with many fluids. Selection of a Loctite® brand Hand Held Valve is based on the desired dispensing controls, the dispense principal of the delivery system, and other process requirements.



**Loctite®
Hand Held Applicator**
**Loctite®
Hand Held Applicator**
**Loctite®
Hand Held Applicator**
**Loctite®
LV Hand Held Applicator**
**Loctite®
Vari-Drop™ Applicator**

					
Item #	97111	97112	97116	97130	97132
Dispense Control	Manual	Pneumatic	Pneumatic	Pneumatic	Manual
Viscosity (cP)	Low to Medium	Low to Medium	Low to Medium	Low	Low to Medium
Dispense Patterns	DR, DT, B	DR, DT, B	DR, DT, B	DR, DT, B	DR, DT, B
Used to Dispense	IA, LC, RC, TL	IA, LC, RC, TL	IA, LC, RC, TL	IA, RC, TL	IA, LC, RC, TL
Valve Type	Manual	P/T	P/T	P/T	Manual
Suck-Back	Yes	Yes	Yes	No	No
Stroke Adjustment	No	No	No	Yes	No
Finger/Foot Actuated	Finger	Foot	Finger	Foot	Finger
Wetted Components	Acetal, PTFE, PTFE Coated Metal	Acetal, PTFE, PTFE Coated Metal	Acetal, PTFE, PTFE Coated Metal	PTFE	PTFE

B = Bead
DR = Drop

DT = Dot
IA = Instant Adhesives

LC = Light Cure/Acrylics
P/T = Pressure Time Dispense

RC = Retaining Compounds
TL = Threadlockers

Fluid Compatibility Selector Chart

Accelerators	●	●	●	●	●
Acrylics	●	●	●	●	●
Activators	●	●	●	●	●
Anaerobics	●	●	●	●	●
Cyanoacrylates	●	●	●	●	●
Inks	●	●	●	●	●
Oils	●	●	●	●	●
Paints	●	●	●	●	●
Primers	●	●	●	●	●
Reagents	●	●	●	●	●
Solvents				●	●
UV & Light Cure Fluids	●	●	●	●	●
UV Anaerobics	●	●	●	●	●
Water				●	

For spare parts, accessories, and additional equipment information, reference the **Loctite® Equipment Sourcebook** or visit www.equipment.loctite.com.

Dispensing 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.

**Loctite®
Stationary
Applicator Valve**



**Loctite®
Diaphragm
Valve**



**Loctite®
Light Cure
Dispense Valve**



**Loctite®
Cyanoacrylate
Dispense Valve**



**Loctite®
Micro Needle
Valve**



**Loctite®
Shot Miser™
Dispense Valve**



**Loctite® Positive
Displacement
Pump**



**Loctite®
Poppet
Valve**











	Loctite® Stationary Applicator Valve	Loctite® Diaphragm Valve	Loctite® Light Cure Dispense Valve	Loctite® Cyanoacrylate Dispense Valve	Loctite® Micro Needle Valve	Loctite® Shot Miser™ Dispense Valve	Loctite® Positive Displacement Pump	Loctite® Poppet Valve
Item #	97113/97114	97135/97136	98009	98013	98084	98085	983330	986300/983914
Viscosity Range	Low to Medium	Low to Medium	Low to Medium	Low to Medium	Low to Medium	Low to Medium	Medium	Medium to High
Dispense Patterns	DT, DR, B	DT, DR, B	DT, MD, DR, B	DT, MD, DR, B	DT, MD, DR, B	DT, DR, B	DR	B, DR
Used to Dispense	IA, RC, TL, G	IA, RC, TL, LC	LC, RC, TL	IA, RC, TL, G	LC, RC, TL	IA, RC, TL, G	TL, RC	AG, TL, RC
Suck-Back	Yes	No	No	No	No	No	No	Yes
Adjustable Stroke	Yes	No	Yes	Yes	Yes	No	Yes	Yes
Valve Type	P/T	P/T	P/T	P/T	P/T	P/T	P/D	P/T
Wetted Components	Acetal, PTFE Coated Metals	Acetal, Stainless Steel, PTFE Coated Metals	Acetal, UHMW	UHMW	Acetal, PTFE, Stainless Steel	PTFE	Acetal, Stainless Steel, PTFE Coated Metals	Acetal
Inlet	¼" OD/⅜" OD	¼" OD/⅜" OD	⅛" NPT	⅛" NPT	¼" NPT	¼" NPT	⅜" OD	⅜" OD
Outlet	¼" UNF Luer-Lok Tip	¼" UNF Luer-Lok Tip	¼" UNF Luer-Lok Tip	¼" UNF Luer-Lok Tip	¼" UNF Luer-Lok Tip	¼" UNF Luer-Lok Tip	¼" OD	986300: Bayonet or ¼" NPT 983914: Bayonet or ⅛" NPT for Luer-Lok Tip

B = Bead
DR = Drop
DT = Dot
G = Gel Instant Adhesives

IA = Instant Adhesives
LC = Light Cure/Acrylics
MD = Microdots
P/D = Positive Displacement

P/T = Pressure Time Dispense
RC = Retaining Compounds
TL = Threadlockers

Loctite® Brand Valves & Pumps Fluid Compatibility Selector Chart

								
Item #	97113/ 97114	97135/ 97136	98009	98013	98084	98085	983330	986300/ 983914
Accelerators			●	●		●		
Acrylics	●	●	●		●	●		●
Activators			●	●		●		
Anaerobics	●	●	●	●	●	●	●	●
Cyanoacrylates	●			●		●		
Gasketing Anaerobics								●
Non-Abrasive Greases								●
Inks	●	●	●	●	●	●		
Lubricants								●
Oils	●	●	●	●	●	●		
One-Part Epoxies	●							●
Paints	●	●	●	●	●	●		
Primers			●	●		●		
Reagents			●	●		●		
Solvents			●	●		●		
UV & Light Cure Fluids	●	●	●		●	●		
UV Anaerobics	●	●	●		●	●		
Water		●	●	●	●	●		

Dispensing

Dispense Tips

Henkel offers a comprehensive line of Loctite® brand dispense tips which include 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. For your less critical applications, we offer more economical general purpose tips that still provide reliable and consistent dispensing shot after shot.



High Precision Stainless Steel Dispense Tips

1/4" Stainless Steel Tips Helical Thread

50 pack Item #	1000 pack Item #	Hub Color/Gauge
98196	98197	Green/18
98198	98199	Pink/20
98200	98201	Purple/21
98114	98115	Yellow/32



5/16" Stainless Steel Tips Helical Thread

50 pack Item #	1000 pack Item #	Hub Color/Gauge
98194	98195	Olive/14
98202	98203	Red/25
98204	98205	Clear/27
98206	98207	Lavender/30



1/2" Stainless Steel Tips Helical Thread

50 pack Item #	1000 pack Item #	Hub Color/Gauge
98396	98397	Amber/15
98398	98399	Green/18
98400	98401	Pink/20
98424	98425	Purple/21
98402	98403	Blue/22
98404	98405	Red/25
98104	98105	Lavender/30



1" Stainless Steel Tips Helical Thread

50 pack Item #	1000 pack Item #	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



1 1/2" Stainless Steel Tips Helical Thread

50 pack Item #	1000 pack Item #	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



45 Degree x 1/2" Stainless Steel Tips - Helical Thread

50 pack Item #	1000 pack Item #	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



90 Degree x 1/2" Stainless Steel Tips - Helical Thread

50 pack Item #	1000 pack Item #	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

1/4" Polyethylene Tapered Tips Helical Thread & UV Light Block Additive

50 pack Item #	1000 pack Item #	Hub Color/Gauge
98385	98386	White/14
98387	98388	Grey/16
98389	98390	Green/18
98391	98392	Pink/20
98393	98394	Blue/22



Flexible Dispense Tips

1/2" Flexible Polypropylene Tips Helical Thread

50 pack Item #	1000 pack Item #	Hub Color/Gauge
97229	98069	Amber/15
97230	98070	Green/18
97231	98071	Pink/20
97232	98082	Red/25



Additional Dispense Tips and Accessories



The Loctite® Showcase Needle Variety 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.

Item # 98439

General Purpose Dispense Tips

1/2" Stainless Steel Tips

50 pack Item #	1000 pack Item #	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



1 1/4" Polyethylene Tapered Tips

50 pack Item #	1000 pack Item #	Tip Color/Gauge
98272	98273	Tan/14
97221	98061	Grey/16
97222	98062	Green/18
97223	98063	Pink/20
97224	98064	Blue/22



Item #	Description
97238/98073	SS, PTFE Lined, 25 Gauge, 50/1000 pk
97233	Luer-Lok Adapter Kit, 20 Luer-Loks and 5 Adapters
97509/97510	Formable Dispense Tip, 21 Gauge, 50/1000 pk
97248	Tip Caps, 50 pk
97261/98074	High Density Polyethylene, 15 Gauge, White, 50/1000 pk
998390	Vari-Drop™ Applicator Brushes, 10 pk
97262	2 each of a variety of Helical Threaded 1/2" SS, Taper Tip, and Polypropylene Tips



Dispensing Monitoring Systems

These state-of-the-art detection systems allow real time process monitoring of dispense cycles. Whether you're looking to determine the presence of adhesive via fluorescence detection, or the amount of adhesive dispensed for an individual dispense nozzle, Henkel has the system that will get the job done with a high degree of precision and reliability.

Loctite® Fluid Waveform Analyzer, Signature Series

These state-of-the-art fluid detection systems are used where high quality production and data inspection are desired. They use "real time" data acquisition to detect plugged and broken dispense nozzles, nozzle voids, no dispense, low or high pressure, and air bubbles. Data acquisition can be stored locally or to a LAN. Fluid Waveform Analyzers are available in a range of price and performance options to meet specific dispensing process requirements.



Availability

Loctite® brand Fluid Waveform Analyzers are available through our Custom Equipment group in a range of price and performance options, custom configured to meet your specific requirements. For more information, contact the Henkel Technical Information Department at 1-800-LOCTITE (562-8483).

Loctite® Fluorescence Detector

Designed for the detection of fluorescent adhesives, this unit connects to an in-house power supply and PLC for monitoring of dispense processes utilizing fluorescent adhesives and sealants. Three interchangeable lenses are available for various detection distances. A 100,000 hour LED life ensures consistent and long-term process monitoring.



Item #	Description
98083	Fluorescence Detector
98101	Lens for 50 mm detection distance
98102	Lens for 9 mm detection distance
98103	Lens for 28 mm detection distance
986091	4 wire-conductor cable with M12 connector

Loctite® In-Line Flow Monitor

The Loctite® brand In-Line Flow Monitor, Item number 97211, when integrated with the Loctite® brand Single Channel Automatic Controller, Item number 97123, can provide an economical approach to adhesive dispense monitoring. Pressure changes due to air entrapment, broken or blocked nozzles, or substrate contact can be effectively monitored by the system with a high degree of accuracy and repeatability. All out of tolerance dispense cycles result in error messages being displayed on the controller display.

Required Accessories (Sold Separately)	Item #	Description
Sensor Cable	8965008	Pressure sensing cable for dispense valve interface
Valve Adapter	97200	Valve body adapter for Loctite® dispense valves 98009, 98013
Valve Adapter	97295	Valve body adapter for Loctite® dispense valves 97113, 97114
Controller	97123	Provides dispense control and tolerance monitoring



Motion Control Dispense Systems Robots

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 repeatedly and reliably dispense patterns of liquid material on a programmed basis, resulting in improved process efficiencies, minimal material waste, and reduced production 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.

SCARA is an acronym for Selective Compliance Assembly Robot Arm. The robot is a multi-jointed arm that moves above the work surface.

Robot Configurations

Loctite® 200 Series Benchtop Robot	
Part No.	Description
98279	200 x 200 mm, 3 axis, 110 V
98280	200 x 200 mm, 3 axis, 100 V CE Rated
98281	200 x 200 mm, 3 axis, 220 V
98282	200 x 200 mm, 3 axis, 220 V CE Rated
98283	200 x 200 mm, 4 axis, 110 V
98284	200 x 200 mm, 4 axis, 100 V CE Rated
98285	200 x 200 mm, 4 axis, 220 V
98286	200 x 200 mm, 4 axis, 220 V CE Rated
Loctite® 300 Series Benchtop Robot	
Part No.	Description
98287	300 x 320 mm, 3 axis, 110 V
98288	300 x 320 mm, 3 axis, 100 V CE Rated
98289	300 x 320 mm, 3 axis, 220 V
98290	300 x 320 mm, 3 axis, 220 V CE Rated
98291	300 x 320 mm, 4 axis, 110 V
98292	300 x 320 mm, 4 axis, 100 V CE Rated
98293	300 x 320 mm, 4 axis, 220 V
98294	300 x 320 mm, 4 axis, 220 V CE Rated

Loctite® 400 Series Benchtop Robot	
Part No.	Description
98295	400 x 400 mm, 3 axis, 110 V
98296	400 x 400 mm, 3 axis, 100 V CE Rated
98297	400 x 400 mm, 3 axis, 220 V
98298	400 x 400 mm, 3 axis, 220 V CE Rated
98299	400 x 400 mm, 4 axis, 110 V
98300	400 x 400 mm, 4 axis, 100 V CE Rated
98301	400 x 400 mm, 4 axis, 220 V
98302	400 x 400 mm, 4 axis, 220 V CE Rated
Loctite® S440 Series SCARA Robot	
Part No.	Description
98303	SCARA, 440 mm, 3 axis, 110 V
98304	SCARA, 440 mm, 3 axis, 100 V CE Rated
98305	SCARA, 440 mm, 3 axis, 220 V
98306	SCARA, 440 mm, 3 axis, 220 V CE Rated
98307	SCARA, 440 mm, 4 axis, 110 V
98308	SCARA, 440 mm, 4 axis, 100 V CE Rated
98309	SCARA, 440 mm, 4 axis, 220 V
98310	SCARA, 440 mm, 4 axis, 220 V CE Rated

Robot Selector Chart



		Loctite® 200 Series	Loctite® 300 Series	Loctite® 400 Series	Loctite® S440 Series
Type		Benchtop	Benchtop	Benchtop	SCARA
Number of controllable axes		3 to 4	3 to 4	3 to 4	3 to 4
Range of operation	X axis	200 mm	300 mm	400 mm	Arm 1: 260 mm ± 90°
	Y axis	200 mm	320 mm	400 mm	Arm 2: 180 mm ± 150°
	Z axis	50 mm	100 mm	150 mm	100 mm
	R axis	± 360°	± 360°	± 360°	± 360°
Portable weight	Work Surface	7.0 kg	11.0 kg	11.0 kg	N/A
	Tool Head	3.5 kg	6.0 kg	6.0 kg	5.0 kg
Speed <small>PTP = Point-to-Point. This is used for dot dispensing. CP = Continuous Path. This is used for bead dispensing.</small>	PTP (X,Y)	5 - 500 mm/s	8 - 800 mm/s	8 - 800 mm/s	15 - 1500 mm/s
	PTP (Z)	2.5 - 250 mm/s	3.2 - 320 mm/s	3.2 - 320 mm/s	3.2 - 320 mm/s
	PTP (R)	6 - 600 °/s	8 - 800 °/s	8 - 800 °/s	10 - 1,000 °/s
	CP (X,Y)	0.1 - 500 mm/s	0.1 - 800 mm/s	0.1 - 800 mm/s	0.1 - 800 mm/s
	CP (Z)	0.1 - 250 mm/s	0.1 - 800 mm/s	0.1 - 800 mm/s	0.1 - 800 mm/s
Repeatability accuracy	X, Y, Z axis	± 0.01 mm	± 0.01 mm	± 0.01 mm	± 0.02 mm
	R axis	± 0.02°	± 0.02°	± 0.02°	± 0.02°
Program capacity		100 programs	100 programs	100 programs	100 programs
Data memory capacity		6,000 points	6,000 points	6,000 points	6,000 points
Dimensions	Width	320 mm	560 mm	584 mm	290 mm
	Depth	377 mm	529 mm	629 mm	773 mm
	Height, 3 axis	536 mm	649 mm	799 mm	840 mm
	Height, 4 axis	655 mm	840 mm	890 mm	840 mm
Weight		18 kg	35 kg	42 kg	41 kg
Power source		110 or 220 V, 50-60 Hz	110 or 220 V, 50-60 Hz	110 or 220 V, 50-60 Hz	110 or 220 V, 50-60 Hz

For spare parts, accessories, and additional equipment information, reference the **Loctite® Equipment Sourcebook** or visit www.equipment.loctite.com.

Motion Control Dispense Systems

Dispense Stations

When a circular dispense pattern or an advancing dispense valve is required, Loctite® brand Motion Control Systems offer robust performance at a lower cost than robotic dispense stations. They are simple to set up and operate and their rugged construction makes them well suited for harsh manufacturing environments.



	Loctite® Advancing Slide Dispense Station	Loctite® Single Rotary Dispense Station	Loctite® Dual Rotary Dispense Station
Item #	98426	98427	98428
Dispense Pattern	Dots or Potting	Circles, Arcs and/or Dots in a Circular Pattern	Circles, Arcs and/or Dots in a Circular Pattern
Number of Dispense Points	1	1	2
Minimum Dispense Time	0.1 sec	0.01 sec	0.01 sec
Adjustable Valve Angle	Yes	Yes	Yes
Slide Stroke	0-2"	0-2"	0-2"
Fluid Pressure Regulation	0-90 psi	0-90 psi	0-90 psi
Maximum Part Size¹	N/A	8.5" Diameter	4" Diameter at 90° 6" Diameter at 45°
Maximum Part Height¹	12"	12"	8"
Weight Capacity²	N/A	30 lbs.	30 lbs.
Rotating Speed	N/A	0.1-100 RPM	0.1-100 RPM
Programming	4 Adjustable Range Analog Timers	Multi-line Digital Control Panel with User Friendly Prompts	Multi-line Digital Control Panel with User Friendly Prompts
Program Capacity	N/A	10 Programs, 20 Events per Program	10 Programs, 20 Events per Program
Dimensions	Width	12"	14"
	Depth	12"	10"
	Height	21"	22"
Weight	25 lbs.	26 lbs.	25 lbs.
Power Source	110 or 220 VAC/50-60 Hz	110 or 220 VAC/50-60 Hz	110 or 220 VAC/50-60 Hz

1 – The maximum part sizes are estimates and can vary depending on the specific part configuration and the size of the dispense syringe, cartridge or valve used.

2 – The weight capacity of the rotary station can vary depending on the center of gravity of the part and the program's rotating speed and acceleration. 30 lb. was provided as a general indicator of the motor's capacity. At weights in this range the equipment should be evaluated to confirm performance.

For additional equipment information, and to see the full line of accessories to complete your robotic dispense system, reference the **Loctite® Equipment Sourcebook** or visit www.equipment.loctite.com.

Fume Filtration

Benchtop Fume Filtration Systems

Benchtop Fume Filtration Systems, 98277 (with arm) and 98278 (without arm), are designed to remove dust particulate and fumes emitted by adhesives, sealants, cleaning solvents, and other chemicals. The compact systems offer flexible operation in a small space and match the airflow of many larger systems. The benchtop systems feature quiet operation and a bi-colored LED light to indicate blocked filters. The units can be operated as an open plenum for a working area up to 12" wide or can easily be converted into an arm system for more direct fume capture. The 2" x 24" flexible arm can be positioned to be unobtrusive to the operator, yet provide effective air filtration. The units are equipped with a Deep Bed Activated Carbon Fume Filter. HEPA/Carbon Filters are available separately.



Features

- High airflow rates
- Runs quietly
- LED light indicates blocked filter
- Efficient arm or plenum applications provide flexibility
- Compact, space-saving footprint
- UL, CSA, and CE compliant

Fume Filtration Systems

These Fume Filtration Systems are ideal for providing fume extraction at the workplace. The systems quietly remove the fumes away from the operator and filter the air. These freestanding units offer location flexibility and significantly reduced cost versus fixed systems. The systems are available in three different versions: a 115 V, 60 Hz version (98274); a 230 V, 50 Hz version (98275); and an explosion-proof version (98276) for the extraction of flammable gases in larger quantities. Each unit features a large 14" x 18" filter, which reduces the frequency of filter replacements. A differential pressure gauge allows the operator to monitor filter status. Each system can be used with up to 4 exhaust arms (987351) or 2 exhaust cabinets (987354) for fume capture, both sold separately. All units are equipped with a Deep Bed, 20 lbs. Activated Carbon Fume Filter. A HEPA filter is available separately.



Features

- High airflow rates
- Runs very quietly
- Large filter size extends filter life span
- Multi-stage filtration
- Connects 1 to 4 exhaust hoses or exhaust cabinet
- Compact size, unit fits under workbench
- Filter status indicator
- Thermal overload protection

Technical Specifications

	Item # 98274	Item # 98275	Item # 98276	Item # 98277	Item # 98278
Air inlet ports	2 x 2.5" dia. & 2 x 4" dia.	2 x 2.5" dia. & 2 x 4" dia.	2 x 2.5" dia. & 2 x 4" dia.	2" dia. x 24" long	12" plenum
Fan capacity	700 cfm	350 cfm	700 cfm	50 cfm	50 cfm
System capacity	200 cfm	264 cfm	200 cfm	50 cfm	50 cfm
Maximum static pressure	3.5 inches of water	5.0 inches of water	3.5 inches of water	5 inches of water	5 inches of water
Power supply	115 V, 60 Hz	230 V, 50 Hz	115 V, 60 Hz	90-264 V, 50-60 Hz	90-264 V, 50-60 Hz
Motor rating	0.75 HP/ 560 Watt	0.25 HP/ 250 Watt	0.75 HP/ 560 Watt	0.11 HP/ 85 Watt	0.11 HP/ 85 Watt
Power consumption	10 Amps	1.5 Amps	10 Amps	1 Amp	1 Amp
Noise level, approx.	60 dBA	58 dBA	60 dBA	55 dBA	55 dBA
Dimensions (W x D x H)	15.5" x 19.5" x 27"	15.5" x 19.5" x 27"	15.5" x 19.5" x 27"	12" x 13.5" x 11.75"	12" x 10.5" x 11.75"
Weight	105 lbs.	105 lbs.	105 lbs.	15.4 lbs.	14.3 lbs.
Power	On/off switch with power indicator light	On/off switch with power indicator light	External on/off foot switch	On/off switch with power indicator light	On/off switch with power indicator light
Approvals	UL, CSA	CE	UL, CSA	UL, CSA, CE	UL, CSA, CE

Light Cure

LED Light Source

Henkel has introduced the new Loctite® 7700 Hand Held LED Light Source, Item # 98418. This high power hand held light source is capable of curing a variety of UV/Visible adhesives in a matter of seconds. With the focused nature of this system's spectral output, IR output is negligible and part assembly heating is virtually eliminated. Compact size and rechargeable battery operation provide extensive use flexibility for even the most crowded or hard to reach locations.

Product Features

- Contains a high powered LED point light source – Typical 0.5 W/cm²*
- Emits light primarily in the visible light range
- Instant On/Off
- Can be operated while recharging
- Virtually no part assembly heating

Tested Loctite® Light Cure Adhesives: Cured Tack Free

- 3105™ (3311™)
- 3106™ (3321™)
- 3107™ (3341™)
- 3525™
- 3922™
- 3924™
- 3926™
- 3944™
- 3971™
- 3972™
- All Loctite® Flashcure® Light Cure Adhesives



Accessories Sold Separately

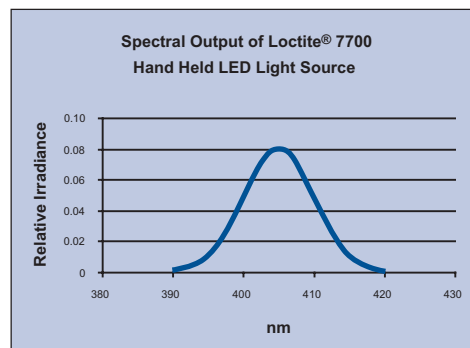
Item #	Description
97210	UV Safety Glasses
98419	AC Battery Charger
98089	ZETA® 7011-V Dosimeter
98440	Foot Switch
98443	Control Timer
98442	Remote Mount Heat Sink
988774	Constant-On Plug

Technical Specifications

Dimensions:	9" L x 1" W x 3/4" H
Weight:	0.44 lbs.
Light Source:	High powered LED
Utilities:	Battery powered or 110 V, 60 Hz
Typical Output*:	0.5 W/cm ²
Spectral Output Range:	390-420; Primary Peak 405 nm

*Exact output measurement is dependent on the brand and calibration method of the meter used.

These measurements were made with a Loctite® 7011-V at a distance of 0.25"



Light Cure Wand Systems




Loctite® brand ZETA® Light Cure Wand Systems are used for the continuous or batch processing of assemblies that require curing in small areas. These cost effective systems provide a variety of curing attributes. Selection of a Loctite® brand ZETA® Wand System is based on the required lamp intensity and the number and length of the light guides needed.

See page 129 for Loctite® brand UV Light Meters to measure spectral output.

**Loctite®
ZETA® 7735 UV
Wand System**

**Loctite®
ZETA® 7740 UV
Wand System**

**Loctite® ZETA® 7750
Programmable
UV Wand System**

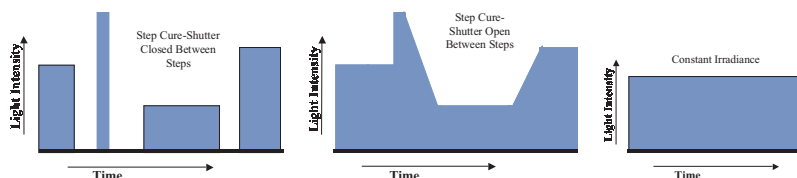
			
Item #	98317A	98157A	98046
Useful Curing Diameter	¼" to 1"	¼" to 1"	¼" to 1"
Number of Light Guides Supplied	None*	None*	None*
Lamp Type	50 Watt High Pressure Mercury Arc	100 Watt High Pressure Mercury Arc	100 Watt High Pressure Mercury Arc
Output Intensity	High	High	High
Maximum Light Power	5-7 W/cm ²	9-11 W/cm ²	9-11 W/cm ²
Intensity Programming	No	No	Yes**
Optimized Spectral Output Range	UVA, B, C	UVA, B, C	UVA, B, C
Spectral Wavelength	250-410 nm	250-410 nm	250-410 nm
Replacement Bulb (Item # - Type)	98339 - Lamp/Reflector Module, 50 W (HPMA)	984818 - Lamp/Reflector Module, 100 W (HPMA)	984818 - Lamp/Reflector Module, 100 W (HPMA)

*Light guides sold separately.

PRODUCT	Item Number	Description	For Use With
Light Guides	983677	Single Light Guide, 1 m long x 5 mm diameter	98317A, 98157A, 98046
	983684	Dual Light Guide, 1 m long x 3 mm diameter (See Note)	98317A, 98157A, 98046
	983800	Single Light Guide, 1.5 m long x 5 mm diameter	98317A, 98157A, 98046
	985045	Dual Wand Adapter Kit (See Note)	98317A, 98157A, 98046

Note: The Dual Wand Balancing Adaptor, Item 985045, is required if purchasing the Dual Light Guide, Item 983684, for the first time.

**Cure Profile Examples for the Loctite® ZETA® 7750 Programmable UV Wand System - 98046



Light Cure Flood Systems

Loctite® brand Flood Systems are modular low and medium intensity ultraviolet and high intensity visible light emitting units designed for the batch curing of light curing adhesives and coatings. Selection of a Loctite® brand Flood System is based on the required intensity of light and cure area.

For proper eye protection,
use Loctite® brand ultraviolet
safety glasses,
Item No. 97210



**Loctite® ZETA® 7411-S
UV Flood System**

**Loctite® ZETA® 7500
Portable UV Spot Lamp**

**Loctite® ZETA® 7420
Visible Light Flood System**

	 (Shown with Optional Shutter Assembly - Item 98420)		
Item #	98413	980127	98060
Useful Cure Area	8" x 8"	1" x 1"	12" x 12" typical
Lamp Type	Metal halide	Fluorescent	Visible Arc Lamp
Output Intensity	Medium	Low	High
Lamp Power	400 W	100 W	1,500 W
Optional Shutter Assembly	98420	-	-
Optimized Spectral Output Range	UVA	UVA	Visible Blue and Green
Optional Bulb Types	Visible Light Enhanced Metal Halide	-	-
Replacement Bulbs (Item # - Type)	97246 - UV Lamp 983050* - Visible Lamp	982033 - Mercury Vapor Bulb, 110 W	985940 - Visible Arc Lamp, 1,500 W
Replacement Filter Glass	988159	-	-

*Optional

Light Cure Cure Conveyors

Loctite® brand Cure Conveyors are used for continuous or batch processing of assemblies. Each conveyor has a unique set of features designed to meet the challenges of bench top curing of light curing adhesives and coatings. Selection of a Loctite® brand Cure Conveyor is based on the part size, required lamp for optimum cure, and whether the need for additional bulb types exists.



See page 129 for Loctite® brand UV Meters to measure spectral output.

**Loctite® ZETA® 7415 UV
Benchtop Conveyor**



**Loctite® ZETA® 7600 UV
Benchtop Conveyor**



		
Item #	98003	980550
Useful Cure Area	6" x 6"	5½" x 5½"
Lamp Type	See footnote*	Medium Pressure Mercury Arc
Output Intensity	High*	High
Maximum Part Cross-Section	3" H x 7½" W	3½" H x 6" W
Lamp Power	1,800 W*	1,800 W
Optimized Spectral Output Range	UVA, B, C*	UVA, B, C
Optional Bulb Types	D, V, H, H+	—
Replacement Bulbs (Item # - Type)	See footnote*	983091 - 6" UV Bulb

* The lamp assembly is sold separately; see the Light Sources and Power Supplies section on page 127 for more details.

Light Cure

Light Sources & Power Supplies

Loctite® brand Light Sources and Power Supplies provide high intensity ultraviolet light for curing light cure adhesives and coatings. These units are designed for use with a Loctite® brand Conveyor System or for integration into an assembly process where the customer provides the necessary shielding. Selection of a Loctite® brand Light Source and Power Supply is based on the bulb type, electrical requirements, and the desired part movement.



For proper eye protection, use Loctite® brand ultraviolet safety glasses, Item No. 97210

Fusion 208V Lamp Assembly and Power Supply

Fusion 240V Lamp Assembly and Power Supply

Loctite® High Intensity UV Source

			
Item #	98004	98005	980160
Useful Cure Area	Set-Up Dependent	Set-Up Dependent	Set-Up Dependent
Lamp Type	Electrodeless Fusion H	Electrodeless Fusion H	Medium Pressure Mercury Arc
Output Intensity	High	High	High
Lamp Power	1,800 W	1,800 W	1,500 W
Optimized Spectral Output Range	UVA, B, C	UVA, B, C	UVA, B, C
Optional Bulb Types	D, V, H+	D, V, H+	—
Replacement Bulbs (Item # - Type)	983471 - H Bulb 983469* - D Bulb 983470* - V Bulb	983471 - H Bulb 983469* - D Bulb 983470* - V Bulb	980161 - 5" UV Bulb

*Optional

Light Cure Cure Chambers

Loctite® brand Cure Chambers are used for the batch processing of parts that require light curing adhesives and coatings. These units are designed to meet a variety of process requirements. Selection of a Loctite® brand Cure Chamber is based on the part size, required lamp for optimum cure, and whether the need for additional bulb types exist.

For proper eye protection,
use Loctite® brand ultraviolet
safety glasses,
Item No. 97210

**Loctite® ZETA® 7215
UV Chamber**

**Loctite® ZETA® 7401
UV Chamber**

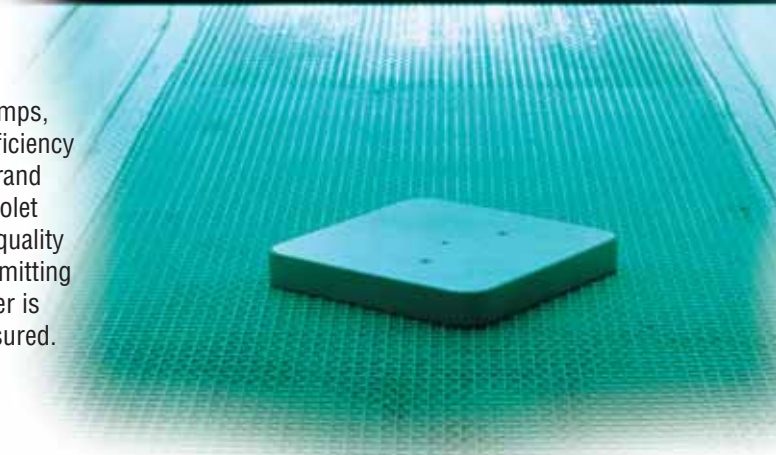
		
Item #	98081 (formerly 98007)	98039
Useful Cure Area	6" x 6"	8" x 8"
Lamp Type	Medium Pressure Mercury Arc	Metal Halide
Output Intensity	High	Medium
Maximum Part Size	9" x 10 ³ / ₄ " x 10 ³ / ₄ "	4" x 10" x 18"
Lamp Power	1,800 W	400 W
Optimized Spectral Output Range	UVA, B, C	UVA
Optional Bulb Types	–	Visible Light Enhanced Metal Halide
Timer Controlled Shutter	Yes	–
Replacement Bulbs (Item # - Type)	983091 - 6" UV Bulb	987246 - UV Lamp, 400 W 983050* - Visible Lamp, 400 W

*Optional

Light Cure

Light Meters

Decreased radiant power related to the degradation of UV lamps, light guides, and reflectors, results in declines in process efficiency or incomplete curing of UV light curing products. Loctite® brand ZETA® Light Meters are used to check the intensity of ultraviolet light emitted from a light source. These units are useful for quality measures, maintenance, and troubleshooting of ultraviolet emitting light sources. Selection of a Loctite® brand ZETA® Light Meter is based on the type of light source that is required to be measured.



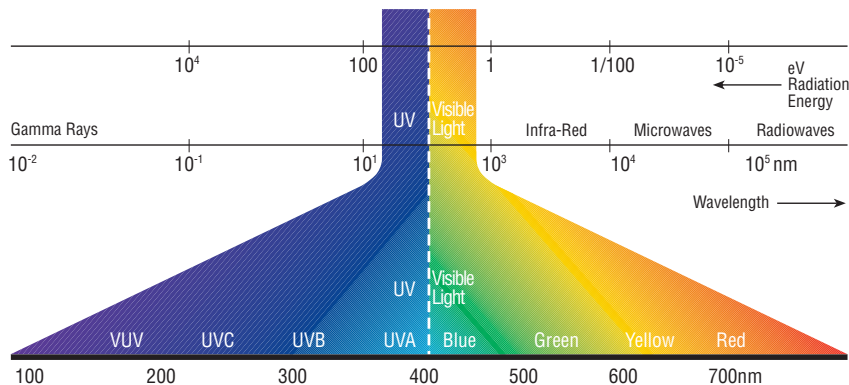
**Loctite® ZETA® 7011-A
Dosimeter-Radiometer**

**Loctite® ZETA® 7011-V
Dosimeter-Radiometer**

**Loctite® ZETA® 7021
Spot Radiometer**

			
Item #	98086	98089	98048
Measured Spectral Range	320-400 nm	350-500 nm	280-400 nm
Used to Measure Output of	Chambers, Conveyors, Flood Systems	Chambers, Conveyors, Flood Systems	3 mm & 5 mm diameter Wands

The Electromagnetic Spectrum



Custom Custom Equipment Systems

The Henkel Equipment Engineering Group can modify any of our standard dispensing or curing systems, or custom develop a system which combines our technology with your current manufacturing process. To access these services or obtain more information, call your Henkel Adhesives and Sealants Specialist at 1-800-LOCTITE (562-8483).

One of the most significant factors in making a process work is getting the adhesive to the part efficiently and effectively.

Since 1971, our Equipment Engineering Group has specialized in the design, fabrication, and testing of custom equipment systems and processes for applying and curing Loctite® brand adhesives. Henkel equipment engineers partner with customers early on in the development of an application. They provide process input to Henkel application engineers and customers to ensure a seamless transition, from selecting an adhesive that will perform in the application, to its implementation on a production line.

The following are just some of the custom systems the Henkel Equipment Engineering Group can provide.

- Dispense Workstations
- Silicone Pumping Systems
- UV Curing Systems
- Turnkey Bonding, Curing, Material Handling
- Porosity Sealing Systems
- Robotic X-Y-Z Gasketing Systems
- Silkscreen and Stencil Systems
- Pre-Applied Sealant Dispense Systems

Loctite® brand custom equipment systems provide optimal compatibility with Loctite® brand products. The Henkel total systems approach, of offering customers one-stop shopping, ensures that the system will meet or exceed expectations. No one is more capable of designing a system to apply and cure adhesives than the manufacturer of the adhesives. Our experience and unique partnership between customer, application engineering, and equipment engineering guarantees the highest level of expertise in the field of adhesive applications.

On-Site Technical Support

An experienced Henkel technical representative will work with you to assure optimal product and process performance. We will work to provide the most effective solution to your sealing problems. Continuous follow-up insures long-term success.

On-Site Service

The Henkel Service Department assures that your sealing operation will be kept up to proper standards at all times. Service is available 24 hours a day.



Loctite® Brand Impregnation Systems

Henkel designs, manufactures, and services a complete line of impregnation equipment to meet any customer requirement for porosity sealing.

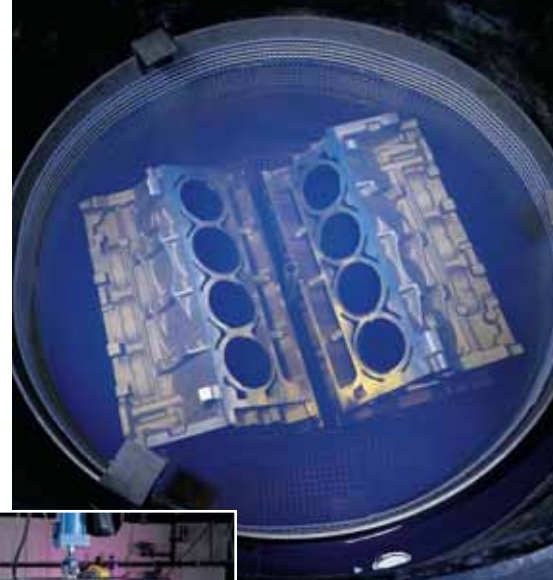
Available configurations include wet vacuum, wet vacuum pressure, and dry vacuum pressure equipment, designed and manufactured to meet the most demanding industrial standards. Whether you need a stand-alone process line, or a custom engineered system, integrated into your manufacturing environment, Henkel is the choice for all your impregnation equipment needs.

For help in specifying the ideal process for your needs, contact your local Henkel porosity sealing specialist at 1-800-LOCTITE, ext. 4338.

Impregnation System Profiles

MODEL	2218	3618	3624	3630	5524
Basket Diameter	22"	36"	36"	36"	55"
Working Depth	18"	18"	24"	30"	24"
Baskets Per Hour (anaerobic cure)	3-5	3-5	3-5	3-5	3-5
Baskets per Hour (elevated temperature cure)	2-3	2-3	2-3	2-3	2-3

Other sizes readily available upon request.



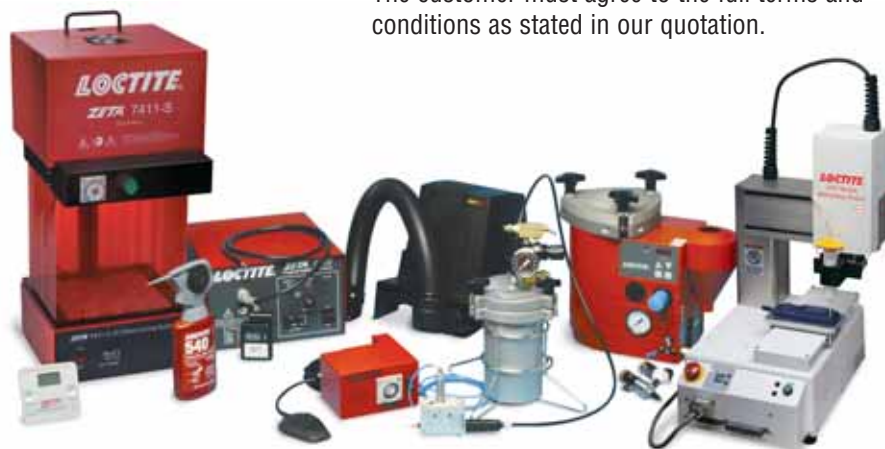
Loctite® Brand Equipment Rental Program

The Henkel rental program allows our customers the flexibility to confirm the performance of our adhesive and equipment essentially risk-free before making a capital investment. If you decide to purchase the equipment in the first 30 days, the entire rental charge is credited. The benefits of this program include:

- No initial capital outlay is required.
- Trained Henkel personnel will validate that equipment is in good working order.
- Your manufacturing and maintenance staff gets "hands-on" training with the equipment prior to purchase.
- The performance of a new manufacturing process can be confirmed in production representative conditions prior to purchase.
- Short-term production runs for rework or seasonal production can be performed without capital outlay.

Participation in the Program

- The Henkel Equipment Services department must be contacted for quotations, pricing, and availability of rental equipment at 1-800-LOCTITE, extension 5174 or 5452.
 - To rent equipment from Henkel, one of the following must apply:
 - You are an established Henkel customer and will use a purchase order.
 - You have a major credit card (Visa or MasterCard).
 - You will have an authorized Loctite® brand distributor send Henkel a purchase order.
 - The purchase order or credit card number must be received prior to shipping rental equipment.
 - The customer must agree to the full terms and conditions as stated in our quotation.



DID YOU KNOW?

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		Typewriter 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® brand 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:

$$\text{Length} \times \text{Width} \times \text{Bondline Thickness} \times 16.4 = \text{cc/ml requirement per part}$$

Non-threaded Cylindrical Parts:

$$\text{Diameter} \times \text{Engagement Length} \times \text{Bondline Thickness (on radius/per side)} \times 3.14 \times 16.4 = \text{cc/ml requirement per part}$$

Potting/Encapsulating Applications:

$$\text{Area} (3.14 \times R^2) \times \text{Potting Depth} \times 16.4 = \text{cc/ml requirement per part}$$

*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® brand 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:

LOCTITE® BRAND PRODUCT EXAMPLES

Product	Approximate Viscosity in Centipoise (cP)	Cyanoacrylates	Anaerobics
Water @ 70°	1-5	420™	–
Blood or Kerosene	10	–	290™
Anti-Freeze or Ethylene Glycol	15	406™	Letter Grade A
Motor Oil SAE 10 or Mazola Corn Oil	50-100	414™, 496™	609™
Motor Oil SAE 30 or Maple Syrup (Log Cabin)	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™
Karo® Corn Syrup or Honey	2,000-3,000	410™, 4211™	635™
Uncle Tom's® Blackstrap Molasses	5,000-10,000	411™, 382™	277™, 620™
Hershey® Chocolate Syrup	10,000-25,000	–	324™, 326™
Heinz® Ketchup or French's Mustard	50,000-70,000	409™	330™
Tomato Paste or Peanut Butter	150,000-250,000	–	592™
Crisco® Shortening – 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. Heinz® Ketchup is a good example that exhibits this property. Loctite® brand products include Loctite® 262™ Threadlocker and Loctite® 509™ Flange Sealant.

SHELF LIFE

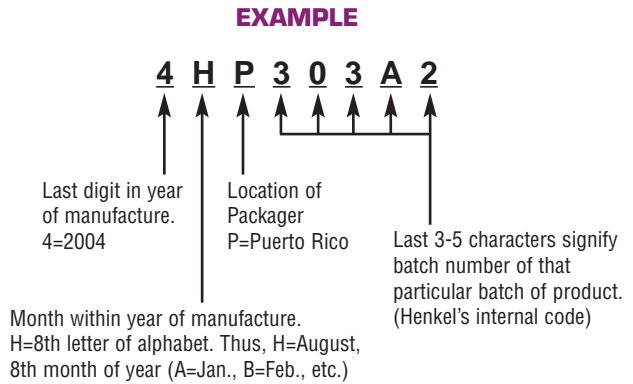
What is the Henkel shelf life policy for Loctite® brand products?

Most Loctite® brand products have a one year shelf life from date of shipment from Henkel facilities, unless otherwise specified by product label. One year holds true for unopened containers only. Once opened, Henkel does not put a time frame on shelf life due to lack of control over how the product is handled once sold. Cyanoacrylates are the primary line of products that should be refrigerated (40° ± 5°F) prior to opening. Once opened, store these products at room temperature (below 80°F) in a cool, dry location. Do not re-refrigerate cyanoacrylates after opening. Most other Loctite® brand products should be stored at room temperature (below 80°F) in a cool, dry location before and after opening.

Do the 6 or 7 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 2 years from date of manufacturing for most products.

How do you read this 6 or 7 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.

Henkel is in the process of implementing a new “Use By Date” label on all product packages to make the shelf life policy easier to understand.

PRODUCT & ITEM NO.	PRODUCT NAME	PAGE NO.	PRODUCT & ITEM NO.	PRODUCT NAME	PAGE NO.
ANZ023N01	Loctite® Standard Adapter/Check Valve/Jam Nut for Nozzles	109	392	Loctite® 392™ Structural Adhesive, Fast Fixture/Magnet Bonder	8, 10
D609	Loctite® D609™ Hysol® Epoxy Adhesive, Ultra Clear	17, 18, 21	401	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive	14
E-00CL	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	16, 18, 21	403	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	12, 14
E-00NS	Loctite® E-00NS™ Hysol® Epoxy Adhesive, Non-Sag	16, 18, 21	404	Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose	12, 14, 62, 63
E-05CL	Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened	16, 18, 21	406	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	14
E-20HP	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting	16, 18, 21	408	Loctite® 408™ Prism® Instant Adhesive, Low Odor/Low Bloom	14
E-20NS	Loctite® E-20NS™ Hysol® Epoxy Adhesive, Metal Bonder	16, 19, 21	409	Loctite® 409™ Super Bonder® Instant Adhesive, Industrial Grade Gel	14
E-30CL	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder	16, 19, 21	410	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	14
E-40FL	Loctite® E-40FL™ Hysol® Epoxy Adhesive, Flexible	16, 19, 21	411	Loctite® 411™ Prism® Instant Adhesive, Clear/Toughened	12, 14
E-60HP	Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened	16, 19, 21	414	Loctite® 414™ Super Bonder® Instant Adhesive	14
E-60NC	Loctite® E-60NC™ Hysol® Epoxy Adhesive, Electrically Non-Corrosive	17, 19	415	Loctite® 415™ Super Bonder® Instant Adhesive	14
E-90FL	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	17, 19, 21	416	Loctite® 416™ Super Bonder® Instant Adhesive	14
E-120HP	Loctite® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength	17, 19, 21	420	Loctite® 420™ Super Bonder® Instant Adhesive	14
E-214HP	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	17, 19, 21	422	Loctite® 422™ Super Bonder® Instant Adhesive	14
H3000	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	9, 11	425	Loctite® 425™ Assure™ Instant Adhesive, Surface Curing Threadlocker	51, 52
H3101	Loctite® H3101™ Speedbonder™ Structural Adhesive	11	426	Loctite® 426™ Prism® Instant Adhesive, Black/Toughened Gel	14
H3151	Loctite® H3151™ Speedbonder™ Structural Adhesive, Metal Bonder	9, 11	430	Loctite® 430™ Super Bonder® Instant Adhesive	12, 14
H3300	Loctite® H3300™ Speedbonder™ Structural Adh., General Purpose/Fast Fixture	9, 11	444	Loctite® 444™ Tak Pak® Instant Adhesive	12, 14
H4000	Loctite® H4000™ Speedbonder™ Structural Adhesive, Non-Sag	9, 11	454	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	14, 62, 63
H4100	Loctite® H4100™ Speedbonder™ Structural Adhesive, Ultra Fast	9, 11	455	Loctite® 455™ Prism® Instant Adhesive Gel, Low Odor/Low Bloom	15
H4200	Loctite® H4200™ Speedbonder™ Structural Adhesive, Toughened	9, 11	460	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	15
H4500	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	9, 11	480	Loctite® 480™ Prism® Instant Adhesive, Black/Toughened	15
H4800	Loctite® H4800™ Speedbonder™ Structural Adhesive, Toughened	9, 11	493	Loctite® 493™ Super Bonder® Instant Adhesive	15
H8000	Loctite® H8000™ Speedbonder™ Structural Adhesive, Fast Fixture	9, 11	495	Loctite® 495™ Super Bonder® Instant Adhesive	12, 15
M-11FL	Loctite® M-11FL™ Hysol® Medical Device Urethane Adhesive	59, 61	496	Loctite® 496™ Super Bonder® Instant Adhesive	15
M-21HP	Loctite® M-21HP™ Hysol® Medical Device Epoxy Adhesive	59, 61	498	Loctite® 498™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant	13, 15
M-31CL	Loctite® M-31CL™ Hysol® Medical Device Epoxy Adhesive	59, 61	499	Loctite® 499™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant Gel	15
M-121HP	Loctite® M-121HP™ Hysol® Medical Device Epoxy Adhesive	59, 61	504	Loctite® 504™ Gasket Eliminator® Flange Sealant, Gap Filling	34, 35
U-05FL	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	17, 20, 21	509	Loctite® 509™ Gasket Eliminator® Flange Sealant, Flexible	34, 35
U-09FL	Loctite® U-09FL™ Hysol® Urethane Adhesive, Highly Flexible	17, 20, 21	510	Loctite® 510™ Gasket Eliminator® Flange Sealant, High Temperature	34, 35, 84, 86
U-09LV	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20, 21	515	Loctite® 515™ Gasket Eliminator® Flange Sealant	34, 35
1C	Loctite® 1C™ Hysol® Epoxy Adhesive	18	518	Loctite® 518™ Gasket Eliminator® Flange Sealant	34, 35, 84, 86
1C-LV	Loctite® 1C-LV™ Hysol® Epoxy Adhesive	18	534	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	86, 87
1X	Loctite® 1X™ Hysol® Hot Melt Adhesive, EVA Based	25, 26	542	Loctite® 542™ Thread Sealant, Fine Threads	54, 56
3X	Loctite® 3X™ Hysol® Polyshot™ Hot Melt Adhesive, EVA Based	25, 26	545	Loctite® 545™ Thread Sealant, Hydraulic/Pneumatic Fittings	54, 56, 98, 99
6C	Loctite® 6C™ Hysol® Epoxy Adhesive	18	548	Loctite® QuickStix™ 548™ Gasket Eliminator®	86
11C	Loctite® 11C™ Hysol® Epoxy Adhesive	18, 21	549	Loctite® 549™ Instant Seal Plastic Gasket Thread Sealant	35
55	Loctite® 55™ Pipe Sealing Cord	98, 99	554	Loctite® 554™ Thread Sealant, Refrigerant Sealant	54, 56
220	Loctite® 220™ Threadlocker, Wicking Grade/Low Strength	52, 96, 97	561	Loctite® QuickStix™ 561™ PST® Pipe Sealant	98, 99
222	Loctite® 222™ Threadlocker, Low Strength/Small Screw	52	564	Loctite® 564™ Thread Sealant, General Purpose	54, 56, 98, 99
232	Loctite® 232™ Hysol® Hot Melt Adhesive, EVA Based	25, 27	565	Loctite® 565™ PST® Thread Sealant, Controlled Strength	54, 56, 98, 99
236	Loctite® 236™ Hysol® Hot Melt Adhesive, EVA Based	25, 27	567	Loctite® 567™ PST® Thread Sealant, High Temperature	55, 56, 98, 99
242	Loctite® 242™ Threadlocker, Medium Strength	50, 52, 96, 97	568	Loctite® 568™ Flange Sealant, Plastic Gasket	35
243	Loctite® 243™ Threadlocker, Medium Strength/Oil Resistant	50, 52	569	Loctite® 569™ Thread Sealant, Hydraulic Sealant	56
246	Loctite® 246™ Threadlocker, Medium Strength/High Temperature	50, 52	571	Loctite® 571™ Thread Sealant, Pipe Sealant HVV	56
248	Loctite® QuickStix™ 248™ Threadlocker, Medium Strength/Removable	96, 97	572	Loctite® 572™ Thread Sealant, Low Strength	55, 56
262	Loctite® 262™ Threadlocker, Medium to High Strength	50, 52, 96, 97	573	Loctite® 573™ Flange Sealant, Medium Strength	35
266	Loctite® 266™ Threadlocker, High Strength/High Temperature	50, 52	574	Loctite® 574™ Flange Sealant, Fast Curing	35
268	Loctite® QuickStix™ 268™ Threadlocker, High Strength	96, 97	577	Loctite® 577™ Thread Sealant, Coarse Threads	55, 56
271	Loctite® 271™ Threadlocker, High Strength	51, 52	579	Loctite® 579™ Thread Sealant, Instant Seal	55, 56
272	Loctite® 272™ Threadlocker, High Strength/High Temperature	51, 52	580	Loctite® 580™ PST® Thread Sealant, Low Halogen/Low Sulfur	55, 56
277	Loctite® 277™ Threadlocker, High Strength	51, 52	587	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	85, 87
290	Loctite® 290™ Threadlocker, Wicking Grade	51, 52, 96, 97	592	Loctite® 592™ PST® Thread Sealant, Slow Cure	55, 56
294	Loctite® 294™ Threadlocker, Wicking Grade/High Temperature	51, 52	598	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	85, 87
312	Loctite® 312™ Speedbonder™ Structural Adhesive	10	608	Loctite® 608™ Hysol® Epoxy Adhesive, High Strength	17, 18, 21
324	Loctite® 324™ Speedbonder™ Structural Adhesive, High Impact	8, 10	609	Loctite® 609™ Retaining Compound, Press Fit/General Purpose	46, 47, 94, 95
325	Loctite® 325™ Speedbonder™ Structural Adhesive, High Temperature	8, 10	615	Loctite® 615™ Hysol® Epoxy Adhesive, Sandable	17, 18, 21
326	Loctite® 326™ Speedbonder™ Structural Adhesive, Fast Fixture	8, 10	620	Loctite® 620™ Retaining Compound, Slip Fit/High Temperature	46, 47, 94, 95
330	Loctite® 330™ Depend® Adhesive, No-Mix	8, 10, 62, 63	630	Loctite® 630™ Retaining Compound, Slip Fit/High Strength/Slow Cure	46, 47
332	Loctite® 332™ Structural Adhesive, Severe Environment	8, 10	638	Loctite® 638™ Retaining Compound, Slip Fit/Maximum Strength	46, 47
334	Loctite® 334™ Structural Adhesive, High Performance	10	640	Loctite® 640™ Retaining Compound, Press Fit/Med. Strength/High Temperature	46, 47
342	Loctite® 342™ Hysol® Hot Melt Adhesive, EVA Based	26	641	Loctite® 641™ Retaining Compound, Press & Slip Fit/Controlled Strength	46, 47
349	Loctite® 349™ Impruv® Light Cure Adhesive	30	648	Loctite® 648™ Retaining Compound, Press Fit/High Strength/Rapid Cure	47
352	Loctite® 352™ Light Cure Adhesive	28, 30	660	Loctite® 660™ Quick Metal® Retaining Compound, Press Fit Repair	47, 94, 95
363	Loctite® 363™ Impruv® Light Cure Adhesive	30	661	Loctite® 661™ Retaining Compound, Slip Fit/UV Cure	22, 23, 47
366	Loctite® 366™ Light Cure Adhesive	30	668	Loctite® QuickStix™ 668™ Retaining Compound, High Temperature	94, 95
380	Loctite® 380™ Black Max® Instant Adhesive, Toughened	12, 14, 62, 63	675	Loctite® 675™ Retaining Compound, Press Fit/Medium Strength	47
382	Loctite® 382™ Tak Pak® Instant Adhesive, Ultra Performance	14	680	Loctite® 680™ Retaining Compound, Slip Fit/High Strength/High Viscosity	47, 95

NOTE: Can't find a Loctite® product/item number? Contact Customer Service for assistance at: 1-800-243-4874.

PRODUCT & ITEM NO.	PRODUCT NAME	PAGE NO.	PRODUCT & ITEM NO.	PRODUCT NAME	PAGE NO.
712	Loctite® 712™ Tak Pak® Accelerator	49	3751	Loctite® 3751™ LiteTak® Light Cure Adhesive	30
713	Loctite® 713™ Prism® Medical Device Accelerator	61	3761	Loctite® 3761™ LiteTak® Light Cure Adhesive	30
740	Loctite® 740™ Hysol® Hot Melt Adhesive, EVA Based	26	3911	Loctite® 3911™ Light Cure Adhesive	60
770	Loctite® 770™ Prism® Primer	48, 49	3912	Loctite® 3912™ Light Cure Adhesive	60
793	Loctite® 793™ Prism® Primer	49	3913	Loctite® 3913™ Light Cure Adhesive	60
222MS	Loctite® 222MS™ Threadlocker, Low Strength/Small Screw	50, 52, 96, 97	3921	Loctite® 3921™ Light Cure Adhesive, Plastic/Metal	58, 60
603	Loctite® 603™ Retaining Compound, Press Fit/Oil Tolerant	46, 47, 94, 95	3922	Loctite® 3922™ Light Cure Adhesive, Plastic/Metal	58, 60
740LV	Loctite® 0740LV™ Hysol® Hot Melt Adhesive, EVA Based	27	3924	Loctite® 3924™ Light Cure Adhesive, Plastic/Metal	58, 60
907	Loctite® 907™ Hysol® Epoxy Adhesive	18	3926	Loctite® 3926™ Light Cure Adhesive, Plastic/Metal	58, 60
0151	Loctite® 0151™ Hysol® Epoxy Adhesive, Ultra Clear	17, 18, 21, 23	3933	Loctite® 3933™ Light Cure Adhesive	60
0420	Loctite® 0420™ Hysol® SprayPac® Polyshot™ Hot Melt Adhesive, EVA Based	25, 26	3936	Loctite® 3936™ Light Cure Adhesive	60
0430	Loctite® 0430™ Hysol® SprayPac® Polyshot™ Hot Melt Adhesive, EVA Based	25, 26	3941	Loctite® 3941™ Light Cure Adhesive, High Performance/Various Substrates	58, 60
0437	Loctite® 0437™ Hysol® SprayPac® Hot Melt Adhesive, EVA Based	25, 26	3942	Loctite® 3942™ Light Cure Adhesive, High Performance/Various Substrates	58, 60
0450	Loctite® 0450™ Hysol® SprayPac® Polyshot™ Hot Melt Adhesive, EVA Based	25, 26	3943	Loctite® 3943™ Light Cure Adhesive, High Performance/Various Substrates	58, 60
0452	Loctite® 0452™ Hysol® SprayPac® Hot Melt Adhesive, EVA Based	25, 26	3944	Loctite® 3944™ Light Cure Adhesive	60
1942	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	25, 26, 44	3971	Loctite® 3971™ Light Cure Adhesive, Plasticized Substrates	58, 60
2432	Loctite® 2432™ Threadlocker, Low Halogen/Low Sulfur	51, 52	3972	Loctite® 3972™ Light Cure Adhesive, Plasticized Substrates	58, 60
2440	Loctite® 2440™ Threadlocker, Primerless/Medium Strength	51, 52	3981	Loctite® 3981™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	59, 61
2760	Loctite® 2760™ Threadlocker, Primerless/High Strength	51, 52	3982	Loctite® 3982™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	59, 61
3030	Loctite® 3030™ Adhesive, Polyolefin Bonder	9, 11	3984	Loctite® 3984™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	59, 61
3100	Loctite® 3100™ Light Cure Adhesive	30	4011	Loctite® 4011™ Prism® Medical Device Adhesive	59, 61
3101	Loctite® 3101™ Light Cure Adhesive	30	4013	Loctite® 4013™ Prism® Medical Device Adhesive	61
3102	Loctite® 3102™ Light Cure Adhesive	30	4014	Loctite® 4014™ Prism® Medical Device Adhesive	61
3103	Loctite® 3103™ Light Cure Adhesive	28, 30	4031	Loctite® 4031™ Prism® Medical Device Adhesive	61
3104	Loctite® 3104™ Light Cure Adhesive	30	4046	Loctite® 4046™ Hysol® Polyshot™ Hot Melt Adhesive	27
3105	Loctite® 3105™ Light Cure Adhesive	28, 30	4061	Loctite® 4061™ Prism® Medical Device Adhesive	61
3106	Loctite® 3106™ Light Cure Adhesive	28, 30	4081	Loctite® 4081™ Prism® Medical Device Adhesive	61
3107	Loctite® 3107™ Light Cure Adhesive	28, 30	4161	Loctite® 4161™ Prism® Medical Device Adhesive	61
3108	Loctite® 3108™ Light Cure Adhesive	28, 30	4203	Loctite® 4203™ Prism® Instant Adhesive, Thermal Resistant	15
3140	Loctite® 3140™ Hysol® Epoxy Resin, General Purpose	40, 42, 44	4204	Loctite® 4204™ Prism® Instant Adhesive, Thermal Resistant	13, 15
3141	Loctite® 3141™ Hysol® Epoxy Resin, High Temperature	40, 42, 44	4205	Loctite® 4205™ Prism® Instant Adhesive, Thermal Resistant	15
3142	Loctite® 3142™ Hysol® Epoxy Resin, Thermally Conductive	40, 43, 44	4206	Loctite® 4206™ Prism® Medical Device Adhesive	61
3144	Loctite® 3144™ Hysol® Epoxy Resin, Flame Retardant	40, 43, 44	4210	Loctite® 4210™ Prism® Instant Adhesive, Thermal Resistant	13, 15
3162	Loctite® 3162™ Hysol® Epoxy Hardener, Fast Cure	40, 42, 43, 44	4211	Loctite® 4211™ Prism® Instant Adhesive, Thermal Resistant	15
3163	Loctite® 3163™ Hysol® Epoxy Hardener, Excellent Adhesion	40, 42, 43, 44	4212	Loctite® 4212™ Prism® Instant Adhesive, Thermal Resistant Gel	13, 15
3164	Loctite® 3164™ Hysol® Epoxy Hardener, General Purpose	40, 42, 43, 44	4304	Loctite® 4304™ Flashcure® Light Cure Adhesive	29, 31, 60
3165	Loctite® 3165™ Hysol® Epoxy Hardener, Low Shrinkage	40, 42, 43, 44	4305	Loctite® 4305™ Flashcure® Light Cure Adhesive	29, 31, 60
3173	Loctite® 3173™ Hysol® Polyurethane Resin, General Purpose	40, 41, 44	4306	Loctite® 4306™ Flashcure® Light Cure Adhesive, Instant	29, 31, 59, 60
3175	Loctite® 3175™ Light Cure Adhesive	28, 30	4307	Loctite® 4307™ Flashcure® Light Cure Adhesive, Instant	29, 31, 59, 60
3182	Loctite® 3182™ Hysol® Polyurethane Hardener, Fast Cure	40, 41, 44	4471	Loctite® 4471™ Prism® Instant Adhesive, Surface Insensitive	15
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23693	Loctite® 3104™ Light Cure Adhesive	30	28588	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20
23694	Loctite® 3104™ Light Cure Adhesive	30	28589	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20
23695	Loctite® 3105™ Light Cure Adhesive	28, 30	28590	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20
23696	Loctite® 3105™ Light Cure Adhesive	28, 30	28591	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20
23697	Loctite® 3106™ Light Cure Adhesive	28, 30	28628	Loctite® 4206™ Prism® Medical Device Adhesive	61

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28654	Loctite® Form-A-Thread® Stripped Thread Repair Kit	104, 105	29709	Krytox® RFE PFPE High Performance Lubricant	88, 90
28753	Loctite® 564™ Thread Sealant, General Purpose	98, 99	29710	Krytox® RFE PFPE Lubricant	88, 90
28754	Loctite® 564™ Thread Sealant, General Purpose	54, 56, 98, 99	29711	Krytox® RFE PFPE High Performance Lubricant	88, 90
28755	Loctite® 564™ Thread Sealant, General Purpose	54, 56, 98, 99	30138	Krytox® RFE Advanced PTFE Dry Lubricant	89, 90
28802	Loctite® 641™ Retaining Compound, Press & Slip Fits/Controlled Strength	46, 47	30220	Loctite® 3525™ Light Cure Adhesive	29, 30
29005	Loctite® 290™ Threadlocker, Wicking Grade	51, 52	30221	Loctite® 3525™ Light Cure Adhesive	29, 30
29021	Loctite® 290™ Threadlocker, Wicking Grade	51, 52, 96, 97	30287	Loctite® 660™ Quick Metal® Retaining Compound, Press Fit Repair	47
29031	Loctite® 290™ Threadlocker, Wicking Grade	51, 52, 96, 97	30288	Loctite® 3335™ Light Cure Adhesive, UV Cationic Epoxy	29, 31
29041	Loctite® 290™ Threadlocker, Wicking Grade	51, 52, 96, 97	30289	Loctite® 3335™ Light Cure Epoxy Adhesive	29, 31
29043	Loctite® 290™ Threadlocker, Wicking Grade	51, 52	30507	Loctite® Instant Gasket	84, 86, 87
29287	Loctite® 5950™ Fastgasket® Flange Sealant	36, 37	30509	Loctite® Instant Gasket	84, 86, 87
29289	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	16, 18	30510	Loctite® Gasket Sealant 1	84, 87
29290	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	16, 18	30511	Loctite® Gasket Sealant 1	84, 87
29291	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	16, 18	30512	Loctite® Gasket Sealant 1	84, 87
29294	Loctite® E-00NS™ Hysol® Epoxy Adhesive, Non-Sag	16, 18	30513	Loctite® Gasket Sealant 2	84, 87
29295	Loctite® E-00NS™ Hysol® Epoxy Adhesive, Non-Sag	16, 18	30514	Loctite® Gasket Sealant 2	84, 87
29296	Loctite® E-00NS™ Hysol® Epoxy Adhesive, Non-Sag	16, 18	30515	Loctite® Gasket Sealant 2	84, 87
29299	Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened	16, 18	30516	Loctite® Aviation Gasket Sealant	86, 87
29300	Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened	16, 18	30517	Loctite® Aviation Gasket Sealant	86, 87
29301	Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened	16, 18	30518	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	85, 87
29302	Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened	16, 18	30521	Loctite® Pro Strength Degreaser	72, 74, 75
29303	Loctite® E-05CL™ Hysol® Epoxy Adhesive, Toughened	16, 18	30522	Loctite® Hydraulic Jack Oil	89, 91
29304	Loctite® E-40FL™ Hysol® Epoxy Adhesive, Flexible	16, 19	30523	Loctite® Hydraulic Jack Oil	89, 91
29305	Loctite® E-40FL™ Hysol® Epoxy Adhesive, Flexible	16, 19	30524	Loctite® Hi-Tack Gasket Sealant	86, 87
29306	Loctite® E-40FL™ Hysol® Epoxy Adhesive, Flexible	16, 19	30525	Loctite® Hi-Tack Gasket Sealant	86, 87
29309	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	17, 19	30526	Loctite® Hi-Tack Gasket Sealant	86, 87
29310	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	17, 19	30527	Loctite® Belt Dressing & Conditioner	76, 77
29311	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	17, 19	30529	Loctite® Pro Strength Varnish Remover	73, 74, 75
29314	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting	16, 18	30530	Loctite® White Lithium Grease	89, 91
29315	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting	16, 18	30533	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	85, 87
29316	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting	16, 18	30534	Loctite® Thread Sealant with PTFE	99
29317	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting	16, 18	30535	Loctite® Copper Gasket Adhesive	86, 87
29318	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting	16, 18	30536	Loctite® Dielectric Grease	89, 91
29319	Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened	16, 19	30537	Loctite® Contact Adhesive	62, 63
29320	Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened	16, 19	30538	Loctite® Heavy-Duty Rubberized Undercoating	76, 77
29321	Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened	16, 19	30539	Loctite® Extend® Rust Treatment	76, 77
29322	Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened	16, 19	30540	Loctite® Black Contact Adhesive	62, 63
29323	Loctite® E-60HP™ Hysol® Epoxy Adhesive, Toughened	16, 19	30541	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	85, 87
29324	Loctite® E-60NC™ Hysol® Epoxy Adhesive, Electrically Non-Corrosive	17, 19	30542	Loctite® 5920™ Copper, High Perf. RTV Sil. Gasket Mkr	36, 37, 85, 87
29325	Loctite® E-60NC™ Hysol® Epoxy Adhesive, Electrically Non-Corrosive	17, 19	30543	Loctite® White Lithium Grease	89, 91
29326	Loctite® E-60NC™ Hysol® Epoxy Adhesive, Electrically Non-Corrosive	17, 19	30544	Loctite® All-Purpose Spray Adhesive	63
29329	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder	16, 19	30545	Loctite® Non-Chlorinated Parts Cleaner	72, 74, 75
29330	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder	16, 19	30546	Loctite® Multi-Purpose Glass Cleaner	73, 74, 75
29331	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder	16, 19	30548	Loctite® Pro Strength Parts Cleaner	72, 74, 75
29334	Loctite® E-20NS™ Hysol® Epoxy Adhesive, Metal Bonder	16, 19	30556	Loctite® Pipe Joint Compound	99
29335	Loctite® E-20NS™ Hysol® Epoxy Adhesive, Metal Bonder	16, 19	30557	Loctite® Pipe Joint Compound	99
29336	Loctite® E-20NS™ Hysol® Epoxy Adhesive, Metal Bonder	16, 19	30558	Loctite® High Temperature Gasket Maker	86, 87
29339	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	17, 19	30560	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	85, 87
29340	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	17, 19	30561	Loctite® Thread Sealant with PTFE	99
29348	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	17, 20	30562	Loctite® Superflex® RTV, Clear Silicone Adhesive Sealant	85, 87
29349	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	17, 20	30563	Loctite® Superflex® RTV, Black Silicone Adhesive Sealant	85, 87
29350	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	17, 20	30564	Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant	85, 87
29353	Loctite® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength	17, 19	30565	Loctite® Aqua Power® Biodegradable Cleaner & Degreaser	72, 74, 75
29354	Loctite® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength	17, 19	30567	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	85, 87
29355	Loctite® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength	17, 19	30615	Krytox® RFE Cleaner	89, 90
29356	Loctite® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength	17, 19	30671	Loctite® M-21HP™ Hysol® Medical Device Epoxy Adhesive	59, 61
29357	Loctite® E-120HP™ Hysol® Epoxy Adhesive, Ultra Strength	17, 19	30673	Loctite® M-31CL™ Hysol® Medical Device Epoxy Adhesive	59, 61
29370	Loctite® U-09FL™ Hysol® Urethane Adhesive, Highly Flexible	17, 20	30674	Loctite® M-31CL™ Hysol® Medical Device Epoxy Adhesive	61
29371	Loctite® U-09FL™ Hysol® Urethane Adhesive, Highly Flexible	17, 20	30678	Loctite® M-11FL™ Hysol® Medical Device Urethane Adhesive	59, 61
29460	Loctite® U-09FL™ Hysol® Urethane Adhesive, Highly Flexible	17, 20	30680	Loctite® M-121HP™ Hysol® Medical Device Epoxy Adhesive	59, 61
29461	Loctite® U-09FL™ Hysol® Urethane Adhesive, Highly Flexible	17, 20	30684	Loctite® Instant Gasket	84, 86, 87
29462	Loctite® U-09FL™ Hysol® Urethane Adhesive, Highly Flexible	17, 20	30688	Loctite® 3345™ Light Cure Adhesive, Glass/Metal	58, 60
29487	Loctite® 3494™ Light Cure Adhesive	29, 30	30756	Loctite® 3526™ Light Cure Acrylic	23, 29, 30
29505	Loctite® 3175™ Light Cure Adhesive	28, 30	30764	Loctite® 3526™ Light Cure Acrylic	29, 30
29506	Loctite® 3175™ Light Cure Adhesive	28, 30	30765	Loctite® 3494™ Light Cure Adhesive	29, 30
29513	Loctite® 246™ Threadlocker, Medium Strength/High Temperature	50, 52	31064	Loctite® 3336™ Light Cure Adhesive	29, 31
29514	Loctite® 246™ Threadlocker, Medium Strength/High Temperature	50, 52	31065	Loctite® 3336™ Light Cure Adhesive	29, 31

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31132	Loctite® 5960™ Fastgasket® Flange Sealant	36, 37	34979	Loctite® Color Guard®, Tough Rubber Coating/Black	76, 77
31231	Loctite® 312™ Speedbonder™ Structural Adhesive	10	34980	Loctite® Color Guard®, Tough Rubber Coating/Black	76, 77
31243	Loctite® 312™ Speedbonder™ Structural Adhesive	10	34981	Loctite® Color Guard®, Tough Rubber Coating/Black	76, 77
31279	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	24, 27	34982	Loctite® Color Guard®, Tough Rubber Coating/Blue	76, 77
31291	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	24, 27	34983	Loctite® Color Guard®, Tough Rubber Coating/Blue	76, 77
31297	Loctite® 3650™ Hysol® Hot Melt Adhesive, Polyolefin	44	34984	Loctite® Color Guard®, Tough Rubber Coating/Blue	76, 77
31302	Loctite® 3650™ Hysol® Hot Melt Adhesive, Polyolefin	44	34985	Loctite® Color Guard®, Tough Rubber Coating/Red	76, 77
31303	Loctite® 3651™ Hysol® Hot Melt Adhesive, Polyolefin	24, 27, 44	34986	Loctite® Color Guard®, Tough Rubber Coating/Red	76, 77
31360	Krytox® RFE PFPE Lubricant	88, 90	34987	Loctite® Color Guard®, Tough Rubber Coating/Red	76, 77
31361	Krytox® RFE PFPE Lubricant	88, 90	34988	Loctite® Color Guard®, Tough Rubber Coating/Yellow	76, 77
31362	Loctite® Manufacturing Reliability Toolbox	104, 105	34989	Loctite® Color Guard®, Tough Rubber Coating/Yellow	76, 77
32037	Loctite® 3936™ Light Cure Adhesive	60	34990	Loctite® 349™ Impruv® Light Cure Adhesive	30
32040	Loctite® 3933™ Light Cure Adhesive	60	34991	Loctite® Color Guard®, Tough Rubber Coating/Yellow	76, 77
32047	Loctite® 3922™ Light Cure Adhesive, Plastic/Metal	58, 60	34994	Loctite® Primer for Color Guard® Tough Rubber Coating	77
32083	Loctite® 3922™ Light Cure Adhesive, Plastic/Metal	58, 60	34995	Loctite® Thinner for Color Guard® Tough Rubber Coating	77
32084	Loctite® 3933™ Light Cure Adhesive	60	35082	Loctite® 55™ Pipe Sealing Cord	98, 99
32254	Loctite® 4304™ Flashcure® Light Cure Adhesive, Instant	29, 31, 60	35173	Loctite® 3407™ OptiLOC® Fiber Optic Adhesive, Silicone/Heat Cure	23
32268	Loctite® 4305™ Flashcure® Light Cure Adhesive	29, 31, 60	35241	Loctite® 352™ Light Cure Adhesive	28, 30
32304	Loctite® 3936™ Light Cure Adhesive	60	35286	Loctite® 352™ Light Cure Adhesive	28, 30
32407	Loctite® 4304™ Flashcure® Light Cure Adhesive, Instant	29, 31, 60	35533	Loctite® 4500™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
32409	Loctite® 4305™ Flashcure® Light Cure Adhesive	29, 31, 60	35534	Loctite® 4500™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
32429	Loctite® 545™ Thread Sealant, Hydraulic/Pneumatic Fittings	54, 56, 98, 99	35813	Loctite® 4500™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
32430	Loctite® 324™ Speedbonder™ Structural Adhesive, High Impact	8, 10	35814	Loctite® 4500™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
32490	Loctite® 324™ Speedbonder™ Structural Adhesive, High Impact	8, 10	35939	Loctite® H8000™ Speedbonder™ Structural Adhesive, Fast Fixture	9, 11
32525	Loctite® 2760™ Threadlocker, Primerless/High Strength	51, 52	35940	Loctite® H8000™ Speedbonder™ Structural Adhesive, Fast Fixture	9, 11
32526	Loctite® 2760™ Threadlocker, Primerless/High Strength	51, 52	36057	Loctite® 3337™ Light Cure Adhesive, UV Cationic Epoxy	23, 29, 31
32527	Loctite® 2760™ Threadlocker, Primerless/High Strength	51, 52	36058	Loctite® 3337™ Light Cure Adhesive, UV Cationic Epoxy	29, 31
32528	Loctite® 2760™ Threadlocker, Primerless/High Strength	51, 52	36132	Loctite® Urethane Sealant	104, 105
32530	Loctite® 325™ Speedbonder™ Structural Adhesive, High Temperature	8, 10	36160	Loctite® H8000™ Speedbonder™ Structural Adhesive, Fast Fixture	9, 11
32545	Loctite® 3400™ OptiLOC® Fiber Optic Epoxy Adhesive	22, 23	36294	Loctite® 3972™ Light Cure Adhesive, Plasticized Substrates	58, 60
32546	Loctite® 3401™ OptiLOC® Fiber Optic Epoxy Adhesive	22, 23	36295	Loctite® 3972™ Light Cure Adhesive, Plasticized Substrates	58, 60
32547	Loctite® 3402™ OptiLOC® Fiber Optic Epoxy Adhesive	22, 23	36331	Loctite® 363™ Impruv® Light Cure Adhesive	30
32550	Loctite® 3403™ OptiLOC® Fiber Optic Epoxy Adhesive	22, 23	36334	Loctite® Magna-Crete Activator	83
32586	Loctite® 325™ Speedbonder™ Structural Adhesive, High Temperature	8, 10	36354	Loctite® Heavy Duty Anti-Seize	64, 66, 67
32629	Loctite® 326™ Speedbonder™ Structural Adhesive, Fast Fixture	8, 10	36390	Loctite® 363™ Impruv® Light Cure Adhesive	30
32685	Loctite® 326™ Speedbonder™ Structural Adhesive, Fast Fixture	8, 10	36437	Loctite® 3941™ Light Cure Adhesive, High Performance/Variou Substrates	58, 60
33058	Loctite® 330™ Depend® Adhesive, No-Mix	8, 10	36476	Loctite® 3941™ Light Cure Adhesive, High Performance/Variou Substrates	58, 60
33064	Loctite® 330™ Depend® Adhesive, No-Mix	8, 10	36478	Loctite® 3943™ Light Cure Adhesive, High Performance/Variou Substrates	58, 60
33081	Loctite® 330™ Depend® Adhesive, No-Mix	8, 10	36480	Loctite® 3943™ Light Cure Adhesive, High Performance/Variou Substrates	58, 60
33201	Loctite® 332™ Structural Adhesive, Severe Environment	8, 10	36481	Loctite® 3942™ Light Cure Adhesive, High Performance/Variou Substrates	58, 60
33241	Loctite® 567™ PST® Thread Sealant, High Temperature	55, 56, 98, 99	36483	Loctite® 3942™ Light Cure Adhesive, High Performance/Variou Substrates	58, 60
33275	Loctite® 332™ Structural Adhesive, Severe Environment	8, 10	36484	Loctite® 3921™ Light Cure Adhesive, Plastic/Metal	58, 60
33290	Loctite® 332™ Structural Adhesive, Severe Environment	8, 10	36485	Loctite® 3921™ Light Cure Adhesive, Plastic/Metal	58, 60
33403	Loctite® 334™ Structural Adhesive, High Performance	10	36488	Loctite® 3924™ Light Cure Adhesive, Plastic/Metal	58, 60
33417	Loctite® 3345™ Light Cure Adhesive, Glass/Metal	23, 58, 60	36489	Loctite® 3924™ Light Cure Adhesive, Plastic/Metal	58, 60
33470	Loctite® 334™ Structural Adhesive, High Performance	10	36492	Loctite® 3926™ Light Cure Adhesive, Plastic/Metal	58, 60
33486	Loctite® Maintenance Tackle Box	104, 105	36493	Loctite® 3926™ Light Cure Adhesive, Plastic/Metal	58, 60
33510	Loctite® Fixmaster® Super Grout	82, 83	36536	Loctite® 3911™ Light Cure Adhesive	60
33946	Loctite® 2440™ Threadlocker, Primerless/Medium Strength	51, 52	36537	Loctite® 3911™ Light Cure Adhesive	60
33947	Loctite® 2440™ Threadlocker, Primerless/Medium Strength	51, 52	36539	Loctite® 3912™ Light Cure Adhesive	60
33948	Loctite® 2440™ Threadlocker, Primerless/Medium Strength	51, 52	36540	Loctite® 3912™ Light Cure Adhesive	60
34018	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	85, 87	36631	Loctite® 366™ Light Cure Adhesive	30
34026	Loctite® Marine Grade Anti-Seize	65, 66, 67	36646	Loctite® Non-Flammable Contact Cleaner	73, 74, 75
34337	Loctite® 5963™ Procure™ Cure-In-Place Gasket	37	36766	Loctite® 3981™ Hysol® Epoxy Adhesive, High Performance/Variou Substrates	59, 61
34347	Loctite® 5964™ Procure™ Cure-In-Place Gasket	37	36767	Loctite® 3982™ Hysol® Epoxy Adhesive, High Performance/Variou Substrates	59, 61
34348	Loctite® 5964™ Procure™ Cure-In-Place Gasket	37	36768	Loctite® 3984™ Hysol® Epoxy Adhesive, High Performance/Variou Substrates	59, 61
34395	Loctite® Marine Grade Anti-Seize	65, 66, 67	36780	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91
34517	Loctite® White Hi-Temp Anti-Seize	65, 66, 67	36781	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91
34518	Loctite® White Hi-Temp Anti-Seize	65, 66, 67	36782	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91
34663	Loctite® Chisel® MC-Free Gasket Remover	73, 74, 75	36783	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91
34759	Loctite® 564™ Thread Sealant, General Purpose	98, 99	36784	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91
34894	Loctite® Color Guard®, Tough Rubber Coating/Black	76, 77	36786	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91
34895	Loctite® Color Guard®, Tough Rubber Coating/Blue	76, 77	36787	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91
34896	Loctite® Color Guard®, Tough Rubber Coating/Red	76, 77	36788	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-10W	88, 90, 91
34897	Loctite® Color Guard®, Tough Rubber Coating/Yellow	76, 77	36791	Loctite® 3913™ Light Cure Adhesive	60
34931	Loctite® 349™ Impruv® Light Cure Adhesive	30	36792	Loctite® 3971™ Light Cure Adhesive, Plasticized Substrates	58, 60
34943	Loctite® Industrial Hand Wipes	73, 74, 75	36804	Loctite® 3913™ Light Cure Adhesive	60
34944	Loctite® Industrial Hand Wipes	73, 74, 75	36805	Loctite® 3971™ Light Cure Adhesive, Plasticized Substrates	58, 60

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36906	Loctite® 3340™ Light Cure Adhesive, UV Cationic Epoxy	23, 29, 31	39148	Loctite® QuickStix™ 668™ Retaining Compound, High Temperature	94, 95
36907	Loctite® 3340™ Light Cure Adhesive, UV Cationic Epoxy	29, 31	39149	Loctite® QuickStix™ 668™ Retaining Compound, High Temperature	94, 95
36923	Loctite® 5905™ Flange Sealant, RTV Silicone	36, 37	39151	Loctite® QuickStix™ 548™ Gasket Eliminator®	84, 86
37061	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91	39152	Loctite® QuickStix™ 548™ Gasket Eliminator®	84, 86
37087	Loctite® 248™ Threadlocker Stick, Medium Strength/Removable	96, 97	39153	Loctite® QuickStix™ 548™ Gasket Eliminator®	84, 86
37127	Loctite® QuickStix™ 561™ PST® Pipe Sealant	98, 99	39155	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	86, 87
37220	Loctite® 3030™ Adhesive, Polyolefin Bonder	9, 11	39156	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	86, 87
37229	Loctite® QuickStix™ C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	39157	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	86, 87
37230	Loctite® QuickStix™ Silver Grade Anti-Seize	64, 66, 67	39170	Loctite® 4503™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
37297	Loctite® 3981™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	59, 61	39186	Loctite® 220™ Threadlocker, Wicking Grade/Low Strength	52, 96, 97
37298	Loctite® 3982™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	59, 61	39202	Loctite® Quicktite® Instant Adhesive	62, 63
37299	Loctite® 3984™ Hysol® Epoxy Adhesive, High Performance/Various Substrates	59, 61	39213	Loctite® 4503™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
37312	Loctite® Maximum Strength Headliner Adhesive	63	39214	Loctite® 4503™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
37316	Loctite® Fixmaster® Marine Chocking	82, 83	39222	Loctite® QuickStix™ C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67
37388	Loctite® 220™ Threadlocker, Wicking Grade/Low Strength	52, 96, 97	39223	Loctite® QuickStix™ Silver Grade Anti-Seize	64, 66, 67
37439	Loctite® 4306™ Flashcure® Light Cure Adhesive	29, 31, 59, 60	39231	Loctite® 4502™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
37441	Loctite® 4307™ Flashcure® Light Cure Adhesive	29, 31, 59, 60	39232	Loctite® 4502™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
37442	Loctite® 4306™ Flashcure® Light Cure Adhesive	29, 31, 59, 60	39233	Loctite® 4502™ Prism® Instant Adhesive, Fast Curing/Surface Insensitive Gel	13, 15
37443	Loctite® 4307™ Flashcure® Light Cure Adhesive	29, 31, 59, 60	39250	Loctite® 392™ Structural Adhesive, Fast Fixture/Magnet Bonder	8, 10
37684	Loctite® 248™ Threadlocker Stick, Medium Strength/Removable	96, 97	39275	Loctite® 392™ Structural Adhesive, Fast Fixture/Magnet Bonder	8, 10
37685	Loctite® 268™ Threadlocker Stick, High Strength	96, 97	39280	Loctite® 392™ Structural Adhesive, Fast Fixture/Magnet Bonder	8, 10
37686	Loctite® 268™ Threadlocker Stick, High Strength	96, 97	39341	Loctite® ViperLube® Clear High Performance Synthetic Grease	88, 90, 91
37708	Loctite® 4861™ Prism® Instant Adhesive, Flexible	13, 15, 59, 61	39342	Loctite® ViperLube® Clear High Performance Synthetic Grease	88, 90, 91
37710	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91	39363	Loctite® ViperLube® Clear High Performance Synthetic Grease	88, 90, 91
37711	Loctite® 4861™ Prism® Instant Adhesive, Flexible	13, 15, 59, 61	39364	Loctite® ViperLube® Clear High Performance Synthetic Grease	88, 90, 91
37719	Loctite® Fixmaster® Instant Belt Repair	70, 71	39366	Loctite® Fixmaster® Concrete Repair Epoxy	78, 80, 82, 83
37732	Loctite® 4851™ Prism® Instant Adhesive, Flexible	13, 15, 59, 61	39395	Loctite® 3165™ Hysol® Epoxy Hardener, Low Shrinkage	40, 42, 43, 44
37733	Loctite® 4851™ Prism® Instant Adhesive, Flexible	13, 15, 59, 61	39397	Loctite® 3184™ Hysol® Polyurethane Hardener, Flame Retardant	40, 41, 44
37795	Loctite® 542™ Thread Sealant, Fine Threads	54, 56	39398	Loctite® 3184™ Hysol® Polyurethane Hardener, Flame Retardant	40, 41, 44
38004	Loctite® 380™ Black Max® Instant Adhesive, Toughened	12, 14, 62, 63	39401	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38050	Loctite® 380™ Black Max® Instant Adhesive, Toughened	12, 14, 62, 63	39404	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38061	Loctite® 380™ Black Max® Instant Adhesive, Toughened	12, 14	39406	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38145	Loctite® 4501™ Prism® Instant Adhesive, Wicking Viscosity	13, 15	39413	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38146	Loctite® 4501™ Prism® Instant Adhesive, Wicking Viscosity	13, 15	39418	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38147	Loctite® 4501™ Prism® Instant Adhesive, Wicking Viscosity	13, 15	39426	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38181	Loctite® Silver Grade Anti-Seize	64, 66, 67	39428	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38203	Loctite® 382™ Tak Pak® Instant Adhesive, Ultra Performance	14	39431	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38210	Loctite® 3944™ Light Cure Adhesive	60	39439	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38212	Loctite® 3944™ Light Cure Adhesive	60	39441	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38240	Loctite® 382™ Tak Pak® Instant Adhesive, Ultra Performance	14	39444	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38261	Loctite® 382™ Tak Pak® Instant Adhesive, Ultra Performance	14	39452	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38350	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil-90W	88, 90, 91	39455	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38351	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil-90W	88, 90, 91	39457	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38352	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-10W	88, 90, 91	39458	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38353	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-10W	88, 90, 91	39463	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38402	Loctite® 7649™ Primer N™	48, 49, 96, 97	39465	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38535	Loctite® 5905™ Flange Sealant, RTV Silicone	36, 37	39466	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38584	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	39468	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38588	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20	39473	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38589	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20	39476	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38590	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20	39478	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38591	Loctite® U-09LV™ Hysol® Urethane Adhesive, Low Viscosity	17, 20	39479	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38872	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-15W	88, 90, 91	39483	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38873	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-15W	88, 90, 91	39486	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38874	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-15W	88, 90, 91	39488	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38875	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-20W	88, 90, 91	39499	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38876	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-20W	88, 90, 91	39504	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38877	Loctite® ViperLube® High Perf. Synthetic Lubricant, Lightweight Oil-20W	88, 90, 91	39510	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38878	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil-140W	88, 90, 91	39512	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38879	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil-140W	88, 90, 91	39515	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
38880	Loctite® ViperLube® High Performance Synthetic Lubricant, Gear Oil-140W	88, 90, 91	39523	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
38956	Loctite® Toolbox	104, 105	39528	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
39036	Loctite® 55™ Pipe Sealing Cord	98, 99	39536	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
39062	Loctite® Reliability Tackle box	104, 105	39541	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
39088	Loctite® Fixmaster® Fast Cure Epoxy, Mixer Cups	78, 80	39542	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93
39136	Loctite® Fixmaster® Marine Chocking	82, 83	39549	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
39146	Loctite® ViperLube® High Performance Synthetic Grease	88, 90, 91	39551	Loctite® Clover® Silicon Carbide Grease Mix	92, 93
39147	Loctite® QuickStix™ 668™ Retaining Compound, High Temperature	94, 95	39554	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93

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39561	Loctite® Clover® Silicon Carbide Grease Mix	92, 93	40604	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	14
39566	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93	40640	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	14
39574	Loctite® Clover® Silicon Carbide Grease Mix	92, 93	40661	Loctite® 406™ Prism® Instant Adhesive, Surface Insensitive	14
39579	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93	40840	Loctite® 408™ Prism® Instant Adhesive, Low Odor/Low Bloom	14
39587	Loctite® Clover® Silicon Carbide Grease Mix	92, 93	40861	Loctite® 408™ Prism® Instant Adhesive, Low Odor/Low Bloom	14
39589	Loctite® Clover® Silicon Carbide Grease Mix	92, 93	40904	Loctite® 409™ Super Bonder® Instant Adhesive Gel, Industrial Grade	14
39590	Loctite® Clover® Silicon Carbide Grease Mix	92, 93	40945	Loctite® 409™ Super Bonder® Instant Adhesive Gel, Industrial Grade	14
39592	Loctite® Clover® Silicon Carbide Pat Gel® Water Mix	92, 93	40974	Loctite® 409™ Super Bonder® Instant Adhesive Gel, Industrial Grade	14
39598	Loctite® Clover® Duplex Packaging	92, 93	41004	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	14
39633	Loctite® Fixmaster® Rapid Rubber Repair Static Mixers	71	41045	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	14
39635	Loctite® Fixmaster® Rapid Rubber Repair Dispenser	71, 106	41061	Loctite® 410™ Prism® Instant Adhesive, Black/Toughened	14
39636	Loctite® Fixmaster® Flex™ Cleaner	70	41104	Loctite® 411™ Prism® Instant Adhesive, Clear Toughened	12, 14
39637	Loctite® Fixmaster® Fast Set Grout	82, 83	41145	Loctite® 411™ Prism® Instant Adhesive, Clear Toughened	12, 14
39643	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	41161	Loctite® 411™ Prism® Instant Adhesive, Clear Toughened	12, 14
39647	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	41404	Loctite® 414™ Super Bonder® Instant Adhesive	14
39893	Loctite® C-200® High Temperature Solid Film Lubricant	89, 91	41450	Loctite® 414™ Super Bonder® Instant Adhesive	14
39894	Loctite® C-200® High Temperature Solid Film Lubricant	89, 91	41461	Loctite® 414™ Super Bonder® Instant Adhesive	14
39895	Loctite® Moly Dry Film Lubricant	89, 91	41550	Loctite® 415™ Super Bonder® Instant Adhesive	14
39896	Loctite® Moly Dry Film Lubricant	89, 91	41561	Loctite® 415™ Super Bonder® Instant Adhesive	14
39897	Loctite® Moly Dry Film Lubricant	89, 91	41650	Loctite® 416™ Super Bonder® Instant Adhesive	14
39901	Loctite® Zinc Anti-Seize	65, 66, 67	41661	Loctite® 416™ Super Bonder® Instant Adhesive	14
39904	Loctite® Thread Sealing Tape with PTFE	99	42050	Loctite® 420™ Super Bonder® Instant Adhesive	14
39915	Loctite® Big Foot™ Zero V.O.C.	68, 69	42061	Loctite® 420™ Super Bonder® Instant Adhesive	14
39916	Loctite® Urethane Sealant	104, 105	42250	Loctite® 422™ Super Bonder® Instant Adhesive	14
39917	Loctite® Fixmaster® Fast Set Steel Putty	79, 81	42261	Loctite® 422™ Super Bonder® Instant Adhesive	14
39918	Loctite® Nordbak® High Impact Wearing Compound	100, 102, 103	42540	Loctite® 425™ Assure™ Instant Adhesive, Surface Curing Threadlocker	51, 52
39944	Loctite® 3140™ Hysol® Epoxy Resin, General Purpose	40, 42, 44	42561	Loctite® 425™ Assure™ Instant Adhesive, Surface Curing Threadlocker	51, 52
39945	Loctite® 3140™ Hysol® Epoxy Resin, General Purpose	40, 42, 44	43004	Loctite® 430™ Super Bonder® Instant Adhesive	12, 14
39947	Loctite® 3141™ Hysol® Epoxy Resin, High Temperature	40, 42, 44	43050	Loctite® 430™ Super Bonder® Instant Adhesive	12, 14
39948	Loctite® 3141™ Hysol® Epoxy Resin, High Temperature	40, 42, 44	43061	Loctite® 430™ Super Bonder® Instant Adhesive	12, 14
39950	Loctite® 3142™ Hysol® Epoxy Resin, Thermally Conductive	40, 43, 44	44704	Loctite® 4471™ Prism® Instant Adhesive, Surface Insensitive	15
39951	Loctite® 3142™ Hysol® Epoxy Resin, Thermally Conductive	40, 43, 44	44740	Loctite® 4471™ Prism® Instant Adhesive, Surface Insensitive	15
39952	Loctite® 3142™ Hysol® Epoxy Resin, Thermally Conductive	40, 43, 44	44761	Loctite® 4471™ Prism® Instant Adhesive, Surface Insensitive	15
39953	Loctite® 3144™ Hysol® Epoxy Resin, Flame Retardant	40, 43, 44	45404	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	14
39954	Loctite® 3144™ Hysol® Epoxy Resin, Flame Retardant	40, 43, 44	45440	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	14
39956	Loctite® 3160™ Hysol® Epoxy Hardener, Glossy Surface Finish	40, 42, 43, 44	45474	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	14
39958	Loctite® 3160™ Hysol® Epoxy Hardener, Glossy Surface Finish	40, 42, 43, 44	45478	Loctite® 454™ Prism® Instant Adhesive, Surface Insensitive Gel	14
39960	Loctite® 3162™ Hysol® Epoxy Hardener, Fast Cure	40, 42, 43, 44	46004	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	15
39961	Loctite® 3162™ Hysol® Epoxy Hardener, Fast Cure	40, 42, 43, 44	46040	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	15
39962	Loctite® 3162™ Hysol® Epoxy Hardener, Fast Cure	40, 42, 43, 44	46061	Loctite® 460™ Prism® Instant Adhesive, Low Odor/Low Bloom	15
39964	Loctite® 3163™ Hysol® Epoxy Hardener, Excellent Adhesion	40, 42, 43, 44	46548	Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose	12, 14, 62, 63
39965	Loctite® 3163™ Hysol® Epoxy Hardener, Excellent Adhesion	40, 42, 43, 44	46551	Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose	12, 14, 62, 63
39966	Loctite® 3163™ Hysol® Epoxy Hardener, Excellent Adhesion	40, 42, 43, 44	46561	Loctite® 404™ Quick Set™ Instant Adhesive, General Purpose	12, 14
39969	Loctite® 3164™ Hysol® Epoxy Hardener, General Purpose	40, 42, 43, 44	48040	Loctite® 480™ Prism® Instant Adhesive, Black/Toughened	15
39970	Loctite® 3164™ Hysol® Epoxy Hardener, General Purpose	40, 42, 43, 44	48061	Loctite® 480™ Prism® Instant Adhesive, Black/Toughened	15
39973	Loctite® 3165™ Hysol® Epoxy Hardener, Low Shrinkage	40, 42, 43, 44	49350	Loctite® 493™ Super Bonder® Instant Adhesive	15
39980	Loctite® 3172™ Hysol® Polyurethane Resin, Flame Retardant (Low Tg)	40, 41, 44	49361	Loctite® 493™ Super Bonder® Instant Adhesive	15
39982	Loctite® 3172™ Hysol® Polyurethane Resin, Flame Retardant (Low Tg)	40, 41, 44	49504	Loctite® 495™ Super Bonder® Instant Adhesive, General Purpose	12, 15
39984	Loctite® 3173™ Hysol® Polyurethane Resin, General Purpose	40, 41, 44	49550	Loctite® 495™ Super Bonder® Instant Adhesive, General Purpose	12, 15
39985	Loctite® 3173™ Hysol® Polyurethane Resin, General Purpose	40, 41, 44	49561	Loctite® 495™ Super Bonder® Instant Adhesive, General Purpose	12, 15
39986	Loctite® 3173™ Hysol® Polyurethane Resin, General Purpose	40, 41, 44	49595	Loctite® 495™ Super Bonder® Instant Adhesive, General Purpose	12, 15
39992	Loctite® 3181™ Hysol® Polyurethane Hardener, Flame Retardant/Low Temp.	40, 41, 44	49650	Loctite® 496™ Super Bonder® Instant Adhesive	15
39993	Loctite® 3181™ Hysol® Polyurethane Hardener, Flame Retardant/Low Temp.	40, 41, 44	49661	Loctite® 496™ Super Bonder® Instant Adhesive	15
39995	Loctite® 3182™ Hysol® Polyurethane Hardener, Fast Cure	40, 41, 44	49850	Loctite® 498™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant	13, 15
39996	Loctite® 3182™ Hysol® Polyurethane Hardener, Fast Cure	40, 41, 44	49861	Loctite® 498™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant	13, 15
39997	Loctite® 3182™ Hysol® Polyurethane Hardener, Fast Cure	40, 41, 44	49904	Loctite® 499™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant Gel	15
39998	Loctite® 3183™ Hysol® Polyurethane Hardener, General Purpose	40, 41, 44	49945	Loctite® 499™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant Gel	15
39999	Loctite® 3183™ Hysol® Polyurethane Hardener, General Purpose	40, 41, 44	49974	Loctite® 499™ Super Bonder® Instant Adhesive, Thermal Cycling Resistant Gel	15
40086	Loctite® 5031™ Nuvu-Sil® Silicone Potting Compound	29, 31, 45	50441	Loctite® 504™ Gasket Eliminator® Flange Sealant, Large Gaps	34, 35
40087	Loctite® 5031™ Nuvu-Sil® Silicone Potting Compound	29, 31, 45	50480	Loctite® 504™ Gasket Eliminator® Flange Sealant, Large Gaps	34, 35
40088	Loctite® 5033™ Nuvu-Sil® Silicone Potting Compound	31	50965	Loctite® 509™ Gasket Eliminator® Flange Sealant, Flexible	34, 35
40089	Loctite® 5033™ Nuvu-Sil® Silicone Potting Compound	31	51001	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67
40104	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive	12, 14	51002	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67
40140	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive	12, 14	51003	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67
40161	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive	12, 14	51004	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67
40304	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	12, 14	51005	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67
40340	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	12, 14	51006	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67
40361	Loctite® 403™ Prism® Instant Adhesive, Low Odor/Low Bloom	12, 14	51007	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67

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51008	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	56747	Loctite® 567™ PST® Thread Sealant, High Temperature	55, 56, 98, 99
51009	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	56765	Loctite® 567™ PST® Thread Sealant, High Temperature	55, 56, 98, 99
51011	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	56790	Loctite® 567™ PST® Thread Sealant, High Temperature	55, 56
51031	Loctite® 510™ Gasket Eliminator® Flange Sealant, High Temperature	34, 35, 84, 86	56841	Loctite® 568™ Flange Sealant, Plastic Gasket	35
51041	Loctite® 510™ Gasket Eliminator® Flange Sealant, High Temperature	34, 35	56931	Loctite® 569™ Thread Sealant, Hydraulic Sealant	56
51048	Loctite® Moly Paste	64, 66, 67	56941	Loctite® 569™ Thread Sealant, Hydraulic Sealant	56
51049	Loctite® Moly Paste	64, 66, 67	56943	Loctite® 569™ Thread Sealant, Hydraulic Sealant	56
51050	Loctite® Moly Paste	64, 66, 67	57141	Loctite® 571™ Thread Sealant, Pipe Sealant HVV	56
51074	Loctite® 510™ Gasket Eliminator® Flange Sealant, High Temperature	34, 35	57941	Loctite® 579™ Thread Sealant, Instant Seal	55, 56
51084	Loctite® Graphite-50™ Anti-Seize	65, 66, 67	58031	Loctite® 580™ PST® Thread Sealant, Low Halogen/Low Sulfur	55, 56
51094	Loctite® Moly-50™ Anti-Seize	65, 66, 67	58730	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	85, 87
51102	Loctite® Nickel Anti-Seize	64, 66, 67	58775	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	85, 87
51115	Loctite® N-1000™ High Purity Anti-Seize	65, 66, 67	58791	Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	85, 87
51116	Loctite® N-1000™ High Purity Anti-Seize	65, 66, 67	59214	Loctite® 592™ PST® Thread Sealant, Slow Cure	55, 56
51117	Loctite® N-1000™ High Purity Anti-Seize	65, 66, 67	59231	Loctite® 592™ PST® Thread Sealant, Slow Cure	55, 56
51144	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	59241	Loctite® 592™ PST® Thread Sealant, Slow Cure	55, 56
51145	Loctite® Moly Paste	64, 66, 67	59243	Loctite® 592™ PST® Thread Sealant, Slow Cure	55, 56
51146	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	59330	Loctite® Superflex® RTV, Black Silicone Adhesive Sealant	85, 87
51147	Loctite® C5-A® Copper Based Anti-Seize Lubricant	64, 66, 67	59375	Loctite® Superflex® RTV, Black Silicone Adhesive Sealant	85, 87
51152	Loctite® Nickel Anti-Seize	64, 66, 67	59430	Loctite® Superflex® RTV, White Silicone Adhesive Sealant	85, 87
51168	Loctite® Food Grade Anti-Seize	65, 66, 67	59475	Loctite® Superflex® RTV, White Silicone Adhesive Sealant	85, 87
51170	Loctite® Food Grade Anti-Seize	65, 66, 67	59530	Loctite® Superflex® RTV, Clear Silicone Adhesive Sealant	85, 87
51171	Loctite® Food Grade Anti-Seize	65, 66, 67	59575	Loctite® Superflex® RTV, Clear Silicone Adhesive Sealant	85, 87
51211	Loctite® Maxi-Coat™	76, 77	59630	Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant	85, 87
51213	Loctite® Maxi-Coat™	76, 77	59675	Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant	85, 87
51221	Loctite® Penetrating Oil	89, 91	59830	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	85, 87
51242	Loctite® Extreme Pressure Grease	89, 91	59866	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	85, 87
51243	Loctite® N-5000™ High Purity Anti-Seize	65, 66, 67	59875	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	85, 87
51245	Loctite® N-5000™ High Purity Anti-Seize	65, 66, 67	59891	Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	85, 87
51246	Loctite® N-5000™ High Purity Anti-Seize	65, 66, 67	60905	Loctite® 609™ Retaining Compound, Press Fit/General Purpose	46, 47
51252	Loctite® Food Grade Grease	89, 91	60921	Loctite® 609™ Retaining Compound, Press Fit/General Purpose	46, 47, 94, 95
51269	Loctite® N-5000™ High Purity Anti-Seize	65, 66, 67	60931	Loctite® 609™ Retaining Compound, Press Fit/General Purpose	46, 47, 94, 95
51270	Loctite® N-7000™ High Purity Anti-Seize	65, 66, 67	60941	Loctite® 609™ Retaining Compound, Press Fit/General Purpose	46, 47, 94, 95
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