

## Solution Guide



Henkel



# Introduction

## How can this guide help you make the right choice?

**This Solution Guide has been developed to make your product selection quick, easy and right the first time. Select the best product from the Henkel portfolio and choose the solution that's right for your business.**

Henkel is a world-wide operating, market-driven specialist in brands and technologies providing all-round competence from one single source. Strong brands with proven and trusted names – such as Loctite®, Teroson, Hysol®, Nordbak® – are the key to securing ongoing and future market success.

### **Keep it running – Keep it simple – Do it fast**

Henkel solutions are designed to help maintenance professionals in any industry to work smarter, increase equipment reliability, reduce downtime and equipment failures.

This guide offers clear, quick, effective solutions to the most common problems. There are several starting points:

- The problem solving section
- The product categories from the Henkel portfolio
- The product list including ordering information

### **Hands-on Maintenance Workshops help drive down costs**

Learn to cut maintenance time and costs while increasing the reliability of your equipment: Loctite® In-Plant Maintenance Workshops are designed

- to fit your needs
- to provide maintenance personnel with the necessary skills and tools
- to reduce plant down time and maintenance costs.

For further details or services, please visit our web site at **[www.henkel.com](http://www.henkel.com)** or contact your local Henkel Technical Support specialist. For additional information visit our website at **[www.loctite-users-choice.com](http://www.loctite-users-choice.com)**.



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# What's the Problem?



## Nuts, Bolts, Studs, Threaded Parts

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

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## Fluid Pipe Systems

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

See also Emergency Repair Products on page 41

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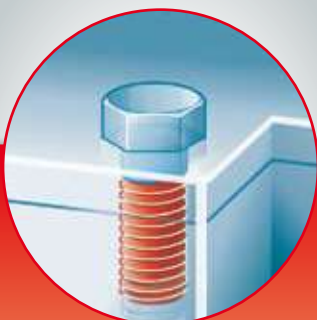
## Flanges Leaking

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

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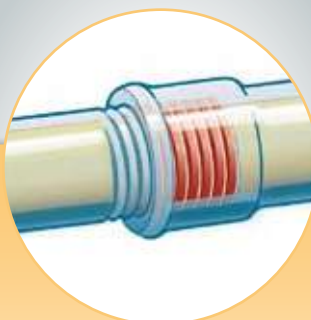
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## Our Solution



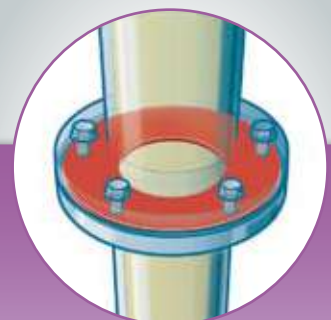
### Threadlocking

## Our Solution



### Pipe and Thread Sealing

## Our Solution



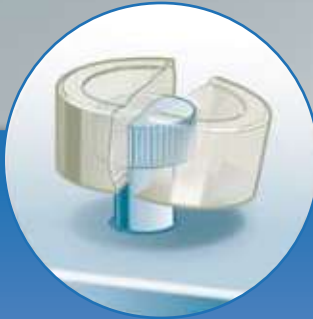
### Gasketing



## Bearings, Bushes, Shafts, Cylindrical Parts

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

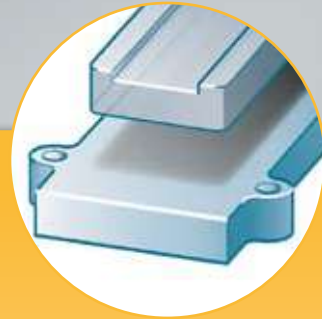
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## Joining Small Parts

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

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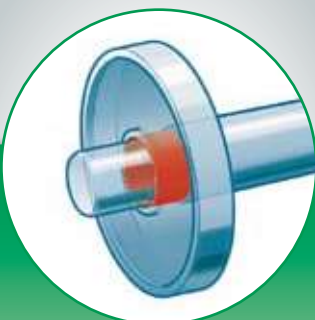


## Joining Large/ Structural Parts

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

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## Our Solution



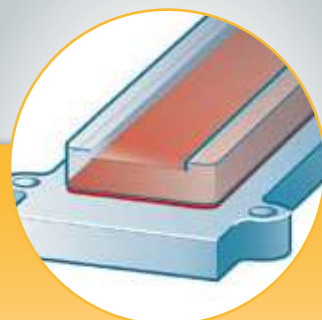
**Retaining**

## Our Solution



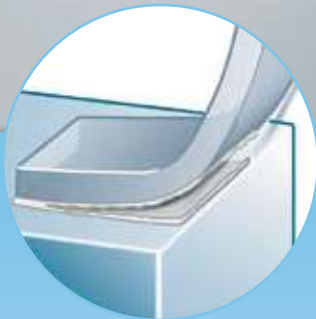
**Instant Bonding**

## Our Solution



**Structural Bonding**

# What's the Problem?



## Flexible Joining of Parts

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

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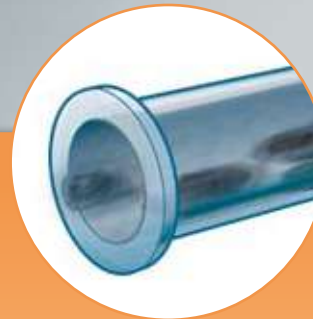


## Worn and Damaged Parts

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

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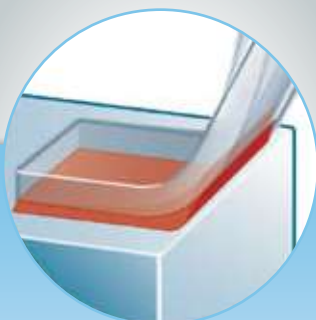
## Wear

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

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## Our Solution



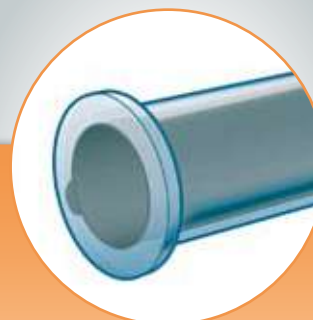
## Flexible Sealing and Bonding

## Our Solution



## Metal Filled Compounds

## Our Solution



## Wearing Compounds



## Cleaning Parts and Hands

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

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## Slow Adhesive/ Poor Adhesion

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

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## Lubrication

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

See also Emergency Repair Products on page 41

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## Our Solution



**Cleaning**

## Our Solution



**Surface Preparation**

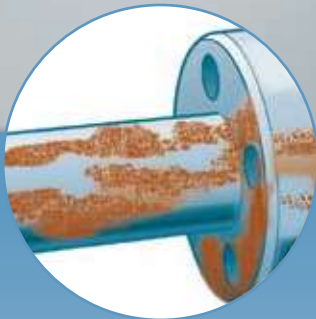
## Our Solution



**Lubrication**



# What's the Problem?



## Corroding Components

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

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## Emergency Repair

- Fill over-sized holes, smooth rough welds, repair non-structural defects
- Make a new O ring – in situ
- Emergency plugging and sealing of burst or leaking pipes

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## Dispensing Adhesives and Sealants

- Apply thick or thin products easily, cleanly, accurately and without waste
- Manual and semi-automatic options

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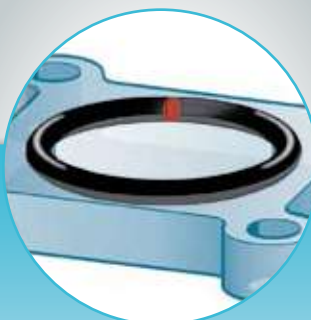
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## Our Solution



**Surface Treatment and Rust Prevention**

## Our Solution



**Emergency Repair Products**

## Our Solution



**Equipment**





## Best Practice

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

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## Pump & Centrifuge Gearbox & Shaft

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

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## Product Approvals

In adhesives technology and the general industry products with approvals play an important role. Within Europe there is a wide variety of approvals. Some of the most important ones are:

- Potable water WRC (UK)  
KTW (GER)
- Gas approval EN 751  
DVGW (GER)
- NSF approval (food, water etc)

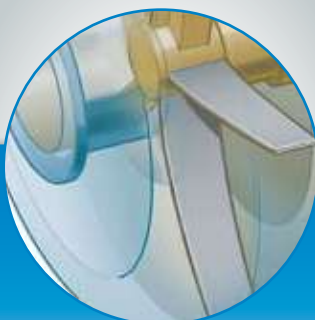
For further details on approvals please contact your local technical service.

## Our Solution



**Maintenance  
Workshop**

## Our Solution



**Repair Programmes**

## Index

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**Product Pack Sizes &  
Ordering Information**

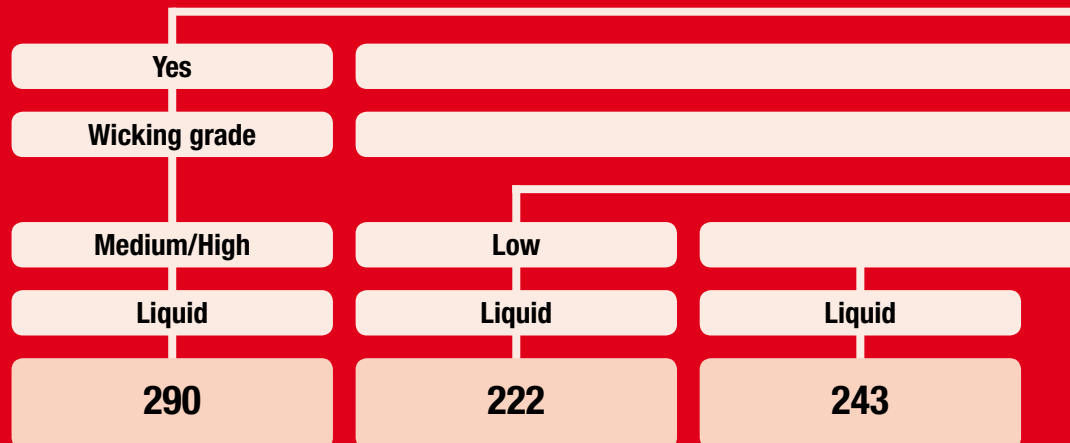
# Threadlocking

- Single-component
- Clean and easy to apply
- Resists vibration
- Locks and seals all threads
- Reduces inventory costs

## Handy Hints:

- Degrease, clean and dry surfaces prior to applying the adhesive – use Loctite® 7063 (see **Cleaning** on page 30/31)
- If the adhesive is applied below 5 °C, pre-treatment with Loctite® 7240 or Loctite® 7649 is advised (see **Surface Preparation** on page 32/33)
- For plastic part(s) please refer to **Instant Bonding** on page 18/19

## Are the metal parts already assembled?



## Solution

| Size of thread                         | Up to M 6            | Up to M 36           | Up to M 36           |
|--|----------------------|----------------------|----------------------|
| Functional strength after <sup>1</sup> | 3 hrs                | 6 hrs                | 2 hrs                |
| Breakaway torque M10 bolts             | 10 Nm                | 6 Nm                 | 20 Nm                |
| Operating temperature                  | -55 °C to +150 °C    | -55 °C to +150 °C    | -55 °C to +150 °C    |
| Pack sizes                             | 10 ml, 50 ml, 250 ml | 10 ml, 50 ml, 250 ml | 10 ml, 50 ml, 250 ml |
| Equipment <sup>2</sup>                 | 97001/98414          | 97001/98414          | 97001/98414          |

<sup>1</sup> Typical value at 22 °C

<sup>2</sup> For detailed information see pages 42/43



### Loctite® 290

- Ideal for locking preassembled fasteners, e.g. instrumentation screws, electrical connectors and set screws



### Loctite® 222

- Ideal for low-strength thread-locking of adjusting screws, countersunk head screws and set screws
- Good on low strength metals which could break during disassembly, e.g. aluminium or brass

P1 NSF Reg. No.: 123002



### Loctite® 243

- Effective on all types of metal threaded fasteners
- Prevents loosening on vibrating parts, e.g. pumps, motor mounting bolts, gear boxes or presses
- Permits disassembly with hand tools for servicing
- Good on oil-contaminated parts

P1 NSF Reg. No.: 123000



No

What strength do you require?

Medium

High

Semi-solid

Liquid

Liquid

Semi-solid

**248**

**2701**  
(improved 270)

**278**

**268**

Up to M 50

Up to M 20

Up to M 36

Up to M 50

6 hrs

6 hrs

3 hrs

24 hrs

19 Nm

38 Nm

30 Nm

25 Nm

-55 °C to +150 °C

-55 °C to +150 °C

-55 °C to +200 °C

-55 °C to +150 °C

9 g, 19 g stick

10 ml, 50 ml, 250 ml

50 ml, 250 ml

9 g, 19 g stick

n.a.

97001/98414

97001/98414

n.a.



## Loctite® 248

- Convenient to use
- Non-dripping, no migration
- Great for difficult to access areas – overhead, underneath or on fixed parts
- Good for all types of metal threaded fasteners
- Permits disassembly with hand tools for servicing

Certified to NSF/ANSI,  
Standard 61



## Loctite® 2701 (improved Loctite® 270)

- Suitable for all metal fasteners, including stainless steel as well as coated ones, e.g. zinc-coated
- Ideal for permanently locking studs on engine blocks and pump housings
- To be used if regular removal for maintenance is not required

Loctite® 270: P1 NSF Reg.

No.: 123006

Loctite® 2701: DVGW approval  
(EN 751-1): NG-5146AR0617



## Loctite® 278

- Oil tolerant
- Temperature resistant
- To be used if regular removal for maintenance is not required



## Loctite® 268

- Convenient to use
- Non-dripping, no migration
- Great for difficult to access areas – overhead, underneath or on fixed parts
- Good for all types of metal threaded fasteners
- To be used if regular removal for maintenance is not required, e.g. suspension bolts, mounts, cap bolts and studs



# Pipe and Thread Sealing

- Single-component
- Does not creep, shrink or block systems
- Replaces all tapes and hemp & paste
- Permits disassembly

## Handy Hints:

- Degrease, clean and dry surfaces prior to applying the adhesive – use Loctite® 7063 (See **Cleaning** on page 30/31)
- If the anaerobic sealant (Loctite® 542, 561, 572, 577 or 586) is applied below 5°C, pre-treatment with Loctite® 7240 or Loctite® 7649 is advised (See **Surface Preparation** on page 32/33)

## Are the parts metal or plastic?

Metal, plastic or a combination of both

Do you need to make post assembly adjustments?

Yes

No

Fine

Cord

Gel

Liquid

55

5331

542

**Solution**

| Substrate to be sealed    | Metal, plastic or both | Metal, plastic or both | Metal                |
|---------------------------|------------------------|------------------------|----------------------|
| Maximum pipe size         | Tested to 4"           | 3"                     | 3/4"                 |
| Disassembly strength      | Low                    | Low                    | Medium               |
| Instant low pressure seal | Yes (full pressure)    | Yes                    | No                   |
| Operating temperature     | -50 °C to +130 °C      | -50 °C to +150 °C      | -55 °C to +150 °C    |
| Pack sizes                | 50 m, 150 m cord       | 100 ml                 | 10 ml, 50 ml, 250 ml |
| Equipment <sup>1</sup>    | n.a.                   | n.a.                   | 97001 / 98414        |

<sup>1</sup> For detailed information see pages 42/43



### Loctite® 55

- Non curing, immediate, full pressure seal
- WRC listed for use with potable water up to 85 °C**  
**Meets BS 6920 KTW approval for cold and hot water**  
**DVGW approval (No. DV-5142AU 0166) for gas and water**  
**Tested in accordance with EN 751-2 Class Arp and DIN 30660**  
**Certified to ANSI/NSF Standard 61**



### Loctite® 5331

- Ideal for use on threaded plastic or plastic/metal fittings carrying hot or cold water e.g. industrial and agricultural plastic water pipe systems or drainage systems
- WRC approved for use with potable water up to 85 °C**  
**Meets BS 6920 DVGW approval (No. NG-5146AR0618) for gas and water**  
**Tested in accordance with EN 751-1**  
**P1 NSF Reg. No.: 123620**



### Loctite® 542

- Ideal for fine threads as used in hydraulic, pneumatic & general fittings
- DVGW approval (EN 751-1): NG-5146AR0855**





## Metal

### Are the threads fine or coarse?

#### Medium

#### Gel

**586**

#### Coarse

#### Gel

**577**

#### Gel

**572**

#### Semi-solid

**561**

Metal

2"

High

No

-55 °C to +150 °C

50 ml, 250 ml

n.a.

Metal

3"

Medium

Yes

-55 °C to +150 °C

50 ml, 250 ml

97002

Metal

3"

Medium

Yes

-55 °C to +150 °C

50 ml, 250 ml

97002

Metal

3"

Low

Yes

-55 °C to +150 °C

19 g stick

n.a.



#### Loctite® 586

- Slow curing, high strength sealant
- Especially suitable for copper and brass fittings



#### Loctite® 577

- General purpose sealant for all coarse metal threads
- Suitable for fast applications at low temperatures, e.g. outdoor plant maintenance

P1 NSF Reg. No.: 123001

DVGW approval (EN 751-1):

NG-5146AR0621

WRC Approval (BS 6920):

0302507



#### Loctite® 572

- Suitable for coarse metal threads
- Ideal where slow cure is required for adjusting the alignment of fittings



#### Loctite® 561

- Convenient to use
- Non-dripping, no migration
- Ideal for all coarse metal threads where disassembly is required
- Applicable in various industries, e.g. chemical processing, waste water treatment and automotive

Certified to NSF/ANSI,  
Standard 61

# Gasketing

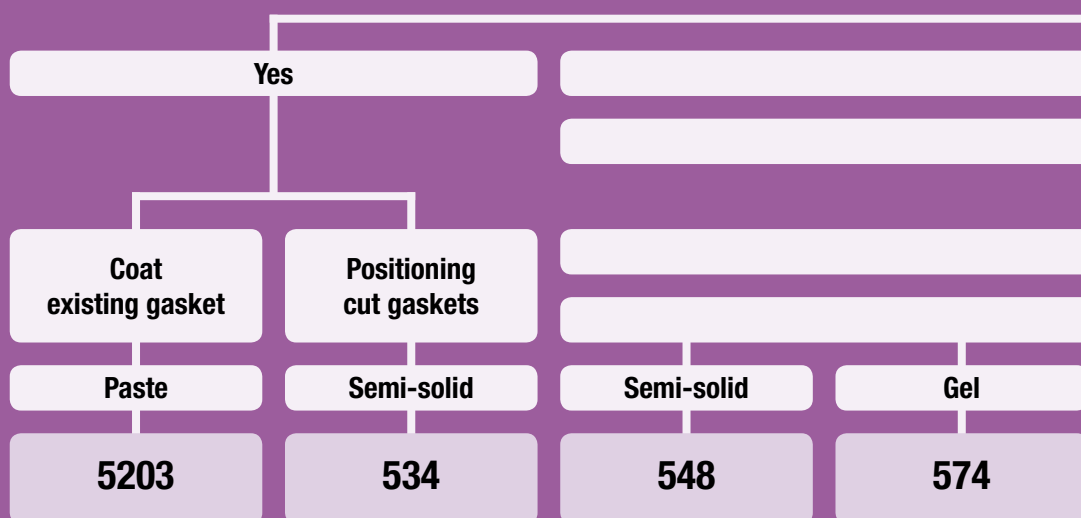
- Single-component
- Fills all voids – no fine surface finish needed
- No shimming – no need for re-torquing
- Excellent instant seal
- Resists high pressure when fully cured
- Permits disassembly

## Handy Hints:

- Remove residues of old gaskets with Loctite® 7200 Gasket Remover
- Degrease, clean and dry surfaces prior to applying the adhesive – use Loctite® 7063 (See **Cleaning** on page 30/31)
- If the anaerobic sealant is applied below 5 °C, pre-treatment with Loctite® 7240 or Loctite® 7649 is advised (See **Surface Preparation** on page 32/33)

## Solution

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



| Flange type             | Rigid                   | Rigid or Flexible | Rigid             | Rigid                           |
|-------------------------|-------------------------|-------------------|-------------------|---------------------------------|
| Cure method             | Anaerobic               | Anaerobic         | Anaerobic         | Anaerobic                       |
| Oil resistance          | Excellent               | Good              | Good              | Excellent                       |
| Water/glycol resistance | Moderate                | Good              | Good              | Excellent                       |
| Operating temperature   | -55 °C to +150 °C       | -55 °C to +150 °C | -55 °C to +150 °C | -55 °C to +150 °C               |
| Pack sizes              | 50 ml, 300 ml cartridge | 9 g, 19 g stick   | 9 g, 18 g stick   | 50 ml, 160 ml cartridge, 250 ml |
| Equipment <sup>1</sup>  | 97040, 97002            | n.a.              | n.a.              | 97002                           |

<sup>1</sup> For detailed information see pages 42/43



**Loctite® 5203**

- Permits easy disassembly of metal/metal sealed flanges
- Ideal for coating and re-using metal gaskets to improve sealing



**Loctite® 534**

- Ideal for holding pre-cut gaskets in place during assembly
- Applicable to all rubber, cork, paper and metal gaskets



**Loctite® 548**

- Ideal for all types of rigid iron, steel and aluminium flanges, e.g. compressor and motor housings



**Loctite® 574**

- Ideal for use on rigid metal parts, e.g. cast iron components and pump housings



No

What gap must the sealant fill?

Up to 0.25 mm

Greater than 0.25 mm

Metals

Plastic or combined plastic/metal parts

Paste

Paste

Paste

Paste

Paste

518

510

5910

5699

5970

| Rigid                                     | Rigid                              | Flexible                | Flexible           | Flexible           |
|---|------------------------------------|-------------------------|--------------------|--------------------|
| Anaerobic                                 | Anaerobic                          | Moisture                | Moisture           | Moisture           |
| Excellent                                 | Excellent                          | Excellent               | Good               | Excellent          |
| Excellent                                 | Excellent                          | Moderate                | Excellent          | Good               |
| -55 °C to +150 °C                         | -55 °C to +200 °C                  | -60 °C to + 200 °C      | -60 °C to + 200 °C | -60 °C to + 200 °C |
| 25 ml syringe,<br>50 ml, 300 ml cartridge | 50 ml, 250 ml, 300 ml<br>cartridge | 50 ml, 300 ml cartridge | 300 ml cartridge   | 300 ml cartridge   |
| 97040, 97002                              | 97040, 97002                       | 97040, 97002            | 97040, 97002       | 97040, 97002       |



**Loctite® 518**

- Ideal for use on rigid iron, steel and aluminium flanges

**P1 NSF Reg. No.: 123758**



**Loctite® 510**

- Ideal for use on rigid flanges where high temperature and chemical resistance is necessary

**P1 NSF Reg. No.: 123007**



**Loctite® 5910**

- Replacement for cork and paper cut gaskets on flanges and stamped sheet metal covers
- Ideal for use where high vibration or flexing occurs
- Can be used with plastic and painted parts
- Tack free after 20 min.



**Loctite® 5699**

- Ideal for sealing all types of flanges including stamped sheet metal where water glycol resistance is required
- Tack free after 10 min.

**P1 NSF Reg. No.: 122998**



**Loctite® 5970**

- Replacement for cork and paper cut gaskets on flanges and stamped sheet metal covers
- Ideal for use where high vibration or flexing occurs
- Can be used with plastic and painted parts
- Tack free after 25 min.



# Retaining

- Single-component
- Fills all voids – 100% contact
- Prevents corrosion
- Even stress distribution across the joint
- Suitable for high loads
- Eliminates fretting

## Handy Hints:

- Degrease, clean and dry surfaces prior to applying the adhesive – use Loctite® 7063 (See **Cleaning** on page 30/31)
- If the adhesive is applied below 5 °C, pre-treatment with Loctite® 7240 or Loctite® 7649 is advised (See **Surface Preparation** on page 32/33)
- Use in conjunction with existing designs to increase their strength

## Is the assembly very loose or badly worn?

Yes

Disassembly required

Gel

Liquid

Semi-solid

## Solution

**660**

(with Activator 7240)

**641**

**668**

|                                      |                   |                      |                   |
|--------------------------------------|-------------------|----------------------|-------------------|
| Diametrical clearance                | Up to 0.5 mm      | Up to 0.1 mm         | Up to 0.15 mm     |
| Strength required                    | High              | Medium               | Medium            |
| Handling strength after <sup>1</sup> | 20 min.           | 30 min.              | 30 min.           |
| Operating temperature                | -55 °C to +150 °C | -55 °C to +150 °C    | -55 °C to +150 °C |
| Pack sizes                           | 50 ml             | 10 ml, 50 ml, 250 ml | 9 g, 19 g stick   |
| Equipment <sup>2</sup>               | n.a.              | 97001/98414          | n.a.              |

<sup>1</sup> At room temperature on steel joints.

<sup>2</sup> For detailed information see pages 42/43

\* After heat cure 180 °C for 30 min.



**Loctite® 660**  
(use with Activator Loctite® 7240)

- Ideal for repairing worn coaxial parts without remachining
- Enables re-use of worn bearing seats, keys, splines or tapers
- Suitable for retaining shims

P1 NSF Reg. No.: 123704



**Loctite® 641**

- Ideal for parts that need subsequent dismantling, i.e. retention of bearings onto shafts and into housings



**Loctite® 668**

- Convenient to use
- Non-dripping, no migration
- Great for difficult to access areas – overhead, underneath or on fixed parts
- Ideal for all kinds of medium strength retaining applications





No

No disassembly required

What operating temperature is required?

Up to 230 °C

Up to 175 °C

Up to 150 °C

Gap ≤ 0.25 mm

Gap ≤ 0.1 mm

Liquid

Liquid

Liquid

Liquid

**620**

**648**

**638**

**603**

(improved 601)

Up to 0.2 mm

Up to 0.15 mm

Up to 0.25 mm

Up to 0.1 mm

High

High

High

High

60 min.

5 min.

8 min.

8 min.

-55 °C to +230 °C \*

-55 °C to +175 °C

-55 °C to +150 °C

-55 °C to +150 °C

50 ml, 250 ml

10 ml, 50 ml, 250 ml

10 ml, 50 ml, 250 ml

10 ml, 50 ml, 250 ml

97001/98414

97001/98414

97001/98414

97001/98414



## Loctite® 620

- High temperature resistance
- Ideal for retaining pins in radiator assemblies, sleeves into pump housings and bearings in auto transmissions

DVGW approval (EN 751-1):  
NG-5146AR0622



## Loctite® 648

- Increased temperature resistance
- Ideal for retaining of parts with a clearance or interference fit, i.e. retaining bushes, bearings, seals, fans, and liners

WRC Approval (BS 6920):  
0311505



## Loctite® 638

- Best resistance to dynamic, axial and radial loads
- Ideal for shafts, gears, pulleys and similar cylindrical parts

P1 NSF Reg. No.: 123010

DVGW Approval (EN 751-1):  
NG-5146AR0619

WRC Approval (BS 6920):  
0511518

KTW Approval for Potable Water



## Loctite® 603 (improved Loctite® 601)

- Ideal for retaining close fitting cylindrical parts
- For use on cylindrical fitting parts where thorough degreasing is not possible
- Approved for use on bearings

P1 NSF Reg. No.: 123003

WRC Approval (BS 6920):  
0412505

# Instant Bonding

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

## Handy Hints:

- In combination with Loctite® Instant Adhesives:
  - a) to improve adhesion of difficult to bond materials use Primer Loctite® 7239, 770, 7452, 7457
  - b) to increase cure speed use Activator Loctite® 7458, 7452 or 7457 (See **Surface Preparation** on page 32/33)
- For difficult to bond plastics (PE and PP) see also Loctite® 3030 on page 20/21

## Are you bonding “difficult to bond” rubber or plastic? e.g. PE, PP, PTFE, TVP

Yes

Do any of the following apply?

If one or more apply

Yes

## Solution

**406**

(with Primer 7239)

**454**

**480**

(black)

**435**

(transparent)

| Fixture time           | 2–10 sec.        | 5–10 sec.         | 20–50 sec.        | 10–20 sec.        |
|------------------------|------------------|-------------------|-------------------|-------------------|
| Viscosity              | 20 mPa·s         | Gel               | 150 mPa·s         | 200 mPa·s         |
| Operating temperature  | -40 °C to +80 °C | -40 °C to +100 °C | -40 °C to +100 °C | -40 °C to +100 °C |
| Pack sizes             | 20 g, 500 g      | 3 g, 20 g, 300 g  | 20 g, 500 g       | 20 g, 500 g       |
| Equipment <sup>1</sup> | 98548            | 98666             | 98548             | 98548             |

<sup>1</sup> For detailed information see pages 42/43/44



### Loctite® 406

- Rapid bonding of rubbers, including EPDM, plastics and elastomers
- Loctite® 7239 Polyolefin Primer improves bonding



### Loctite® 454

- General purpose gel
- Bonding metals, composite materials, wood, cork, foam, leather, card, paper, unglazed ceramics
- Ideal for use on vertical or overhead surfaces

P1 NSF Reg. No.: 123009



### Loctite® 480

- Ideal for bonding metal to metal, to rubber or magnets
- For applications where high peel strength is required and/or shock loads are present
- Good resistance in humid and/or chemical environments



### Loctite® 435

- Bonding of plastics, rubber, metals, porous and absorbent substrates and acidic surfaces
- High resistance to impact and shock loads, high peel strength
- Good resistance in humid and/or chemical environments



No

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

No

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

No

**4850**

**4062**

**401**

**431**

**4204**

| 3–10 sec.        | 2–5 sec.         | 3–10 sec.         | 5–10 sec.        | 20–50 sec.        |
|------------------|------------------|-------------------|------------------|-------------------|
| 400 mPa-s        | 2 mPa-s          | 90 mPa-s          | 1,000 mPa-s      | 4,000 mPa-s       |
| -40 °C to +70 °C | -40 °C to +80 °C | -40 °C to +80 °C  | -40 °C to +80 °C | -40 °C to +120 °C |
| 20 g, 500 g      | 20 g, 500 g      | 20 g, 50 g, 500 g | 20 g, 500 g      | 20 g, 500 g       |
| 98548            | 98548            | 98548             | 98548            | 98548             |



### Loctite® 4850

- For bonding flexible materials and components
- Also for porous and absorbent substrates and acidic surfaces



### Loctite® 4062

- Extremely fast fixture speed
- Ideal for very fast bonding of plastics and rubbers
- Also for difficult to bond materials: PE, PP, PTFE, thermoplastic or silicone rubbers
- Combine with a Loctite® Polyolefin Primer



### Loctite® 401

- General purpose
- Also for porous substrates such as wood, paper, leather, cork and fabric
- For acidic surfaces such as chromated or galvanized surfaces

P1 NSF Reg. No.: 123011



### Loctite® 431

- General purpose
- Also for porous substrates such as wood, paper, leather, cork and fabric
- For acidic surfaces such as chromated or galvanized surfaces



### Loctite® 4204

- Excellent hot strength and heat aging capabilities
- Good resistance in humid and/or chemical environments
- Good resistance to impact, shock and peel loads



# Structural Bonding

- Two-component
- Bonds a wide variety of materials, e.g. wood, metals, hard plastics and glass
- Provides tough and resilient bonds
- Yields high shear and peel strength

## What product performance is required?

### Handy Hints:

- Degrease, clean and dry surfaces prior to applying the adhesive – use Loctite® 7063 (See **Cleaning** on page 30/31)
- If the adhesive cures slowly, clamping during cure is advised

**Bonding of PP, PE or a combination of both**

**Bonding of glass to metal**

**General purpose**

### Solution

**3030**

**319/7649**

**3421 A&B**

| Description            | Acrylic              | Acrylic (no mix)        | Epoxy   |
|------------------------|----------------------|-------------------------|---|
| Working life           | 3 min.               | –                       | 180 min.  |
| Fixture time           | <10 min.             | 1 min.                  | 240 min.  |
| Colour                 | Transparent amber    | Light amber             | Clear amber                                     |
| Viscosity              | 15 Pa·s              | 2.75 Pa·s               | 40 Pa·s   |
| Operating temperature  | up to 100 °C         | -55 °C to +120 °C       | -55 °C to +120 °C                               |
| Pack sizes             | 35 ml dual cartridge | 0.5 ml, 5 g / 4 ml kits | 50 ml, 200 ml, 400 ml dual cartridges, 1 kg can |
| Equipment <sup>1</sup> | 96001, 97042, 98463  | n.a.                    | 96001, 97042 / 96003, 983437 / 983438, 983439   |

<sup>1</sup> For detailed information see pages 42/43



#### Loctite® 3030

- Ideal for bonding HDPE, LDPE and PP
- Good chemical resistance
- Used e.g. to assemble small appliances, signs and displays, battery cases, speaker components, liquid tanks and storage bins



#### Loctite® 319/7649

- Ideal for bonding metal to glass
- Good resistance in humid environment
- Good temperature resistance



#### Loctite® 3421 A&B

- Extended working life
- Excellent humidity resistance
- For bonding of large surfaces
- Ideal for bonding metals, plastics and most other surfaces which will be subjected to high humidity environments





## Five-minute

## Toughened

## High temperature

**330 / 7388**  
MULTI-BOND®

**3430 A&B**

**3450 A&B**

**9466 A&B**

**9492 A&B**

| Acrylic (no mix)                       | Epoxy  | Epoxy              | Epoxy   | Epoxy  |
|--|--|--------------------|---|--|
| –                                      | 4 min.   | 4 min.             | 60 min.                                       | 15 min.                                      |
| 5 min.                                 | 12 min.  | 12 min.            | 180 min.                                      | 75 min.                                      |
| Light amber                            | Ultra clear  | Grey               | Off-white                                     | White  |
| 67.5 Pa-s                              | 25 Pa-s  | 35 Pa-s            | 30 Pa-s                                       | 30 Pa-s                                      |
| -55 °C to +100 °C                      | -55 °C to +100 °C  | -55 °C to +100 °C  | -55 °C to +120 °C                             | -55 °C to +180 °C                            |
| 50 ml / 40 ml kit,<br>315 ml cartridge | 24 ml twin syringe<br>50 ml, 200 ml, 400 ml<br>dual cartridges | 25 ml twin syringe | 50 ml, 400 ml<br>dual cartridges,<br>1 kg can | 50 ml, 400 ml<br>dual cartridges<br>1 kg can |
| 97002                                  | 96001, 97042 / 96003,<br>983437 / 983438, 983439               | n.a.               | 96001, 97042 / 983438,<br>983439              | 96001, 97042 / 983438,<br>983439             |



### Loctite® 330/7388

- Toughened adhesive
- Fast curing
- Good impact resistance
- Ideal for bonding dissimilar substrates, including plastics, like PVC, phenolic and acrylic

**Loctite® 330:**  
**P1 NSF Reg. No.: 123005**



### Loctite® 3430 A&B

- Ultra clear
- Toughened
- Water resistant
- Ideal for bonding glass, decorative panels and displays as well as general repair applications



### Loctite® 3450 A&B

- Grindable
- High strength
- Ideal for bonding and filling damaged components



### Loctite® 9466 A&B

- Extended working life
- High strength
- Toughened
- Ideal for bonding a wide variety of substrates like metals, ceramic and most plastics



### Loctite® 9492 A&B

- Excellent chemical resistance
- High temperature resistant
- Good hot strength
- For bonding and potting a wide variety of substrates exposed to higher temperatures e.g. heaters and electronic components

# Flexible Sealing and Bonding – Silicone

- Withstands impact shock and bending
- Resists thermal expansion and contraction as well as vibration
- Has very good gap fill
- Wide temperature range
- Good weathering resistance

Do you need a fast fixture / fast cure adhesive?

Yes

Do you seal electrical items?

**Solution**

**5610 A&B**

**5145**

|                        |                             |                       |
|------------------------|-----------------------------|-----------------------|
| Cure method            | Two parts                   | Moisture              |
| Skin over time         | 5–7 min.                    | 70 min.               |
| Viscosity              | Paste                       | Paste                 |
| Especially for         | Fast cure sealing / bonding | Electrical components |
| Colour variations      | Black                       | Translucent           |
| Operating temperature  | -55 °C to 180 °C            | -55 °C to 180 °C      |
| Pack sizes             | 400 ml                      | 40 ml, 300 ml         |
| Equipment <sup>1</sup> | 983438, 983439              | 97040, 97002          |

<sup>1</sup> For detailed information see pages 42/43

\* 5366 – Clear  
5367 – White  
5368 – Black



**Loctite® 5610 A&B**

- Fast curing
- High adhesion 2-part silicone
- Unlimited depth of cure
- Low odour
- Ideal for bonding and sealing metal, glass, ceramics, composites, most plastics and elastomers



**Loctite® 5145**

- Non-corrosive (neutral cure)
- Electrical grade
- Low odour
- Ideal for bonding, sealing and protecting electrical and electronic components



No

Do you require high temperature resistance?

Up to 250 °C

Up to 350 °C

5366 / 5367 / 5368

5398

5399

| Moisture                | Moisture          | Moisture            |
|-------------------------|-------------------|---------------------|
| 5 min.                  | 8–10 min.         | 5 min.              |
| Paste                   | Liquid            | Paste               |
| Glass                   | Sealing / Potting | Heat source sealing |
| Clear / White / Black * | Red               | Red                 |
| -55 °C to 250 °C        | -55 °C to 350 °C  | -55 °C to 350 °C    |
| 310 ml                  | 310 ml            | 310 ml              |
| 97040, 97002            | 97040, 97002      | 97040, 97002        |



**Loctite® 5366 / 5367 / 5368**

- Ideal for bonding, sealing and protecting components subjected to vibration or relative movement
- Suitable for glass, metal, ceramics, composites, and most plastics



**Loctite® 5398**

- High temperature resistant
- Ideal for sealing heat exchangers, steam circuits, water heaters, turbines and pumps
- For protection and insulation of electrical boxes



**Loctite® 5399**

- High temperature resistant
- Ideal for bonding and sealing glass, metal, and ceramics, where temperature can reach 350 °C, e.g. sealing of stove flues/ chimneys, industrial ovens and electro-appliances

# Flexible Sealing and Bonding – MS Polymer

- Withstands impact shock and bending
- Resists thermal expansion as well as vibration
- Has very good gap fill
- Resistant to weathering and UV radiation
- Freshly cured MS can be over-painted
- Free of isocyanate and silicone

What main function are you looking for?

Elastic Sealing

General purpose

High / medium resistance

Self spreading

Solution

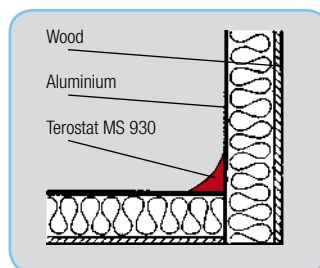
Terostat MS 930

Terostat 9120

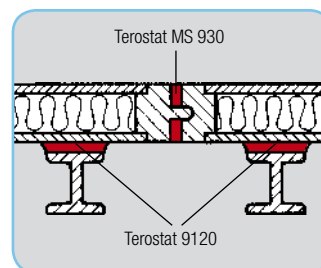
Terostat MS 931

|                        |                    |                          |                  |
|------------------------|--------------------|--------------------------|------------------|
| Operating temperature  | -50 °C to 80 °C    | -40 °C to 100 °C         | -40 °C to 100 °C |
| Cure method            | Moisture           | Moisture                 | Moisture         |
| Skin over time         | 25 to 40 min.      | 10 to 15 min.            | 10 to 20 min.    |
| Viscosity              | Paste              | Paste                    | Liquid           |
| Characteristic         | General purpose    | High / medium resistance | Self spreading   |
| Colour                 | White, Grey, Black | White, Grey, Black       | White            |
| Pack sizes             | 310 ml, 570 ml     | 310 ml, 570 ml           | 310 ml           |
| Equipment <sup>1</sup> | 97040 / 97002      | 97040 / 97002            | 97040 / 97002    |

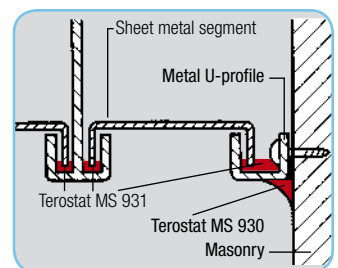
<sup>1</sup> For detailed information see pages 42/43



Sealing of sandwich elements in cold stores



Sealing/bonding of side panels to load-bearing structures



Sealing of clean-room ceilings

## Terostat MS 930

- Can be applied as bead or even sprayed using suitable equipment
- Vibration absorbing properties
- High elongation
- Spray-on seam sealing for large surface applications

## Terostat 9120

- Elastic adhesive/ sealant
- High sag resistance
- High / medium resistance
- Easy smoothing
- High position tack
- Sealing and bonding of parts in railway carriage and container manufacture

## Terostat MS 931

- Apply by pouring and extruding
- Self spreading
- Soft elastic after full curing
- Fast curing
- Sprayable for large surface coating
- Fluid seal in frame profiles of modular clean room ceilings





### Elastic bonding

General purpose

Rapid RTV curing

High modulus

Two component  
rapid cure

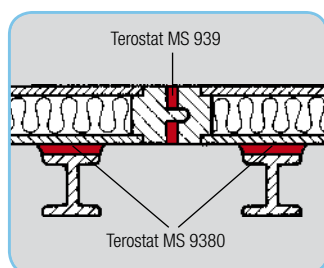
**Terostat MS 939**

**Terostat MS 937**

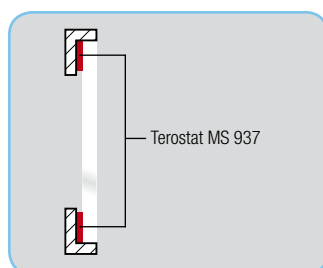
**Terostat 9220**

**Terostat MS 9399**

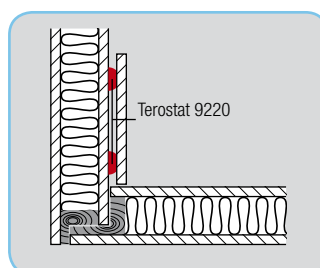
|                               |                    |                  |                         |
|-------------------------------|--------------------|------------------|-------------------------|
| -40 °C to 100 °C              | -40 °C to 100 °C   | -40 °C to 100 °C | -40 °C to 100 °C        |
| Moisture                      | Moisture           | Moisture         | Two parts               |
| 10 min.                       | 10 to 15 min.      | 5 to 10 min.     | Open time: 30 min.      |
| Paste                         | Paste              | Paste            | Paste                   |
| General purpose               | Rapid curing       | High modulus     | Curing without humidity |
| White, Off-White, Grey, Black | White, Grey, Black | Black            | White, Black            |
| 310 ml                        | 310 ml             | 310 ml           | 2x 200 ml (A+B)         |
| 97040 / 97002                 | 97040 / 97002      | 97040 / 97002    | 983439                  |



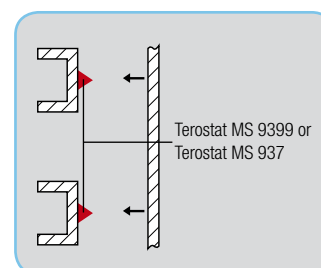
Bonding/sealing of side panels to/on load-bearing structures



Bonding of basement windows into metal frames



Bonding of anti-ram rails in container manufacture and in vehicle superstructures



Bonding of side panels, roofing or floor elements to load-bearing structures

#### Terostat MS 939

- High position tack
- Non sagging
- High elongation
- Elastic bonding of metals and plastics

#### Terostat MS 937

- Fast curing
- Non sagging
- Elastic bonding of metals and plastics

#### Terostat 9220

- High modulus
- Fast skin formation
- Non sagging
- High position tack
- Elastic bonding of metals or painted substrates

#### Terostat MS 9399

- Full depth cure in 24 hours
- High viscosity
- High position tack
- Elastic bonding in the construction of containers, caravans etc.

# Metal-filled Compounds

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

## Repair or rebuild metal damaged parts?

### Steel

#### Putty

#### Pourable

#### Fast cure

### Solution

**3471 A&B**  
(Metal Set S1)

**3472 A&B**  
(Metal Set S2)

**3473 A&B**  
(Metal Set S3)

| Description                   | Epoxy                | Epoxy                | Epoxy                |
|-------------------------------|----------------------|----------------------|----------------------|
| Mix ratio by volume / weight: | 1:1                  | 1:1                  | 1:1                  |
| Working life                  | 45 min.              | 45 min.              | 6 min.               |
| Fixture time                  | 180 min.             | 180 min.             | 15 min.              |
| Viscosity                     | Putty                | Liquid               | Putty                |
| Shear strength (GBMS)         | 20 N/mm <sup>2</sup> | 25 N/mm <sup>2</sup> | 20 N/mm <sup>2</sup> |
| Compressive strength          | 70 N/mm <sup>2</sup> | 70 N/mm <sup>2</sup> | 60 N/mm <sup>2</sup> |
| Operating temperature         | -20 °C to 120 °C     | -20 °C to 120 °C     | -20 °C to 120 °C     |
| Pack sizes                    | 500 g tub kit        | 500 g tub kit        | 500 g tub kit        |

#### Loctite® 3463 Steel filled kneadable stick

- Working time 3 minutes
- Sets in 10 minutes

For further information See page 41



#### Loctite® Hysol® 3471 A&B

- Steel putty
- Low shrinkage on cure (0.1 %)
- For repairing and rebuilding worn metal parts
- Ideal for repairing pipes and castings as well as cracks in housings and machine parts



#### Loctite® Hysol® 3472 A&B

- Steel liquid
- Low shrinkage on cure (0.1 %)
- Self-levelling
- For repairing and rebuilding worn metal parts
- Ideal for making moulds, models, tools and fixtures



#### Loctite® Hysol® 3473 A&B

- Steel putty
- Fast curing
- For emergency repairing and rebuilding worn metal parts to minimise downtime
- Ideal for repairing pipes and castings as well as cracks in housings and machine parts



## Aluminium

## Metallic pieces under high compression

## Metallic pieces under friction

### Multi purpose

### High temperature resistant

### Putty

### Wear resistant

### 3475 A&B (Metal Set A1)

### 3479 A&B (Metal Set HTA)

### 3478 A&B (Superior Metal)

### 3474 A&B (Metal Set M)

| Epoxy                | Epoxy                | Epoxy                 | Epoxy                |
|----------------------|----------------------|-----------------------|----------------------|
| 1:1                  | 1:1                  | 4:1                   | 1:1                  |
| 45 min.              | 40 min.              | 20 min.               | 45 min.              |
| 180 min.             | 150 min.             | 120 min.              | 180 min.             |
| Putty                | Putty                | Putty                 | Putty                |
| 20 N/mm <sup>2</sup> | 20 N/mm <sup>2</sup> | 17 N/mm <sup>2</sup>  | 20 N/mm <sup>2</sup> |
| 70 N/mm <sup>2</sup> | 90 N/mm <sup>2</sup> | 125 N/mm <sup>2</sup> | 70 N/mm <sup>2</sup> |
| -20 °C to 120 °C     | -20 °C to 190 °C     | -30 °C to 120 °C      | -20 °C to 120 °C     |
| 500 g tub kit        | 500 g tub kit        | 453 g tub kit         | 500 g tub kit        |



#### Loctite® Hysol® 3475 A&B

- Aluminium putty
- Low shrinkage on cure (0.1 %)
- For repairing and rebuilding worn metal parts
- Ideal for repairing pipes and castings as well as cracks in housings and machine parts



#### Loctite® Hysol® 3479 A&B

- Aluminium putty
- Low shrinkage on cure (0.2 %)
- For repairing and rebuilding worn metal parts in high operating temperature applications
- Ideal for repairing pipes and castings as well as cracks in housings and machine parts



#### Loctite® Hysol® 3478 A&B

- Steel putty
- Low shrinkage on cure (0.1 %)
- High compression strength
- Good hot strength
- Ideal for renewing surfaces subjected to compression, thrust, impact and harsh environments



#### Loctite® Hysol® 3474 A&B

- Steel putty
- Self-lubricating
- High wear resistant
- Forms a self-lubricating surface to reduce sliding wear on moving parts
- Ideal for repairing metallic surfaces under friction

# Wearing Compounds

## Protect against particle abrasion or chemical attack?

### Handy Hints:

- Use Loctite® Nordbak® 7227 or 7228 as primer / primary coat to ensure best adhesion of Loctite® Nordbak® 7218, 7230, 7219, 7226, 7229 and 7222

### Solution

| Coarse particle              |  |                                   |
|------------------------------|--|-----------------------------------|
| Resists abrasion & corrosion | Resists abrasion & corrosion at high temperature | Resists impact & sliding abrasion |
| Wearing Compound             | High Temperature Wearing Compound                | High Impact Wearing Compound      |
| 7218                         | 7230   | 7219                              |

|                             |                   |                   |                   |
|-----------------------------|-------------------|-------------------|-------------------|
| Colour                      | Grey              | Grey              | Grey              |
| Temperature range           | -30 °C to +120 °C | -30 °C to +230 °C | -30 °C to +120 °C |
| Mix ratio by volume         | 2:1               | 4:1               | 2:1               |
| Working time                | 30 min.           | 30 min.           | 30 min.           |
| Cure time                   | 7 hrs             | 7+2 hrs at 150 °C | 6 hrs             |
| Recommended layer thickness | min. 6mm          | min. 6 mm         | min. 6 mm         |
| Pack sizes                  | 1 kg/10 kg Kit    | 10 kg kit         | 1 kg/10 kg Kit    |

Badly worn surfaces are rebuilt using **Loctite® Nordbak® 7222 Wear Resistant Putty** or **Loctite® Nordbak® 7232 High Temperature Wear Resistant Putty**, prior to applying protective Loctite® Nordbak® composite coatings.



#### Loctite® Nordbak® 7218

- Trowelable ceramic filled epoxy
- Ideal for protecting, rebuilding and repairing high wear areas of processing equipment
- Suitable for overhead applications and irregular surfaces



#### Loctite® Nordbak® 7230

- Ceramic filled epoxy
- Ideal for protecting, rebuilding and repairing high wear areas of processing equipment
- Requires post curing for ultimate performance and temperature resistance



#### Loctite® Nordbak® 7219

- Rubber modified ceramic filled epoxy
- Ideal for areas exposed to abrasion and impact
- Suitable for overhead applications and irregular surfaces





## Fine particle

## Chemical attack

Resists fine particle abrasion

Resists fine particle abrasion at high temperature

Brushable protective coating

Brushable protective coating at high temperature

Chemical resistant brushable coating

Pneu-Wear

High Temperature Pneu-Wear

Brushable Ceramic

High Temperature Brushable Ceramic

Chemical Resistant Coating

**7226**

**7229**

**7227 / 7228**

**7234**

**7221**

| Grey              | Grey              | Grey / White      | Grey              | Grey             |
|-------------------|-------------------|-------------------|-------------------|------------------|
| -30 °C to +120 °C | -30 °C to +230 °C | -30 °C to +95 °C  | -30 °C to +205 °C | -30 °C to +65 °C |
| 4:1               | 4:1               | 2.75:1 / 2.8:1    | 2.6:1             | 2.3:1            |
| 30 min.           | 30 min.           | 30 min. / 15 min. | 30 min.           | 20 min.          |
| 6 hrs             | 6+2 hrs at 150 °C | 6 hrs / 5 hrs     | 8+3 hrs at 150 °C | 16 hrs           |
| min. 6 mm         | min. 6 mm         | min. 0.5 mm       | min. 0.5 mm       | min. 0.5 mm      |
| 1 kg/10 kg Kit    | 10 kg kit         | 1 kg kit          | 1 kg kit          | 5.4 kg kit       |



### Loctite® Nordbak® 7226

- Small ceramics beads and silicon carbide filled epoxy
- Ideal for protecting processing equipment from fine particle abrasion
- Suitable for providing abrasion resistance on overhead and vertical surfaces

### Loctite® Nordbak® 7229

- Trowelable small ceramics bead filled epoxy
- Ideal for protecting equipment from fine particle abrasion in dry, high temperature applications
- Requires post curing for ultimate performance and temperature resistance

### Loctite® Nordbak® 7227/7228

- Ultra-smooth ceramic reinforced epoxy
- Provides a high gloss, low friction coating to protect against turbulence and abrasion
- Seals and protects equipment from corrosion and wear

### Loctite® Nordbak® 7234

- Brushable two-part epoxy
- Ideal for protecting against turbulence and abrasion under extreme heat
- Requires post curing for ultimate performance and temperature resistance

### Loctite® Nordbak® 7221

- Protects equipment against extreme chemical attack and corrosion
- Forms a smooth, glossy, low-friction finish
- Ideal for protecting against turbulence and cavitation
- Can be applied by brush or pressure sprayed

# Cleaning

- Cleans components prior to using Loctite® adhesives/ sealants
- Cleans and degreases worktops and parts
- Removes cured sealant residue
- The hand cleaners are effective, gentle and biodegradable

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

General cleaner

Hand cleaner

General purpose

For ink, paint or resin on hands

Solution

7840

7850

7855

| Description | Cleaner & degreaser                      | Hand cleaner                      | Hand cleaner                         |
|-------------|--|-----------------------------------|--------------------------------------|
| Pack sizes  | 750 ml trigger spray, 5 l can, 20 l drum | 400 ml bottle, 3 l pump dispenser | 400 ml bottle, 1.75 l pump dispenser |



**Loctite® 7840  
Cleaner & degreaser**

- Biodegradable
- Solvent free, non-toxic, non-flammable
- Diluted with water
- Removes grease, oil, cutting fluids and workshop grime



**Loctite® 7850  
Hand cleaner**

- Natural extract base
- Free from mineral oils
- Biodegradable
- Contains premium skin conditioners
- Works with or without water
- Removes ground-in dirt, grease, grime, and oil



**Loctite® 7855  
Hand cleaner**

- Biodegradable
- Non toxic
- Removes paint, resin and adhesives



## Parts, machines and surface cleaners

### General purpose

**7063**

Cleaner & degreaser

400 ml aerosol, pump,  
10l can

### Plastic parts

**7070**

Cleaner & degreaser

400 ml aerosol

### Gasket remover

**7200**

Gasket remover

400 ml aerosol

### Electrical contact

**7039**

Contact cleaner spray

400 ml aerosol



#### Loctite® 7063 Cleaner & degreaser

- Solvent based general parts cleaner
- Leaves no residue
- Ideal for use prior to adhesive bonding and sealing applications
- Removes most greases, oils, lubrication fluids, metal cuttings and fines from all surfaces



#### Loctite® 7070 Cleaner & degreaser

- Solvent based general parts cleaner
- Usable as spray or in immersion cleaning process at room temperature
- Removes special heavy oils
- For most plastic parts without the risk of stress cracks



#### Loctite® 7200 Gasket remover

- Removes cured gasket sealants and traditional gaskets in 10 to 15 minutes
- Minimal scraping
- Usable on most types of surfaces



#### Loctite® 7039 Contact cleaner spray

- For cleaning electrical contacts exposed to moisture or other contaminations
- Does not affect insulating varnishes
- Typical application: Cleaning of electrical contacts, relays, switchgear etc.



# Surface Preparation

- Activators accelerate cure even at low temperatures
- Primers improve adhesion to non-wetting surfaces

What is your application?

Instant Bonding

What do you want to do?

Improve adhesion

General purpose

Solution

7239

770

7458

| Description | Primer     | Primer      | Activator  |
|-------------|------------|-------------|------------|
| Colour      | Colourless | Colourless  | Colourless |
| Pack Size   | 4 ml       | 10 g, 300 g | 500 ml     |



**Loctite® 7239 – Plastic Primer**

- General purpose
- Suitable for use on all industrial plastics
- Improves the adhesion of Instant Adhesives on polyolefins and other low surface energy plastics



**Loctite® 770 – Polyolefin Primer**

- Only for difficult to bond plastics
- Provides (best) adhesion of Instant Adhesives to polyolefins and other low surface energy plastics



**Loctite® 7458**

- General purpose
- For all substrates
- Good on part life – can be pre- or post-applied
- Low odour
- Minimizes post cure white discolouring
- Provides good aesthetic appearance of the bondline





Threadlocking, Pipe and Thread Sealing,  
Gasketing, Retaining

Accelerate

What activator is preferred?

Best cosmetic  
appearance

Ideal for stress cracking  
sensitive plastics

Solvent-based

Solvent-free

7452

7457

7649

7240

Activator

Transparent, light-amber

500 ml, 18 ml

Activator

Colourless

150 ml, 18 ml

Activator

Transparent, green

150 ml, 500 ml

Activator

Blue-green

90 ml



#### Loctite® 7452

- Cures excess adhesive
- Provides excellent cosmetic appearance avoiding white discolouring of Instant Adhesive
- Not recommended on stress cracking sensitive plastics



#### Loctite® 7457

- Good on part life – can be pre- or post-applied
- Recommended for use on stress cracking sensitive plastics



#### Loctite® 7649

- Increases cure speed of anaerobic products
- Especially recommended for applications with passive metals, such as stainless steel and plated or passivated surfaces, or inactive surfaces
- For large bond gaps

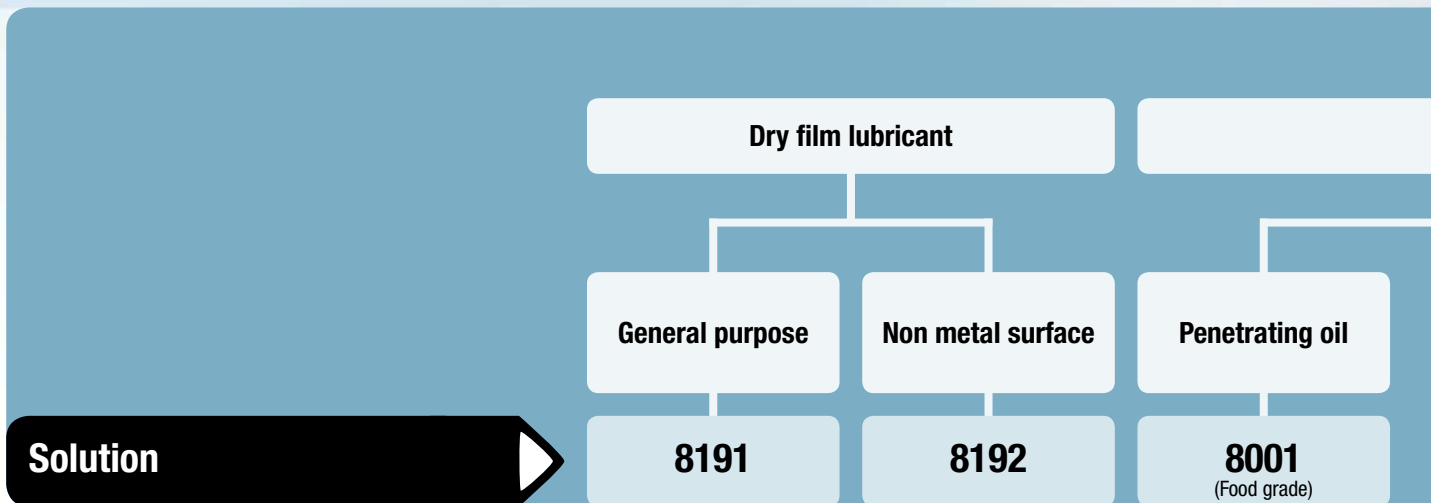


#### Loctite® 7240

- Increases cure speed on passive and inactive surfaces
- Ensures product cure with large bond gaps
- Recommended when cure temperature is low (<5 °C)

# Lubrication – Dry Film and Oils

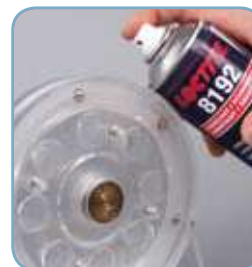
- Prevents seizing and galling during assembly and operation
- Inhibits corrosion and oxidation in chemically and thermally aggressive environments
- Penetrates and frees corroded assemblies
- Prevents wear and cold welding during assembly and operation



| Solution                       | 8191              | 8192               | 8001<br>(Food grade) |
|--------------------------------|-------------------|--------------------|----------------------|
| Appearance                     | Black             | White              | Colourless           |
| Base                           | MoS <sub>2</sub>  | PTFE               | Mineral oil          |
| Viscosity                      | 11 (Cup 4)        | 11 (Cup 4)         | 4 mm <sup>2</sup> /s |
| Temperature range              | -40 °C to +340 °C | -180 °C to +260 °C | -20 °C to +120 °C    |
| Load test 4 ball N (Weld load) | n.a.              | n.a.               | 1,200                |
| Pack sizes                     | 400 ml aerosol    | 400 ml aerosol     | 400 ml aerosol       |



- Loctite® 8191**  
**MoS<sub>2</sub> Anti-friction coating – aerosol**
- Quick drying
  - Surface protection against corrosion
  - Enhances the performance of oils and greases



- Loctite® 8192**  
**PTFE coating**
- For non-metal and metal surfaces
  - Creates sliding surface for free movement
  - Prevents dust/dirt accumulation
  - Protection against corrosion
  - For conveyor belts, slideways and cams
- H1 NSF Reg. No.: 122980**



- Loctite® 8001**  
**Penetrating mineral oil spray**
- Multi-purpose penetrating oil for micro mechanisms
  - Penetrates inaccessible mechanisms
  - Lubricates valve seats, collars, chains, hinges and cutting knives
- H1 NSF Reg. No.: 122999**



## Oil

Chain lubricant

Freeing parts

Silicone oil

Cutting oil

General purpose

8011

8040

8021

8030/8031

8201

| Yellow                  | Amber                | Colourless liquid | Dark yellow                                  | Light yellow liquid     |
|-------------------------|----------------------|-------------------|--|-------------------------|
| Synthetic oil           | Mineral oil          | Silicone oil      | Mineral oil                                  | Mineral oil             |
| 11.5 mm <sup>2</sup> /s | 8 mm <sup>2</sup> /s | 583 mPa·s         | 170 mm <sup>2</sup> /s                       | 17.5 mm <sup>2</sup> /s |
| -20 °C to +250 °C       | n.a.                 | -30 °C to +150 °C | -20 °C to +160 °C                            | -20 °C to +120 °C       |
| 2,450                   | n.a.                 | n.a.              | 8,000  | n.a.                    |
| 400 ml aerosol          | 400 ml aerosol       | 400 ml aerosol    | 8030: 250 ml bottle,<br>8031: 400 ml aerosol | 400 ml aerosol          |



**Loctite® 8011**  
High temperature  
chain oil spray

- Oxidation resistance prolongs lubricant service life
- Lubricates open mechanisms, conveyors and chains at elevated temperatures up to 250 °C



**Loctite® 8040**  
Freeze & Release

- Releases rusted, corroded and seized components by the shock-freezing effect
- Wicks directly into the rust by capillary action
- Released parts remain lubricated and protected from corrosion



**Loctite® 8021**  
Silicone oil

- Lubricates metal and non-metal surfaces
- Suitable as release agent



**Loctite® 8030 bottle**  
**Loctite® 8031 aerosol**  
Cutting oil

- Protects cutting tools in operation
- Improves surface finish
- Increases tool life
- For drilling, sawing or tapping steel, stainless steel and most non-ferrous metals



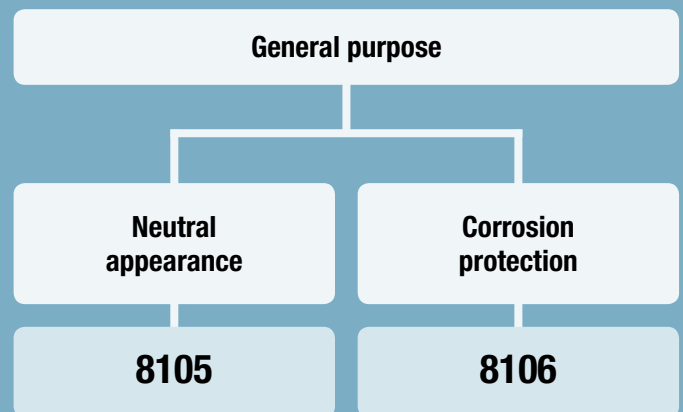
**Loctite® 8201**  
Five way spray

- Frees assemblies
- For light lubrication of metals
- Cleans parts
- Displaces moisture
- Prevents corrosion

H2 NSF Reg. No.: 122978

# Lubrication – Greases

- Prevents seizing and galling during assembly and operation
- Inhibits corrosion and oxidation in chemically and thermally aggressive environments
- Withstands high temperatures and extreme pressures



## Solution

|                                |                              |                              |
|--------------------------------|------------------------------|------------------------------|
| Appearance                     | Colourless                   | Light brown                  |
| Base oil and additives         | Mineral                      | Mineral                      |
| Thickener                      | Inorganic gel                | Lithium soap                 |
| Drop point                     | None                         | > 230 °C                     |
| N.L.G.I. class                 | 2                            | 2                            |
| Temperature range              | -20 °C to +150 °C            | -30 °C to +160 °C            |
| Load test 4 ball N (Weld load) | 1,300                        | 2,400                        |
| Pack sizes                     | 400 ml cartridge,<br>1 l can | 400 ml cartridge,<br>1 l can |

Special equipment available on request.



**Loctite® 8105**  
**Mineral grease**

- Lubricates moving parts
- Colourless
- Odourless
- Ideal for bearings, cams, valves and conveyors

**H1 NSF Reg. No.: 122979**



**Loctite® 8106**  
**Multi-purpose grease**

- Lubricates moving parts
- Provides corrosion protection
- For rolling, plain bearings and slideways





## High performance

## Special purpose

High temperature  
resistance

Heavy load  
applications

Plastic part  
applications

Chains, gears

**8102**

**8103**

**8104**

**8101**

Light brown

Black smooth paste

Colourless smooth paste

Amber high tack paste

Mineral E.P.

Mineral oil, MoS<sub>2</sub>

Silicone

Mineral oil, E.P.

Lithium soap complex

Lithium soap

Silica gel

Lithium soap

> 250 °C

> 250 °C

n.a.

> 250 °C

2

2

2/3

2

-30 °C to +200 °C

-30 °C to +160 °C

-50 °C to +200 °C

-30 °C to +170 °C

3,300

3,600

n.a.

3,900

400 g cartridge,  
1 l can

400 g cartridge,  
1 l can

75 ml tube,  
1 l can

400 ml aerosol



**Loctite® 8102**  
High temperature grease

- Prevents wear and corrosion
- Suitable in humid environmental conditions
- Withstands heavy loads at medium and high speeds
- Lubricates rolling, plain bearings, open gears and slideways



**Loctite® 8103**  
MoS<sub>2</sub> grease

- For moving parts at all speeds
- Withstands vibration and heavy loads
- For highly stressed joints, plain and roller bearings, socket joints and slide ways



**Loctite® 8104**  
Silicone grease

- Valve and packing grease
- Wide temperature range
- Lubricates most plastic and elastomeric components

**H1 NSF Reg. No.: 122981**



**Loctite® 8101**  
Chain lubricant

- Adhesive grease for open mechanical systems with anti-fling properties
- Protects against water ingress
- Excellent wear and high pressure resistance
- Lubricates chains, open gears and worm screws

# Lubrication – Anti-Seize

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

## Handy Hints:

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

## Solution

### High performance applications

High water  
resistance

8023

High purity

8013

Long term  
protection

8009

High load

8025  
(AS767)

| Colour                  | Black  | Dark grey                | Black                       | Silver                     |
|-------------------------|--|--------------------------|-----------------------------|----------------------------|
| Solid lubricating agent | Graphite, calcium, boron nitride & rust inhibitors | Graphite & calcium oxide | Graphite & calcium fluoride | Aluminium, Nickel, EP      |
| N.L.G.I. class          | –  | –                        | –                           | 1                          |
| Temperature range       | -30 °C to +1,315 °C                                | -30 °C to +1,315 °C      | -30 °C to +1,315 °C         | -30 °C to +1,200 °C        |
| Pack sizes              | 454 g brush top                                    | 454 g brush top          | 454 g brush top, 3.6 kg can | 400 ml aerosol, 1 l bottle |

Special equipment available on request.



#### Loctite® 8023 brush top

- Anti-Seize with ultimate wash out resistance
- For stainless steel

#### Approvals:

American Bureau of Shipping certified;  
MIL-PRF-907E



#### Loctite® 8013 brush top

- High purity metal free Anti-Seize
- Excellent chemical resistance
- For stainless steel
- Ideal for use in the nuclear industry

PMUC; D50YP12 General Electric; TIL 1117-3R1



#### Loctite® 8009 brush top

- Metal free Anti-Seize
- Provides long term lubrication
- For all metals including stainless steel and titanium

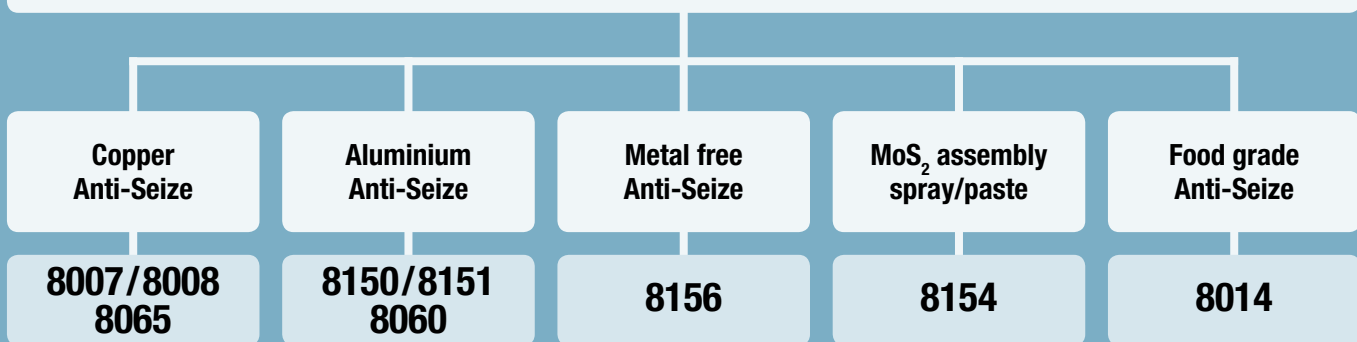


#### Loctite® 8025 (AS 767)

- Nickel based Anti-Seize
- For easy disassembly
- Typical applications: screws, bolts, grooves



## Standard applications



| Copper   | Grey  | White             | Black             | White   |
|--|---|-------------------|-------------------|---|
| Copper & graphite  | 8150/8151<br>Aluminium, graphite, EP<br>8060<br>Aluminium, graphite | Ceramic           | MoS <sub>2</sub>  | White oil and extreme pressure (EP) additives |
| –  | 1   | 2                 | 1                 | –   |
| –30 °C to +980 °C  | –30 °C to +900 °C   | –30 °C to +900 °C | –30 °C to +450 °C | –30 °C to +400 °C                             |
| 400 ml aerosol,<br>113 g, 454 g brush top,<br>3.6 kg can, 20 g stick | 400 ml aerosol,<br>500 g, 1 kg,<br>20 g stick                       | 500 g can         | 400 ml aerosol    | 907 g can                                     |



**C5-A®**  
**Loctite® 8007 aerosol**  
**Loctite® 8008 brush top**  
**Loctite® 8065 stick**

- Copper based Anti-Seize
- Typical applications: screws, nuts, pipes, exhaust bolts, brake caliper bolts



**Loctite® 8150 can**  
**Loctite® 8151 aerosol**  
**Loctite® 8060 stick**

- Aluminium based Anti-Seize
- Protects threaded connections
- Prevents seizing and corrosion
- Typical applications: screws, nuts, pipes, heat exchangers and fittings of oil and gas burners



**Loctite® 8156 can**

- Metal free Anti-Seize
- Prevents seizing and jamming
- Withstands high loads at low speeds and high temperatures
- Typical applications: exhaust pipes of combustion engines and fittings of oil and gas burners



**Loctite® 8154 aerosol**

- Assembly paste with MoS<sub>2</sub>
- Facilitates assembly and disassembly of cylindrical parts
- Withstands heavy operation conditions
- Lubricates and seals cylindrical parts, bearings, gearwheels at low speed

**H2 NSF Reg. No.: 122982**



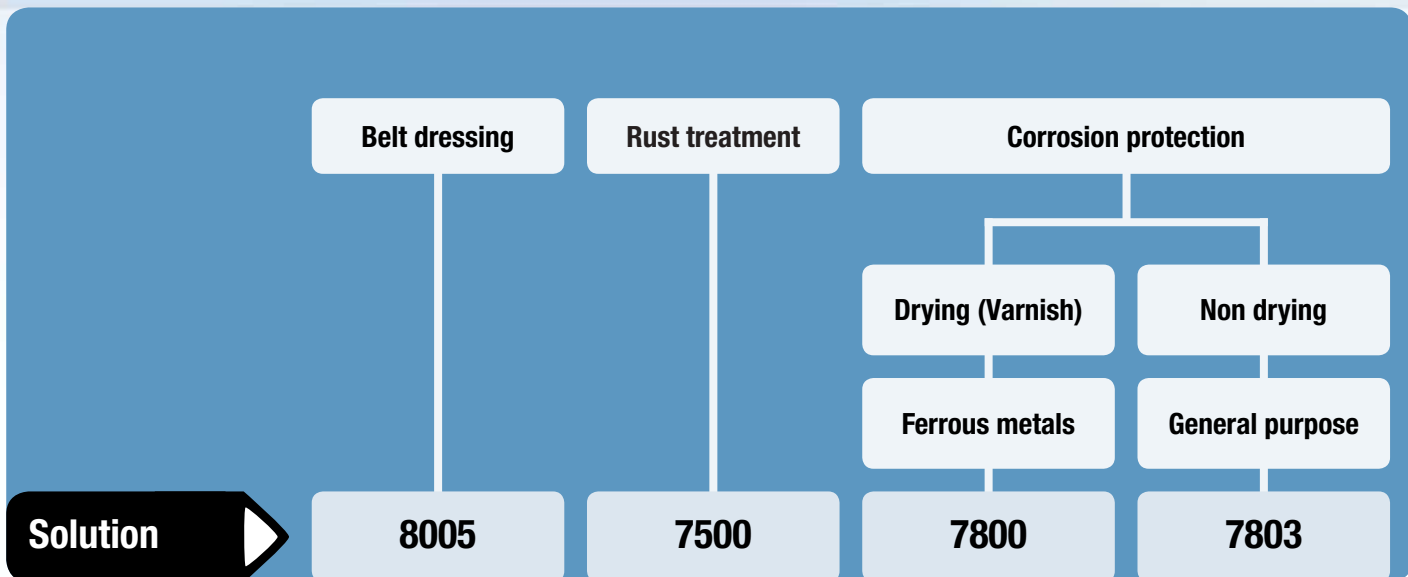
**Loctite® 8014 can**

- Food grade metal free Anti-Seize
- For stainless steel components
- Suitable for wet environments

**H1 NSF Reg. Nr.: 123004**

# Surface Treatment and Rust Prevention

- Stabilizes existing rust
- Guards against corrosion
- Prevents electro-chemical corrosion
- Increases belt friction



| Description       | Liquid spray   | Rust treatment | Zinc spray        | Metal protection coating |
|-------------------|----------------|----------------|-------------------|--------------------------|
| Colour            | Clear yellow   | Matt black     | Grey              | White                    |
| Temperature range | n.a.           | n.a.           | -50 °C to +550 °C | -30 °C to +60 °C         |
| Pack sizes        | 400 ml aerosol | 1 l can        | 400 ml aerosol    | 400 ml aerosol           |



**Loctite® 8005  
Belt dressing**

- Prevents slippage
- Increases friction for all types of belts
- Extends belt life



**Loctite® 7500  
Rust treatment**

- Converts existing rust into a stable base
- Protects surfaces from corrosion
- Cured product acts as a primer ready for painting
- For metal pipes, valves, fittings, storage tanks, fences, guard rails, conveyors, construction and agricultural equipment



**Loctite® 7800  
Zinc spray**

- Excellent cathodic corrosion protection on ferrous metals
- Restores protection to galvanized parts
- Typical applications: Touching-up of metal parts after welding, long term protection of metal assemblies



**Loctite® 7803  
Metal protection coating spray**

- Non drying, tack free coating
- Provides long term corrosion protection
- For iron, steel, sheet steel, pipes, moulds, machines and installations that have to be stored outdoors



## Emergency Repair Products

|             | O-Ring Replacement  | Holes filler, repair of non-structural defects   | Leak detector  | Leak sealer (pipes)   |
|-------------|---|--|--|---|
| Solution    | O-Ring kit  | 3463   | 7100   | 5070  |
| Description | <ul style="list-style-type: none"> <li>Eliminates the need for an inventory of different sized O-rings</li> </ul> | <ul style="list-style-type: none"> <li>Steel filled kneadable stick</li> <li>Ideal for emergency sealing of leaking tanks and pipes</li> </ul> | <ul style="list-style-type: none"> <li>Facilitates the detection of both micro-leaks and larger leaks in gas handling systems</li> </ul> | <ul style="list-style-type: none"> <li>Easy-to-use repair kit</li> <li>Use for temporary/medium term repair of leaking pipes and reinforcement of weak areas</li> </ul> |



### Loctite® O-Ring kit

- Saves the need for complete disassembly
- Joints resist water/oil and are as strong as the rubber itself
- Kit contains: 7 standard diameter sizes of nitrile cord, splicing jig, safety knife and Loctite® 406 instant adhesive



### Loctite® 3463 Metal Magic Steel™ stick

- Working time 3 minutes – sets in 10 minutes
- Adheres to damp surfaces and cures under water
- Chemical and corrosion resistant
- Can be drilled, filed and painted
- Smooths welds, repairs small cracks in castings and fills oversized bolt holes
- Available pack sizes: 50 g and 114 g



### Loctite® 7100 Leak Detector

- Produces bubbles at areas where a leak is present
- Non toxic
- Non flammable
- For use with all gases and gas mixtures except pure oxygen. Use also for iron, copper and plastic piping



### Loctite® 5070 Pipe Repair kit

- Repairs pipe leaks in 1 hour
- No tools required
- Maximum temperature 120 °C
- Kit contains: Protective gloves, Loctite® 3463 Metal Magic Steel™ Stick, and urethane-impregnated GRP tape

# Equipment

- Ergonomically designed for manual application of Loctite® adhesives and fluids directly from their original package
- For the simple, easy, clean, hand held dispensing of fluids
- Reduces waste and operator contact
- Excellent compatibility with Loctite® products



**Loctite® 97001 / 98414 Peristaltic Hand Pump**

- Portable bottle-top applicator
- Threads directly on any 50 ml (98414) or 250 ml (97001) bottle of anaerobic product
- Dispenses from 0.01 to 0.04 ml



**Loctite® 97040 300 ml Cartridge Manual Dispenser**

- Hand held, manually-operated dispenser for all standard 300 ml cartridges
- Rapid-loading system to make cartridge changes cleanly and easily



**Loctite® 97002 Pneumatic Cartridge Dispenser**

- Hand held unit for 300 ml cartridges and 250 ml squeeze tubes
- Integrated pressure regulator
- Quick pressure relief, in order to minimize run-on effect



**Loctite® 96001 / 97042 50 ml Dual Cartridge Applicator**

- Hand-held dispenser for 50 ml dual cartridges (item 96001 manual / item 97042 pneumatic)
- Convenient & cost-effective for applying product with minimal waste
- Suitable for 1:1 / 1:2 / 1:10 mix ratio



**Loctite® 96003 / 983437 200 ml Dual Cartridge Applicator**

- Hand-held dispenser for 200 ml dual cartridges (item 96003 manual / item 983437 pneumatic)
- Convenient & cost-effective for applying product with minimal waste
- Suitable for 1:1 / 1:2 mix ratio



**Loctite® 983438 / 983439 400 ml Dual Cartridge Applicator**

- Hand-held dispenser for 400 ml dual cartridges (item 983438 manual / item 983439 pneumatic)
- Convenient & cost-effective method for applying product with minimal waste
- Suitable for 1:1 / 1:2 mix ratio



**Loctite® 1047326 Electrical Cartridge Applicator, 300 ml**

- Powerful tool to dispense even high viscosity materials
- Works with a rechargeable battery that allows application of up to 80 cartridges with one charge



**Loctite® 98548 Benchtop Peristaltic Dispenser**

- For low viscosity, non-thixotropic adhesives
- For precise dosing and controlled flow rate
- Versatile use as manual or semi-automatic workstation
- No air source required



**Loctite® 98666 Syringe Dispensing System**

- Analogue gauge, digital timer
- General purpose dispensing of viscosities from water-thin to paste-like
- Delivers repeatable dots in a timed mode, or beads in a continuous mode
- For products packaged in 10 ml or 30 ml syringes



**Loctite® 97009 / 97121 / 97201 Integrated Semi Automatic Dispensing System**

- Combines a controller and reservoir into a single unit
- Provides digital timing control, empty and end-of-cycle signal
- Pinch Valve suitable for stationary or hand held setup mode

## Loctite® equipment solutions

Loctite® products are used for a wide variety of bonding, threadlocking, retaining, gasketing and thread sealing applications. For some jobs it is sufficient to dispense adhesives and sealants manually from the bottle or cartridge onto the surfaces to be joined. In other cases, however, more precise handheld or stationary automated dispensing is required.

To meet this need, Henkel developed an equipment range especially designed to make the application of Loctite® products economical, fast, precise and clean. Henkel equipment technology enables our customers to apply beads, drops or continuous rings of adhesives, and spray and spin of adhesives and sealants.


Henkel provides a complete modular line of Loctite® dispensing equipment, ranging from simple hand-held dispensers to fully automated systems including dispense monitors by either flow monitoring or on-part detection. Henkel also provides spot light and flood light curing systems to suit customer curing needs.

In addition to the standard equipment available, Henkel can design and build equipment based upon customers requirements to provide unique application solutions. A standard range of x-y-robots facilitates automation of assembly processes. Automated and special equipment on request.




# Equipment


## 1 1/2" Flexible Dispense Tips. Dispense Needle, Polypropylene (PPF), Helical Thread

| Product   | Item No. (50 pieces) | IDH No. | Hub Colour | Gauge | Inner Dia. in mm |
|---|----------------------|---------|------------|-------|------------------|
|  | 97229                | 142640  | Amber      | 15    | 1.37             |
|   | 97230                | 142641  | Green      | 18    | 0.84             |
|   | 97231                | 142642  | Pink       | 20    | 0.61             |
|   | 97232                | 142643  | Red        | 25    | 0.25             |













## 1 1/4" Tapered Dispense Tips. Dispense Needle, Polyethylene – Conical (PPC), Helical Thread

| Product   | Item No. (50 pieces) | IDH No. | Hub Colour | Gauge | Inner Dia. in mm |
|---|----------------------|---------|------------|-------|------------------|
|  | 97221                | 88660   | Grey       | 16    | 1.19             |
|   | 97222                | 88661   | Green      | 18    | 0.84             |
|   | 97223                | 88662   | Pink       | 20    | 0.61             |
|   | 97224                | 88663   | Blue       | 22    | 0.41             |

## 1 1/2" High Precision Dispense Tips. Dispense Needle, Stainless Steel – Standard (SSS), Helical Thread

| Product   | Item No. (50 pieces) | IDH No. | Hub Colour | Gauge | Inner Dia. in mm |
|---|----------------------|---------|------------|-------|------------------|
|  | 97225                | 88664   | Amber      | 15    | 1.37             |
|   | 97226                | 88665   | Green      | 18    | 0.84             |
|   | 97227                | 88666   | Pink       | 20    | 0.61             |
|   | 97228                | 88667   | Red        | 25    | 0.25             |

## Additional Dispense Tips and Accessories

| Product   | Item No. | IDH No. | Description   |
|---|----------|---------|---|
|  | 97216    | 303605  | 10 cc Syringe Starter Kit   |
|  | 97233    | 88672   | Luer-Lok® Adapter Kit, 20 Luer-Loks® and 5 adapters                             |
|  | 97238    | 218272  | Dispense Needle, Stainless Steel – PTFE-lined (SSTL), 25 Gauge (50 pack)        |
|  | 97248    | 218275  | Luer-Lok Tip Caps (50 pack)   |
|  | 97262    | 218288  | Needle selection pack: 2 each of a variety of Dispense Needle                   |
|  | 97290    | 397462  | All plastic precision dispense tip, 20 Gauge (50 pack)                          |
|  | 97511    | 530835  | Tri-Nozzle – Helps eliminate bubbles in anaerobic gasket applications (10 pack) |
|  | 984569   | 478562  | Square Mix Nozzle Kit for 50 ml, 10 Pcs. Static Mixer SQ 5.3-24                 |
|  | 984570   | 478563  | Square Mix Nozzle Kit for 200/400 ml, 10 Pcs. Static Mixer SQ 7.5-24            |
|  | K1003100 | 88805   | Formable Dispense Tip, 21 Gauge/ 0,5 mm (50 pack)                               |
|  | K1003200 | 142674  | Formable Dispense Tip, 12 Gauge/ 2 mm, (50 pack)                                |
|  | 98463    | 720221  | Static mixer 50 ml 3030, 10:1 S-cartridges only (10 pack)                       |



## Maintenance Workshop

The Maintenance Workshop is a practical hands-on training program on the use of Loctite® products in Maintenance, Repair and Overhaul environments.

This program will provide your workforce with the knowledge and tools to do the following:

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

We offer Training Modules for the following applications:

### ● Standard Reliability Training

- Threadlocking
- Pipe & Thread Sealing
- Gasketing
- Retaining

### ● Maintenance Solution Training

- Metal Rebuilding
- Lubrication
- Surface Treatment & Rust Prevention
- Bonding
- Flexible Sealing & Bonding

### ● Additional Training

- Cleaning

### Key Maintenance Workshop features:

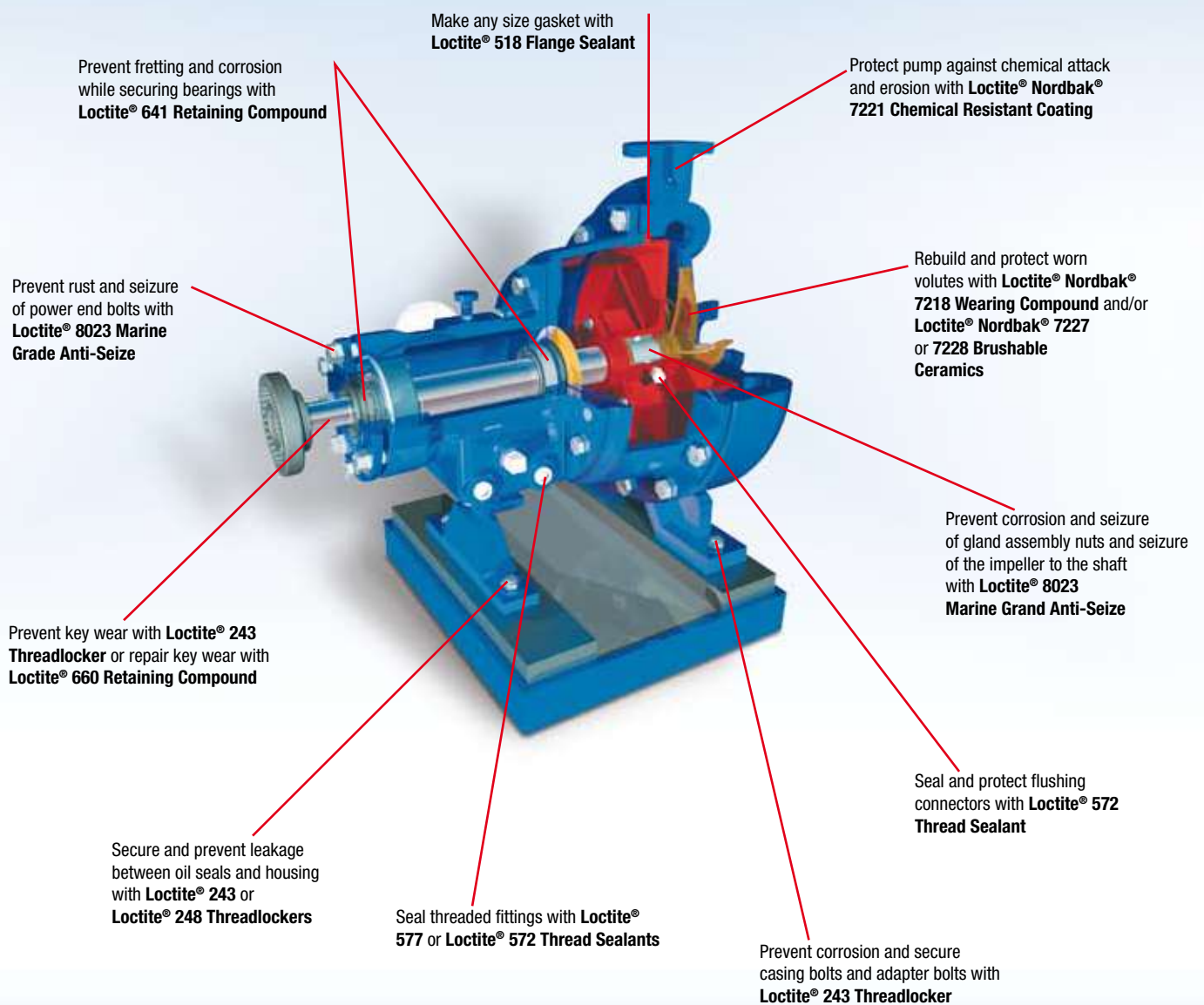
- Pre-plant survey
- Hands-on training
- Covers all trades
- Conducted on site
- Training materials supplied
- Review of common failure causes and prevention
- Standard 2 hour workshop can be tailored to meet your needs through a plant tour and pre-survey
- In-plant follow up



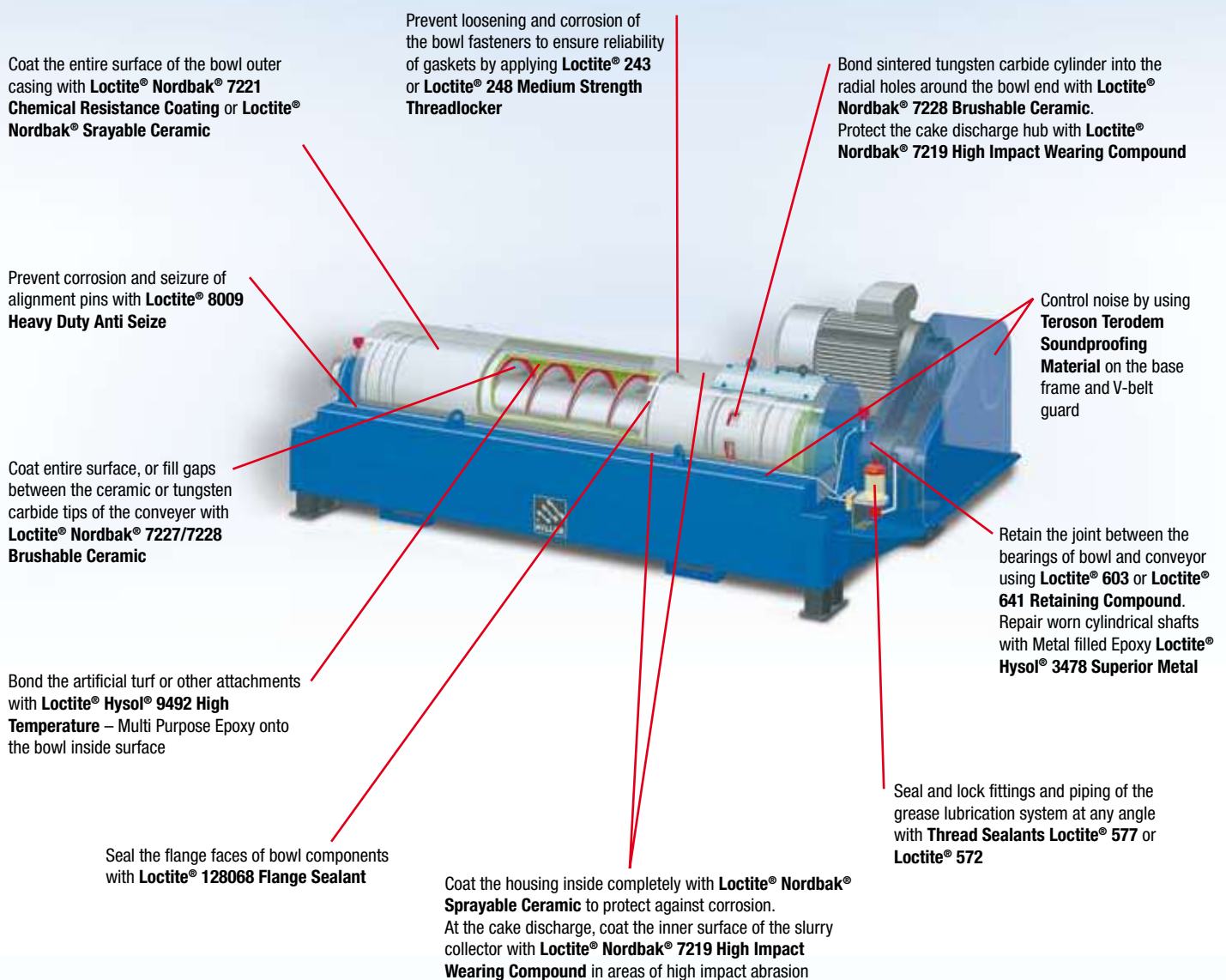
# Pump & Centrifuge

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

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



Industrial centrifuges, used to separate, purify, extract, and wash various materials in industrial settings, are subject to high wear and tear. Loctite® and Teroson products help to extend their service life while keeping maintenance costs down.

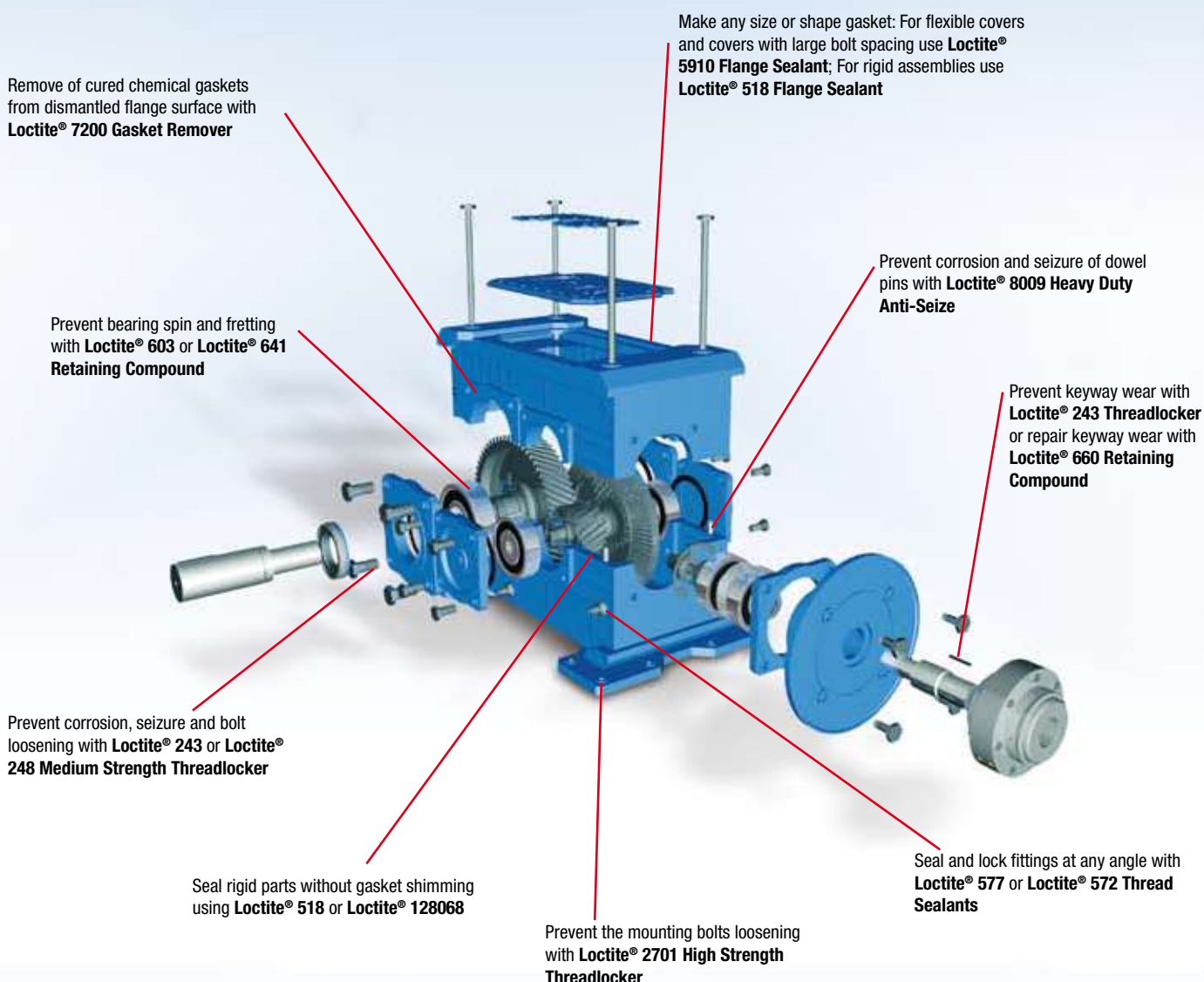




# Gearbox & Shaft

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

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





Most shaft assemblies run in harsh environments and operating conditions which result in wear, erosion, corrosion, and leaks. A comprehensive range of Loctite® products provides all the technologies required to minimise expensive downtime, enhance reliability and dramatically cut costs.

## Additional Products:

### Loctite® 7063 Cleaner & Degreaser:

- Use for all repair methods, for cleaning parts prior to adhesive bonding

### Loctite® 7649 Activator:

- Use in combination with Retaining Compound
- Increases cure speed on passive surfaces such as stainless steel, aluminium, and plated or passivated metals

### Loctite® 8192 Dry Film Lubricant

#### Release Agent:

- Use as a release agent for the repair methods on parallel keys and splines

## Proactive Maintenance:

### Loctite® 8012 Moly Paste:

- Prevent wear caused by friction
- Prevent corrosion

## Sleeving:

### Loctite® 603, 648 and 668 Retaining Compounds:

- For badly worn shafts
- High load applications
- Use a sleeve material similar to the original shaft material

## Bonding:

### Loctite® 603, 648, 660 Retaining Compound and Loctite® Hysol® 9466 A&B Epoxy:

- Recover worn or incorrectly machined components by using repair adhesives
- Adhesive selection depends on depth of wear

## Proactive Maintenance:

### Loctite® 243 and 248 Threadlockers:

- Stop threads working loose
- Eliminate the micro-movement which leads to fretting
- Prevent keyway wear
- Prevent corrosion

## Rebuilding:

### For badly worn Shafts Loctite® Hysol® 3478 A&B Metal filled Epoxy:

- Rebuild the worn surface with metal filled epoxy
- Machine the shaft after repair to the original (nominal) diameter

### Loctite® 660 Retaining Compound and Loctite® 7649 Activator:

- Bond the shaft mounted component onto the worn surface



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|             |  | 250 ml        | 267359  |      |
| 243         | Threadlocker, Medium Strength                        | 10 ml         | 135279  | 11   |
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|             |  | 250 ml        | 135357  |      |
| 248         | Threadlocker, Medium Strength, Semi-solid            | 9 g           | 540498  | 11   |
|             |  | 19 g          | 540491  |      |
| 268         | Threadlocker, High Strength, Semi-solid              | 9 g           | 540900  | 11   |
|             |  | 19 g          | 540907  |      |
| 270         | Threadlocker, High Strength                          | 10 ml         | 267380  | 11   |
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| 2701        | Threadlocker, High Strength                          | 10 ml         | –       | 11   |
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| 278         | Threadlocker, High Strength                          | 50 ml         | *       | 11   |
|             |  | 250 ml        | *       |      |
| 290         | Threadlocker, Wicking                                | 10 ml         | 267397  | 10   |
|             |  | 50 ml         | 233733  |      |
|             |  | 250 ml        | 267398  |      |
| 319/7649    | Rear View Mirror Mesh Kit<br>Glass-Metal Bonding Kit | 0.5 ml        | 194088  | 20   |
|             |  | 5 g / 4 ml    | –       |      |
| 330/7388    | MULTI-BOND® Kit                                      | 50 ml / 40 ml | 230054  | 21   |
| 330         | Structural Adhesive, Toughened, non-mix              | 315 ml        | 135407  | 21   |
| 3030        | Structural Adhesive                                  | 35 ml         | TBD     | 20   |
| 3421 A&B    | Structural Adhesive, General Purpose                 | 50 ml         | 248211  | 20   |
|             |  | 200 ml        | 254055  |      |
|             |  | 400 ml        | 530376  |      |
| 3421 A      | Structural Adhesive, General Purpose                 | 1 kg          | 431949  | 20   |
|             |  | 20 kg         | 588012  |      |
| 3421 B      | Structural Adhesive, General Purpose                 | 1 kg          | 431948  | 20   |
|             |  | 20 kg         | 588378  |      |
| 3430 A&B    | Structural Adhesive, Fast cure, Ultra clear          | 24 ml         | 242865  | 21   |
|             |  | 50 ml         | 843054  |      |
|             |  | 200 ml        | 843759  |      |
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| 3450 A&B    | Structural Adhesive, Fast cure, Black                | 25 ml         | 229177  | 21   |
| 3463        | Metal Magic Steel™ Stick                             | 50 g          | 396913  | 41   |
|             |  | 114 g         | 265628  |      |
| 3471 A&B    | Metal Set S1, Putty, Tub Kit                         | 500 g         | 229176  | 26   |
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| 3475 A&B    | Metal Set A1, Multi Purpose, Tub Kit                                 | 500 g        | 229173  | 27   |
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|             |  | 500 g        | 135431  |      |
| 406         | Instant Adhesive, Low Viscosity                                      | 20 g         | 233695  | 18   |
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| 431         | Instant Adhesive, Surface Insensitive, High viscosity                | 20 g         | 261800  | 19   |
|             |  | 500 g        | 195693  |      |
| 435         | Instant Adhesive, Rubber Toughened, Clear                            | 20 g         | 871787  | 18   |
|             |  | 500 g        | 872303  |      |
| 454         | Instant Adhesive, General Purpose Gel<br><br>(Collapsible Cartridge) | 3 g          | –       | 18   |
|             |  | 20 g         | 195678  |      |
|             |  | 300 g        | 88526   |      |
|             |  | 300 g        | 234443  |      |
| 480         | Instant Adhesive, Rubber Toughened, Black                            | 20 g         | 135250  | 18   |
|             |  | 500 g        | 135253  |      |
| 4850        | Flexible Instant Adhesive  | 20 g         | 373358  | 19   |
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| 5070        | Pipe Repair Kit  | 2" x 6' tape | 255861  | 41   |
| 510         | Flange Sealant, Rigid Parts, High Temperature                        | 50 ml        | 142608  | 15   |
|             |  | 250 ml       | 135477  |      |
|             |  | 300 ml       | 135325  |      |
| 5145        | Flexible Adhesive Sealant, Non Corrosive                             | 40 ml        | 88318   | 22   |
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| 518         | Flange Sealant, Rigid Parts  | 25 ml        | –       | 15   |
|             |  | 50 ml        | 229875  |      |
|             |  | 300 ml       | 435566  |      |
| 5203        | Flange Sealant, Low Strength   | 50 ml        | 388178  | 14   |
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| 5331        | Thread Sealant, Plastic  | 100 ml       | 142492  | 12   |
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|             |  | 19 g         | 705075  |      |
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| 55          | Pipe Sealing Cord  | 50 ml<br>150 ml           | 483283<br>270153           | 12   |
| 561         | Pipe Sealant, Semi-solid                                   | 19 g                      | 540920                     | 13   |
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|             |  | 10 kg     | 458216  |      |
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|             |  | 10 kg     | 458213  |      |
| 7221        | Loctite® Nordbak® Chemical Resistant Coating Kit         | 5.4 kg    | 735862  | 29   |
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\*on request

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| 8065        | Copper based Anti-Seize, Stick                   | 20 g      | 525392  | 39   |
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# Henkel – The Solution Provider

## Solutions For Today – And Tomorrow

With its highly recognized Loctite®, Teroson, Hysol®, Nordbak® and other power brands, Henkel is a world market leader bringing total solutions to OEMs, to MRO facilities and for aftermarket repair needs. This makes Henkel products the professionals' choice for applications from a diverse technology portfolio. Henkel customers benefit from the company's decades of experience as a technology innovator, as well as unparalleled service and support.

### Powerful Solutions meet all needs

As a Solution Provider, Henkel offers much more than outstanding products – it provides powerful solutions based on innovative technologies and concepts, and on an in-depth understanding of the customers' devices. Multiple functionalities deliver benefits which help customers both in maintenance and repair and in original equipment manufacturing respond effectively to the problems in ensuring reliability, safety and durability.

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At Henkel, customer training is an ongoing effort – because even high-quality products can be only as good as the people who use them. The company offers hands-on seminars and workshops focused on Best Practices and advice on how to maximize reliability while cutting maintenance time and costs. Conducted at the customer's premises, training can be tailored to meet individual needs through a plant tour and pre-survey.

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

As Official Partner and Supplier to the Dakar Rally for several years, Henkel has supported the competing teams with products that reflect the company's innovation and technological excellence. Over the years, close contacts have developed into a strong relation of mutual trust and understanding, built on the competent service and the high-quality adhesives and sealants offered for fast and efficient repairs which have helped many drivers to make it to the finish line.



For more information on the Henkel portfolio, please visit [www.henkel.com](http://www.henkel.com), where you can download catalogues, data sheets, technical papers, etc.



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

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