

Technology	Acrylic
Chemical Type	Methacrylate ester
Appearance (uncured)	White to off-white paste ^{LMS}
Components	One component - requires no mixing
Viscosity	High
Cure	Anaerobic
Secondary Cure	Activator
Application	Thread sealing
Strength	Low

The graph illustrates the curing kinetics of three materials. The y-axis represents the percentage of full strength achieved on a steel substrate, ranging from 0 to 100. The x-axis represents the cure time in minutes, hours, and days. Brass (blue line) cures fastest, reaching full strength by 10 minutes. Steel (black line) reaches full strength by 30 minutes. Stainless steel with Activator 7649™ (red line) cures slowest, reaching approximately 85% strength after 72 hours.

Cure Time	Brass (%)	Steel (%)	Stainless steel with Activator 7649™ (%)
1min	20	10	0
5min	90	85	40
10min	100	95	70
30min	100	100	80
1h	100	100	83
3h	100	100	85
6h	100	100	85
24h	100	100	85
72h	100	100	85

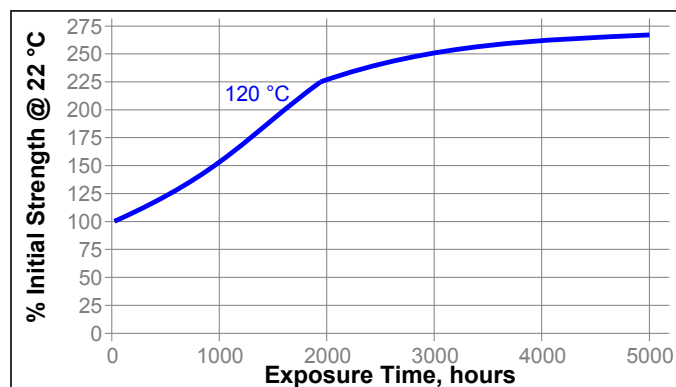
A line graph showing the percentage of full strength on steel versus cure time for three different temperatures: 4°C (red line), 22°C (blue line), and 40°C (black line). The x-axis represents cure time on a logarithmic scale with markers at 1min, 5min, 10min, 30min, 1h, 3h, 6h, 24h, and 72h. The y-axis represents the percentage of full strength on steel from 0 to 100. The 4°C curve rises most steeply, reaching nearly 100% strength by 10 minutes. The 22°C curve reaches about 95% strength by 10 minutes and continues to rise slowly. The 40°C curve rises sharply to about 85% strength by 5 minutes and then plateaus, reaching approximately 88% strength by 72 hours.

Cure Time	4 °C (%)	22 °C (%)	40 °C (%)
1min	~10	~20	~10
5min	~90	~85	~85
10min	~95	~90	~85
30min	~98	~93	~85
1h	~99	~94	~85
3h	~100	~95	~85
6h	~100	~96	~85
24h	~100	~97	~85
72h	~100	~98	~88

Breakaway Torque, ASTM D 6396, Pre-torqued to 27 N·m:
3/8 NPT steel pipe tees
and plugs

Heat Aging

Aged at temperature indicated and tested @ 22 °C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength
		720 h
Air reference	87	131
Motor oil (MIL-L-46152)	87	125
Unleaded gasoline	87	99
Phosphate ester	87	116
Processing Temperature	87	99
Transmission fluid	87	126
Brake fluid	87	97
Distilled water	87	161
Water/glycol 50/50	87	153

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use:**For Assembly**

1. For best results, clean all surfaces (external and internal) with a LOCTITE® cleaning solvent and allow to dry.
2. If the material is an inactive metal or the cure speed is too slow, spray with Activator 7471™ or 7649™ and allow to dry.
3. Apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free. Force the material into the threads to thoroughly fill the voids. For bigger threads and voids, adjust product amount accordingly and apply a 360° bead of product on the female threads also.
4. Using compliant practices, assemble and wrench tighten fittings in accordance with manufacturers recommendations.
5. Properly tightened fittings will seal instantly to moderate pressures. For maximum pressure resistance and solvent resistance allow the product to cure a minimum of 24 hours.

For Disassembly

1. Remove with standard hand tools.
2. Where hand tools do not work because of excessive engagement length or large diameters (over 1"), apply localized heat to approximately 250 °C. Disassemble while hot.

For Cleanup

1. Cured product can be removed with a combination of soaking in a Loctite solvent and mechanical abrasion such as a wire brush.

Loctite Material Specification^{LMS}

LMS dated August 27, 1999. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties. Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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Reference 1.2