

What's the Problem?

Solution

Nuts, Bolts, Studs, Threaded Parts

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

222	Recommended for low-strength threadlocking of adjusting screws, countersunk head screws and set screws. Also use on low strength metals such as aluminium or brass which could break during disassembly. P1 NSF Reg. No.: 123002	Size of Thread Up to M36	Strength Low	Long-Term Temperature Resistance +150 °C	
243	Effective on all types of metal threaded fasteners. Prevents loosening on vibrating parts such as pumps, motor mounting bolts, gear boxes or presses. Recommended for use where disassembly with hand tools is required for servicing and where parts are contaminated with oil. P1 NSF Reg. No.: 123000. Certified to ANSI/NSF Standard 61	Size of Thread Up to M36	Strength Medium	Long-Term Temperature Resistance +150 °C	
248	Convenient to use, no migration. Suitable where product application access is difficult – overhead, under, or around machinery – on components that cannot be moved. Effective on all types of metal threaded fasteners. Recommended for applications where disassembly is required – Machine tools and presses, pumps and compressors, mounting bolts, gear boxes. Certified to ANSI/NSF Standard 61	Size of Thread Up to M50	Strength Medium	Long-Term Temperature Resistance +150 °C	
2701 (Improved 270)	For use on all metal fasteners (including stainless steels and those with protective coatings such as zinc) where regular removal for maintenance is not required. Recommended for permanently locking studs on engine blocks and pump housings. P1 NSF Reg. No.: 123006 – only Loctite® 270, WRC Approval 040303 – only Loctite® 2701	Size of Thread Up to M20	Strength High	Long-Term Temperature Resistance +150 °C	
268	Convenient to use, no migration. Suitable where product application access is difficult – overhead, under, or around machinery – on components that cannot be moved. Effective on all types of metal threaded fasteners. Recommended for use where regular removal for maintenance is not required – suspension bolts, motor transmission and pump mounts, bearing cap bolts and studs.	Size of Thread Up to M50	Strength High	Long-Term Temperature Resistance +150 °C	

Fluid Pipe Systems

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

55	Can be safely applied on metal and plastics threaded fittings. Potable water: WRC listed for use with potable water up to 85 °C, meets BS 6920. Meets KTW recommendation for cold and hot water. Gas and water: Carries the German DVGW approval (No. DV-5142AU0166), together with DIN 30660. Tested in accordance with EN751-2 Class ARP. Certified to ANSI/NSF Standard 61	Maximum Pipe Size Tested to 4"	Temperature Resistance +130 °C	Disassembly Strength Low	
542 (Hydraulic and pneumatic)	Recommended for fine threaded fittings as used in hydraulic and pneumatic installations and small fittings in general. Carries the German DVGW approval (NG-5146 AR 0855). Tested in accordance to EN 751-1. Meets BS 6956 type A for sealing gas fittings.	Maximum Pipe Size 3/4"	Temperature Resistance +150 °C	Disassembly Strength Medium	
577 (General purpose)	Recommended for all coarse metal threads. Suitable for applications at low temperatures e.g. outdoor plant maintenance. Carries the German DVGW approval (NG-5146 AR 0621). Tested in accordance to EN 751-1. Meets BS 6956 type B for sealing gas fittings. P1 NSF Reg. No.: 123001	Maximum Pipe Size 3"	Temperature Resistance +150 °C	Disassembly Strength Medium	
561	Convenient to use, no migration. Recommended for all coarse metal threads, where disassembly is required. Ideal for use in a broad range of industries including chemical processing, waste water treatment, and automotive. Certified to ANSI/NSF Standard 61	Maximum Pipe Size 3"	Temperature Resistance +150 °C	Disassembly Strength Low	

Flanges Leaking

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

548	Recommended for all types of rigid iron, steel and aluminium flanges. Apply Flange Sealant Stick directly on one surface of the flange.	Flange Type Rigid	Temperature Resistance 150 °C	Oil Resistance Good	
518	Recommended for use on rigid iron, steel and aluminium flanges. Apply as a continuous closed bead to one surface. P1 NSF Reg. No.: 123758	Flange Type Rigid	Temperature Resistance 150 °C	Oil Resistance Excellent	
510	Sealing rigid flanges Recommended for applications where high temperature and chemical resistance is needed. P1 NSF Reg. No.: 123007	Flange Type Rigid	Temperature Resistance Up to 200 °C	Oil Resistance Excellent	
5910	Replacement for cork and paper cut gaskets on flanges and stamped sheet metal covers. Recommended for use where high vibration or flexing occurs. Can also be used with plastic and painted parts.	Flange Type Flexible	Temperature Resistance 200 °C	Oil Resistance Excellent	

Bearings, Bushes, Shafts, Cylindrical Parts

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

660 (with Activator 7240)	Used for repairing worn coaxial parts without remachining: enables re-use of worn bearing seats, keys, splines, tapers, or for retaining shims. (use with Activator Loctite® 7240). P1 NSF Reg. No.: 123704	Strength Required High	Diametrical Clearance Up to 0.5 mm	Temperature Resistance 150 °C	
668	Convenient to use. Suitable where product application access is difficult – overhead, under or around machinery – on components that cannot be moved. Recommended for all kinds of retaining applications with medium strength.	Strength Required Medium	Diametrical Clearance Up to 0.15 mm	Temperature Resistance 150 °C	
648	Recommended for high temperature retaining of parts with a clearance or interference fit i.e. retaining bushes, bearings, seals, fans, and liners.	Strength Required High	Diametrical Clearance Up to 0.15 mm	Temperature Resistance 175 °C	
638	Gives best resistance to dynamic, axial and radial loads. Recommended for retaining shafts, gears, pulleys and similar cylindrical parts. KTW approval for cold and hot water. P1 NSF Reg. No.: 123010, WRC Approval 9909511	Strength Required High	Diametrical Clearance Up to 0.25 mm	Temperature Resistance 150 °C	
603 (Improved 601)	For retaining close fitting cylindrical parts (up to 0.1 mm gap). For use on cylindrical fitting parts where thorough degreasing is not possible. Tested and approved for use on bearings. P1 NSF Reg. No.: 123003	Strength Required High	Diametrical Clearance Up to 0.1 mm	Temperature Resistance 150 °C	

Flexible Joining of Parts

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

5366 5367 5368	Flexible Adhesive/Sealant Cures to a flexible rubber. Recommended for bonding, sealing and protecting components subjected to vibration. Suitable for glass, metal, ceramics, composites, and most plastics. Loctite® 5366 – Clear, Loctite® 5367 – White, Loctite® 5368 – Black	Operating Temperature Up to 250 °C	Skin Over Time 5 min.	Especially for Glass	
5399	Flexible high temperature Adhesive/Sealant Suitable for bonding and sealing glass, metal, and ceramics, where temperature can reach 350 °C, e.g. sealing of stove flues/chimneys, industrial ovens, electro-appliances and ventilation systems.	Operating Temperature Up to 350 °C	Skin Over Time 5 min.	Especially for Oven door seals, heat source sealing	

What's the Problem?

Solution

Joining Small Parts

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

406 (with Primer 7239)	Rapid bonding of rubbers (including EPDM), plastics and elastomers, when used with Loctite® 7239 Polyolefin Primer bonds "difficult to bond" plastics.	Operating Temperature Up to 80 °C	Fixture Time* 10–20 sec.	Especially for Plastics	
401	General purpose for bonding most substrates such as plastics, rubber, metals, card, wood.	Operating Temperature Up to 80 °C	Fixture Time* 5–20 sec.	Especially for Porous Substrates	
454	General purpose gel for bonding metals, composite materials, wood, cork, foam, leather, card, paper, and unglazed ceramics. Recommended for use on vertical or overhead surfaces. P1 NSF Reg. No.: 123009	Operating Temperature Up to 80 °C	Fixture Time* 5–20 sec.	Especially for Porous Substrates	
480	Black, rubber toughened grade for bonding metal to metal and metal to rubber; especially suitable with applications where high peel strength is required and/or shock loads are present.	Operating Temperature Up to 100 °C	Fixture Time* 60–120 sec.	Especially for Metal/Plastics	
330/7388 MULTI-BOND®	MULTI-BOND® 50 ml Kit is a two part no mix, fast curing, toughened adhesive with good impact resistance. Ideal for bonding dissimilar substrates, including plastics like PVC, phenolic and acrylic. Loctite® 330: P1 NSF Reg. No.: 123005	Operating Temperature Up to 100 °C	Fixture Time 5 min.	Viscosity 67.5 Pa.s	
3430 A&B	Loctite® Hysol® 3430 A&B is a five-minute, 2K-Epoxy adhesive, suitable for applications requiring an optically clear bond line. Ideal for bonding glass, decorative panels and displays and general repair applications.	Operating Temperature Up to 80 °C	Fixture Time 12 min.	Viscosity 25 Pa.s	
3450 A&B	Loctite® Hysol® 3450 A&B is a metal-filled, five minute, 2K-Epoxy adhesive, suitable for where large gaps are present. Ideal for bonding and filling damaged components.	Operating Temperature Up to 100 °C	Fixture Time 12 min.	Viscosity 35 Pa.s	

Joining Large/Structural Parts

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

8018	Solvo Rust Releases rusted, corroded and seized components. A penetrating oil to free rusted nuts, bolts, screws, fittings, other fasteners as well as metal components in industrial equipment. Also recommended for cleaning parts before lubrication and as a light lubricant and rust inhibitor.	Appearance Colourless	Base Mineral oil	Temperature Range N.A.	
8021	Silicone oil This product is a general purpose, low viscosity silicone oil used for lubricating metal and non metal surfaces. It may also be used as a release agent.	Appearance Colourless liquid	Base Silicone oil	Temperature Range -30 to +150 °C	
8201	Five Way Spray Frees, lubricates, cleans. Displaces moisture, and prevents corrosion. Ideal for light lubrication of metals and freeing assemblies.	Appearance Light yellow liquid	Base Mineral oil	Temperature Range -20 to +120 °C	
8150 8151 8060	Aluminium Anti-Seize Aluminium based Anti-Seize for screws, nuts, pipes, heat exchangers etc. Typical applications: wheel to hub connection. Loctite® 8150 can/Loctite® 8151 aerosol/Loctite® 8060 stick	Colour Grey	N.L.G.I. Class 0	Temperature Range -30 to +900 °C	
8007 8008 8065	C5-A® Copper Anti-Seize Copper based Anti-Seize, for screws, nuts, pipes, heat exchangers etc. Typical applications: exhaust bolts, brake caliper bolts. Loctite® 8007 aerosol/Loctite® 8008 brush top/Loctite® 8065 stick	Colour Copper	N.L.G.I. Class 1	Temperature Range -30 to +980 °C	
8009	Heavy duty Anti-Seize brush top Metal free Anti-Seize providing a long term lubrication on all metals including stainless steel and titanium.	Colour Black	N.L.G.I. Class 1	Temperature Range -30 to +1315 °C	

Lubrication

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

Corroding Components

? Prevent corrosion after assembly or during storage

7800 7922	Zinc spray Provides excellent cathodic protection on ferrous metals. Can be used as a primer prior to painting. Especially suitable for protecting welds from corrosion on galvanised parts. Loctite® 7800 Zinc spray shiny/Loctite® 7922 Zinc spray matt (not available in UK)	Description Zinc spray	Colour Grey	Temperature Range -50 to +550 °C	
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Worn and Damaged Parts

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

3463	Metal Magic Steel™ stick Working time 3 minutes – sets in 10 minutes. Steel filled kneadable stick. Adheres to damp surfaces and cures under water. Chemical and corrosion resistant. Can be drilled, filed and painted. It is ideal for emergency sealing of leaking tanks and pipes. Smoothes welds, repairs small cracks in castings and fills oversized bolt holes. ANSI/NSF Standard 61	Maximum Temperature 120 °C	Working Time 3 min.	Cure Time 10 min.	
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Cleaning Parts and Hands

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

7850	Hand cleaner Hand cleaner made from natural extracts and free from mineral oils. Biodegradable. Contains premium skin conditioners. Works with or without water. Removes ground-in dirt, grease, grime, and oil.	Description Hand cleaner	
7039	Contact cleaner spray Does not affect insulating varnishes. For cleaning electrical contacts, relays, switchgear etc. without affecting insulating varnishes. Displaces moisture and forms a water repellent film.	Description Contact cleaner spray	
7200*	Gasket remover Removes cured gasket sealants and traditional gaskets from most types of surfaces in 10 to 15 minutes with minimal scraping.	Description Gasket remover	
7063	Cleaner & degreaser Solvent based general parts cleaner which leaves no residue – ideal for use prior to adhesive bonding and sealing applications. Compatible with metal, glass, rubber, most plastics and painted surfaces.	Description Cleaner and degreaser	
7840*	Cleaner & degreaser Biodegradable, solvent free, non-toxic and non flammable, diluted with water. Rated USFA-C1. Removes grease, oil, cutting fluids and workshop grime.	Description Cleaner and degreaser	

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



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Henkel & Motor Sports

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The Dakar Rally 2015 is the latest in a long line of top-level competitive motor sport events in which Henkel has been involved. It's a tough 16-day tour across 6 countries, and the mechanical components in the cars, bikes and trucks that competed were put under enormous stresses. Henkel has assisted the drivers as an Official Supplier, offering a wide range of Loctite® and Tensol products to help them overcome the toughest conditions. From the most demanding top-level events, Henkel has helped to ensure competitors in the field are prepared to win more than a match for the world's most demanding conditions.

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Henkel Loctite
Adhesives Limited
Wood Lane End
Henri-Henrichland
Herdonshire Herts, UK
Tel: 01462 418255
Fax: 01462 418259
www.loctite.co.uk

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