For detailed product performance information and application guidelines, please refer to Technical Data or contact Henkel Loctite.

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"Loctite" is a registered trademark of Loctite Corporation
With this solution guide you can easily select the best Henkel Loctite product to solve engineering problems throughout industry, in original equipment manufacture as well as maintenance and repair.

It has been developed to make your product selection quick, easy and right first time. You may navigate this guide to find solutions from several different starting points:

- The problem solving section
- Henkel Loctite product categories
- A product list including ordering information

For more information about our products or us just “hit” the Henkel Loctite website - www.loctite.com.

This will give you - anytime day or night - further information on all of our products including those described here. Also you have access to our most up-to-date literature and news about solutions to industrial problems using Henkel Loctite, addressing segments such as Industrial OEM, Automotive, Electronics, Maintenance and Repair.
What’s the Problem?

Nuts, Bolts, Studs, Threaded Parts

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

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

Flanges Leaking

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

See also Emergency Repair Products on page 46

Page 10

Page 12

Page 14

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

Page 16

Joining Small Parts

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

Page 18

Joining Plastic and Glass to each other and themselves and to Metals

- ? Need to secure small parts in plastic, glass, metal
- ? Need cure on command
- ? Need fast curing on a semi or fully automated production line
- ? Need to pot/seal

Page 20
What’s the Problem?

Joining Large/Structural Parts
- Strong durable joints between different materials
- Replace welding/riveting - with a corrosion-free, reduced stress joint

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

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

Corroding Components
- Prevent corrosion after assembly or during storage
- Guard against electrochemical effects
- Protect welds at high temperatures

Repair/Join Fibre-reinforced Plastic Parts
- Repair, restore, and join FRP parts or assemblies
- Waterproof filling and sealing of FRP, wood, metal
- Durable structural repairs

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

Page 22
Page 24
Page 26
Page 34
Page 36
Page 38
What's the Problem?

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

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

**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

**Cleaning Parts**
- 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

**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

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

**Emergency Repair**
- Damaged rubber such as conveyor belt surfaces
- Fill over-sized holes, smooth rough welds, repair nonstructural defects
- Make a new O ring - in situ.
- Emergency plugging and sealing of burst or leaking pipes

**Dispensing and Curing Adhesives and Sealants**
- Apply thick or thin products easily, cleanly, accurately and without waste
- Cure UV Bonding products quickly and completely

**Products with NSF Approval**
- NSF is one of the most widely respected and recognised global third-party certification providers focusing on food, water, indoor air and the environment. For more information go to www.nsf.com

- Need NSF approval check section:
  - Threadlocking
  - Pipe and Thread Sealing
  - Gasketing
  - Retaining and Securing Cylindrical Assemblies
  - Instant Bonding
  - Structural Bonding
  - Lubrication - Oils
  - Lubrication - Greases
  - Lubrication - Anti-seize
  - Lubrication - Dry Film
## Threadlocking -
### Locking of Threaded Fasteners

- **Resists vibration**
- **Single part - clean and easy to apply**
- **Can be used on all sizes of fasteners - reduces inventory costs**
- **Seals threads allows through-hole tapping**

### Are the parts already assembled?

<table>
<thead>
<tr>
<th>Solution</th>
<th>Yes</th>
<th>No</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Handy Hints:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>- Clean parts with Loctite® 7063 before applying the adhesive</td>
<td></td>
<td></td>
</tr>
<tr>
<td>- If the threadlocker will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>- If the parts were in contact with aqueous washing solutions or cutting fluids which leave a protective layer on the surface, wash with hot water before use</td>
<td></td>
<td></td>
</tr>
<tr>
<td>- Use Loctite® 406 if either substrate is plastic</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Wicking grade</strong></td>
<td><strong>290</strong></td>
<td><strong>222</strong></td>
</tr>
<tr>
<td><strong>Size of Thread</strong></td>
<td>Up to M 12</td>
<td>Up to M 36</td>
</tr>
<tr>
<td><strong>Strength</strong></td>
<td>Medium/High</td>
<td>Low</td>
</tr>
<tr>
<td><strong>Functional Strength</strong></td>
<td>3 hrs</td>
<td>6 hrs</td>
</tr>
<tr>
<td><strong>Breakaway Torque M10 bolts</strong></td>
<td>10 Nm</td>
<td>6 Nm</td>
</tr>
<tr>
<td><strong>Long-Term Temperature Resistance</strong></td>
<td>+150 °C</td>
<td>+150 °C</td>
</tr>
<tr>
<td><strong>Pack Sizes</strong></td>
<td>10 ml, 50 ml, 250 ml</td>
<td>10 ml, 50 ml, 250 ml</td>
</tr>
</tbody>
</table>

### Application Examples

**Loctite® 290**
Recommended for locking preassembled fasteners, e.g. instrumentation screws, electrical connectors and set screws.

**Loctite® 222**
Recommended for low-strength threadlocking of adjusting screws, countersunk head screws and set screws.
Also use on low strength metals such as aluminum or brass which could break during disassembly.
P1 NSF Reg. No.: 123002

**Loctite® 243**
Effective on all types of metal threaded fasteners.
Prevents loosening on vibrating parts such as pumps, motor mounting bolts, gear boxes or presses.
Recommended for use where disassembly with hand tools is required for servicing and where parts are contaminated with oil.
P1 NSF Reg. No.: 123000
Certified to ANSI/NSF Standard 61.

**Loctite® 2701** (improved 270)
For use on all metal fasteners (including stainless steels and those with protective coatings such as zinc) where regular removal for maintenance is not required.
Recommended for permanently locking studs on engine blocks and pump housings.
P1 NSF Reg. No.: 123006 - only Loctite® 270
**Pipe and Thread Sealing - Sealing of Threaded Components**

- Provide an instant, low pressure seal for all types of pipe connections.
- Will not creep, shrink or block systems (including filters) by shredding.
- Disassembly can be achieved easily with normal tools.
- Replace all tapes and hemp/pastes combinations.

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### Are the parts metal or plastic?

<table>
<thead>
<tr>
<th>Plastic or combined plastic / metal parts</th>
<th>Metal parts</th>
</tr>
</thead>
<tbody>
<tr>
<td>Joining non threaded plastic pipe fittings</td>
<td>Are the threads fine or coarse?</td>
</tr>
<tr>
<td><strong>Cord</strong></td>
<td><strong>Fine up to (R1) pipe thread</strong></td>
</tr>
<tr>
<td><strong>Liquid</strong></td>
<td><strong>Coarse up to (R3) pipe thread</strong></td>
</tr>
</tbody>
</table>

---

### Handy Hints:

- If the sealant (Loctite® 542, 577 or 572) will be applied below 5 °C, pre-treat with Loctite® 7240 (Activation).
- All parts must be clean & dry before sealing – use Loctite® 7063.
- If the parts have been in contact with washes or cutting fluids containing nitrates, wash them with hot water.
- Clean U-PVC pipe surfaces with Loctite® 7044 prior to joining with Loctite® 5004.

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### Application Examples

- **Loctite® 5004**
  - (Not available in UK)
  - Special solvent-based adhesive for bonding U-PVC pipes.
  - Complies with the following: DIN 30870 and KTR guidelines PD 17, BS 4958, part 3 and ASHT 132564.
  - The cured adhesive meets the requirements of admission for drinking water supply through U-PVC pipes in compliance with the Recommendation no. 18 of the Plastic Commission of the Bundesgesundheitsamt (Germany Health Authorities).

- **Loctite® 55**
  - Can be safely applied on metal and plastic threaded fittings.
  - Potable water: VAC tested for use with potable water up to 85 °C.
  - Tested in accordance with EN 751-2 Class ARp.
  - Complies with the following: DIN 16970 and KRV guidelines R1.17, BS 4346, part 3 and ASTM 12564.
  - The cured adhesive meets the requirements of admission for drinking water supply through U-PVC pipes in compliance with the Recommendation no. 18 of the Plastic Commission of the Bundesgesundheitsamt (Germany Health Authorities).

---

### Solution

<table>
<thead>
<tr>
<th>Description</th>
<th>Solvent</th>
<th>Cord</th>
<th>Curing gel</th>
<th>Curing liquid</th>
<th>Curing gel</th>
<th>Curing gel</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum Thread Size</td>
<td>Tested to 4”</td>
<td>As plastic</td>
<td>Low</td>
<td>Medium</td>
<td>Medium</td>
<td>High</td>
</tr>
<tr>
<td>Temperature Resistance</td>
<td>+130 °C</td>
<td>+150 °C</td>
<td>+150 °C</td>
<td>+150 °C</td>
<td>+150 °C</td>
<td></td>
</tr>
<tr>
<td>Disassembly Strength</td>
<td>High</td>
<td>Medium</td>
<td>Medium</td>
<td>Medium</td>
<td>Medium</td>
<td></td>
</tr>
</tbody>
</table>

### Substrate to be Sealed

- U-PVC: No
- Metal, plastic or both: Yes
- Metal: Yes
- Metal: Yes
- Metal: No

### Instant Low Pressure Seal

- No: Yes
- Yes: No
- Yes: Yes
- Yes: No

### Pack Sizes:

- 125 g, 250 g, 500 g
- 80 g = 150 m cord
- 100 ml
- 10 ml, 50 ml, 250 ml
- 50 ml, 250 ml
- 50 ml, 250 ml

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1. Does not apply to Loctite® 5331/55

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**Handy Hints:**

- If the sealant (Loctite® 542, 577 or 572) will be applied below 5 °C, pre-treat with Loctite® 7240 (Activation).
- All parts must be clean & dry before sealing – use Loctite® 7063.
- If the parts have been in contact with washes or cutting fluids containing nitrates, wash them with hot water.
- Clean U-PVC pipe surfaces with Loctite® 7044 prior to joining with Loctite® 5004.
Gasketing –
Sealing of Flanges

■ No shimming effect – controlled tolerances, no need for re-torquing
■ Fill all voids – reduce the need for a fine surface finish of flanges
■ Parts can be disassembled easily even after extended service
■ Resists high pressure when fully cured

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

Yes

No

What gap must the sealant fill?

Up to 0.5 mm

Greater than 0.5 mm

Handy Hints:
■ If there are traces of old gasket left on the parts to be sealed, clean with Loctite® 7200 gasket remover
■ All parts must be clean and dry before sealing – use Loctite® 7013
■ Anaerobic products cure between metal surfaces in the absence of air
■ Use activator Loctite® 7240 in cold conditions to speed up the cure

Loctite® 5203
Recommended for coating and re-using gaskets to improve sealing.
Low strength metal/metal sealing.

Loctite® 5208
(Alternative to Loctite® 574)
Recommended for use on rigid metal parts e.g. cast iron components and pump housings, etc.

Loctite® 518
Recommended for use on rigid iron, steel and aluminium flanges.
P1 NSF Reg. No.: 122758
Certified to ANSI/NSF Standard 61.

Loctite® 510
Sealing rigid flanges
Recommended for applications where high temperature and chemical resistance is needed.
P1 NSF Reg. No.: 123007

Loctite® 5910
Replacement for cork and paper cut gaskets on flanges and stampd sheet metal covers.
Recommended for use where high vibration or flexing occurs. Can also be used with plastic and painted parts.

Loctite® 5699
Recommended for sealing all types of flanges including stamped sheet metal where water glycol resistance is required.
P1 NSF Reg. No.: 122998
Retaining –
Securing Cylindrical Assemblies

- High and moderate strength products - can carry high loads and eliminate fretting
- Fill all voids - prevent corrosion
- Reduce the need for close tolerances
- 100% contact - load and stress is distributed evenly over the joint

Is the assembly very loose or badly worn?

Handy Hints:
- If the retainer will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator)
- All parts must be clean & dry before sealing – use Loctite® 7063
- If the parts have been in contact with washing or cutting fluids containing nickel, wash with hot water
- Can also be used to increase the strength of existing designs

<table>
<thead>
<tr>
<th>Solution</th>
<th>Strength Required</th>
<th>Handling Strength</th>
<th>Diametrical Clearance</th>
<th>Temperature Resistance</th>
<th>Pack Sizes</th>
</tr>
</thead>
<tbody>
<tr>
<td>660 with Activator 7240</td>
<td>High</td>
<td>20 min.</td>
<td>Up to 0.5 mm</td>
<td>150 °C</td>
<td>50 ml</td>
</tr>
<tr>
<td>641</td>
<td>Moderate</td>
<td>30 min.</td>
<td>Up to 0.1 mm</td>
<td>150 °C</td>
<td>10 ml, 50 ml, 250 ml</td>
</tr>
<tr>
<td>648</td>
<td>High</td>
<td>5 min.</td>
<td>Up to 0.15 mm</td>
<td>175 °C</td>
<td>50 ml, 250 ml</td>
</tr>
<tr>
<td>638</td>
<td>High</td>
<td>5 min.</td>
<td>Up to 0.25 mm</td>
<td>150 °C</td>
<td>50 ml, 250 ml</td>
</tr>
<tr>
<td>603 (improved 601)</td>
<td>High</td>
<td>10 min.</td>
<td>Up to 0.1 mm</td>
<td>150 °C</td>
<td>10 ml, 50 ml, 250 ml</td>
</tr>
</tbody>
</table>

Solution for retaining close fitting cylindrical parts (up to 0.1 mm gap).
For use on cylindrical fitting parts where thorough degreasing is not possible.
Tested and approved for use on bearings.

Loctite® 660
(Use with Activator Loctite® 7240)
Used for repairing worn coaxial parts without remachining. Enables re-use of worn bearing seats, keys, splines, tapers, or for retaining shims.
P1 NSF Reg. No.: 123704

Loctite® 641
Recommended for parts that will need subsequent dismantling, i.e. retention of bearings onto shafts and into housings.

Loctite® 648
Recommended for high temperature retaining of parts with a clearance or interference fit, i.e. retaining bushes, bearings, seals, fans, and liners.

Loctite® 638
Gives best resistance to dynamic, axial and radial loads.
Recommended for retaining shafts, gears, pulleys, and similar cylindrical parts.
P1 NSF Reg. No.: 123010

Loctite® 603
(Improved Loctite® 601)
For retaining close fitting cylindrical parts (up to 0.1 mm gap).
For use on cylindrical fitting parts where thorough degreasing is not possible.
Tested and approved for use on bearings.
P1 NSF Reg. No.: 123003
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

Are you bonding “difficult to bond” rubber or plastic?
e.g. polyethylene, polypropylene, PTFE, thermoplastic rubbers such as Santoprene®

Handy Hints:
- To improve adhesion to difficult to bond materials e.g. PE, PP, PTFE, Santoprene® or thermoplastic rubbers; in combination with Loctite® 401, 406, 431, 404 or 480 - use Primer Loctite® 7239

<table>
<thead>
<tr>
<th></th>
<th>Yes</th>
<th>No</th>
</tr>
</thead>
<tbody>
<tr>
<td>Do any of the following apply?</td>
<td>Is the gap over 0.1 mm?</td>
<td>Do you require a non-drip/non-run product?</td>
</tr>
<tr>
<td></td>
<td>Is the bond going to be subject to shock or peel loads?</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Bonding flexible materials</td>
<td></td>
</tr>
</tbody>
</table>

Solution

<table>
<thead>
<tr>
<th></th>
<th>406 with Primer 7239</th>
<th>454</th>
<th>480</th>
<th>4850</th>
<th>4062</th>
<th>401</th>
<th>431</th>
</tr>
</thead>
<tbody>
<tr>
<td>Operating Temperature</td>
<td>Up to 80 °C</td>
<td>Up to 80 °C</td>
<td>Up to 100 °C</td>
<td>70 °C</td>
<td>Up to 80 °C</td>
<td>Up to 80 °C</td>
<td>Up to 80 °C</td>
</tr>
<tr>
<td>Fixture Time</td>
<td>10-20 sec.</td>
<td>5-20 sec.</td>
<td>60-120 sec.</td>
<td>5-20 sec.</td>
<td>3-20 sec.</td>
<td>5-20 sec.</td>
<td>5-20 sec.</td>
</tr>
<tr>
<td>Viscosity mPa.s</td>
<td>20 Gel</td>
<td>300</td>
<td>400</td>
<td>110</td>
<td>1000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Especially for</td>
<td>Plastics</td>
<td>Porous Substrates</td>
<td>Metal/Plastics</td>
<td>Flexible Substrates</td>
<td>Metal/Plastics</td>
<td>Porous Substrates</td>
<td>Porous Substrates</td>
</tr>
<tr>
<td>Pack Sizes</td>
<td>20 g, 500 g</td>
<td>10 g, 20 g, 300 g, 300 g cartridge</td>
<td>20 g, 500 g</td>
<td>20 g, 500 g</td>
<td>20 g, 500 g</td>
<td>3 g, 20 g, 50 g, 500 g</td>
<td>20 g, 500 g</td>
</tr>
</tbody>
</table>

Applications Examples

- **Loctite® 406**: Rapid bonding of rubbers (including EPDM, plastics and elastomers), when used with Loctite® 7239 Polystyrene Primer bonds “difficult to bond” plastics.
- **Loctite® 454**: General purpose gel for bonding metals, composite materials, wood, cork, foam, leather, card, paper, and unglazed ceramics. Recommended for use on vertical or overhead surfaces. P1 NSF Reg. No.: 123009
- **Loctite® 480**: Black, rubber toughened grade for bonding metal to metal and metal to rubber; especially suitable with applications where high peel strength is required and/or shock loads are present.
- **Loctite® 4850**: Flexible Instant Adhesive Medium-viscosity, fast curing, transparent adhesive. Especially designed for the assembly and repair of flexible materials and components. Typical application areas: Bonding materials used in the manufacture and repair of flexible gaskets and seals, gaiters, and loudspeaker assemblies.
- **Loctite® 4062**: Ideal for very fast bonding of plastic, rubber and metal substrates.
- **Loctite® 401**: General purpose for bonding most substrates such as plastics, rubber, metals, card, wood. P1 NSF Reg. No.: 123011
- **Loctite® 431**: Particularly suitable for bonding porous or absorbent materials such as: wood, paper, leather, cork and fabric.
UV Bonding

- Fast and on-command curing
- Rapid fixture after alignment or repositioning of parts
- Clear bond line
- High strength and excellent humidity resistance

What is your transparent substrate?

<table>
<thead>
<tr>
<th>Handy Hints:</th>
<th>Plastic</th>
<th>Glass</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. One of the parts being bonded must be UV-transparent</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Henkel Loctite provides a full range of UV curing equipment</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Solution</th>
<th>Operating Temperature</th>
<th>Fixturing time</th>
<th>Viscosity mPa.s</th>
<th>Pack sizes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Loctite® 302</td>
<td>+100 °C</td>
<td>1-10 sec.</td>
<td>100</td>
<td>250 ml</td>
</tr>
<tr>
<td>Loctite® 322</td>
<td>+100 °C</td>
<td>1-10 sec.</td>
<td>5,800</td>
<td>250 ml</td>
</tr>
<tr>
<td>Loctite® 350</td>
<td>+120 °C</td>
<td>5-20 sec.</td>
<td>5,500</td>
<td>250 ml</td>
</tr>
<tr>
<td>Loctite® 352</td>
<td>Up to 120 °C</td>
<td>5-20 sec.</td>
<td>19,500</td>
<td>250 ml</td>
</tr>
</tbody>
</table>

Fixturing time is dependent on type of lamp and intensity as well as application details.

Handy Hints:

- One of the parts being bonded must be UV-transparent
- Henkel Loctite provides a full range of UV curing equipment

Application Examples

- Loctite® 302: Low viscosity fast curing clear UV curing adhesive. Especially designed for post-application. Recommended for plastics to themselves, metal and glass.
- Loctite® 322: Medium viscosity fast curing clear UV curing adhesive. Highly transparent. Recommended for plastics to themselves, metal and glass.
# Structural Bonding

- Bonds a wide variety of materials such as wood, metals, hard plastics and glass
- Provides a tough and resilient joint
- Have high shear and peel strength

## What is the bond gap?

<table>
<thead>
<tr>
<th>Solution</th>
<th>330/7388</th>
<th>3421</th>
<th>3430</th>
<th>3450</th>
<th>3425</th>
</tr>
</thead>
<tbody>
<tr>
<td>Operating Temp.</td>
<td>Up to 100 °C</td>
<td>Up to 100 °C</td>
<td>Up to 100 °C</td>
<td>Up to 100 °C</td>
<td>Up to 100 °C</td>
</tr>
<tr>
<td>Paintable</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td>Maximum Gap</td>
<td>Up to 0.5 mm</td>
<td>Up to 1 mm</td>
<td>Up to 1 mm</td>
<td>Up to 3 mm</td>
<td>Up to 3 mm</td>
</tr>
<tr>
<td>Cure Method</td>
<td>Activator 7388</td>
<td>Two component</td>
<td>Two component</td>
<td>Two component</td>
<td>Two Component</td>
</tr>
<tr>
<td>Fixture Time</td>
<td>&lt;5 min.</td>
<td>210 min.</td>
<td>12 min.</td>
<td>12 min.</td>
<td>150 min.</td>
</tr>
<tr>
<td>Consistency</td>
<td>Gel</td>
<td>Thick liquid</td>
<td>Thick liquid</td>
<td>Gel</td>
<td>Gel</td>
</tr>
<tr>
<td>Especially for</td>
<td>Metal, plastics, glass</td>
<td>Metal, wood</td>
<td>Metal, glass</td>
<td>Metal, wood</td>
<td>Metal, rigid plastics</td>
</tr>
<tr>
<td>Pack Sizes</td>
<td>50 ml/18 ml kit, 315 ml cartridge</td>
<td>2x0.9 litre tins</td>
<td>24 ml twin syringe (manual mixing)</td>
<td>2x0.9 litre tins</td>
<td>2x0.9 litre Tins</td>
</tr>
<tr>
<td>Dual Cartridge</td>
<td>-</td>
<td>50 ml, 200 ml</td>
<td>24 ml</td>
<td>25 ml</td>
<td>50 ml, 200 ml</td>
</tr>
</tbody>
</table>

## Handy Hints:
- All parts must be clean & dry before bonding – use Loctite® 7063
- For slow curing products, clamp during cure
- For maximum peel and impact resistance use Loctite® 330 MULTI-BOND®

## Application Examples

- **Loctite® 330/7388 MULTI-BOND® 50 ml Kit**
  - Two part no mix fast curing toughened adhesive with good solvent, moisture, impact resistance, and good peel strength.
  - High viscosity. Good chemical resistance and high impact resistance. Suitable for rigid plastics such as GRP (Glass Re-enforced Plastic) and SMC (Sheet Moulding Compound).

- **Loctite® 3421 Multi-purpose**
  - Slow-curing adhesive. Excellent humidity and water resistance. Very high shear strength long working life. Ideal for bonding large surfaces and parts which need careful alignment.

- **Loctite® 3430 Clear**
  - Two part mix adhesive for bonding rigid transparent parts. Recommended for repairing parts where clarity is important.

- **Loctite® 3450 Metal coloured**
  - General purpose adhesive for large (3 mm) bond gaps. High viscosity. Good chemical resistance and heat ageing properties. Ideal for bonding metal surfaces.

- **Loctite® 3425 Toughened**
  - High viscosity, toughened adhesive for bond gaps up to 3 mm. High shear strength, Good chemical and humidity resistance. Suitable for rigid plastics such as GRP (Glass Re-enforced Plastic) and SMC (Sheet Moulding Compound).
Flexible Sealing and Bonding

- Withstand impact shock and bonding
- Resist thermal expansion and contraction as well as vibration
- Have very good gap fill
- Wide temperature range
- Good weathering resistance

Loctite® 5145 Flexible non-corrosive electrical grade Adhesive/Sealant
- Low odour, neutral cure that does not corrode electrical and electronic components.

Loctite® 5399 Flexible high temperature Adhesive/Sealant
- Suitable for bonding and sealing glass, metal, and ceramics, where temperature can reach 350°C, e.g., sealing of stove flues, chimneys, industrial ovens, and ventilation systems.

Are you sealing electrical items?

<table>
<thead>
<tr>
<th>Yes</th>
<th>No</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Do you require high temperature resistance?</td>
</tr>
<tr>
<td></td>
<td>Up to 250°C</td>
</tr>
<tr>
<td></td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>If a higher strength sealer and/or paintability is required</td>
</tr>
<tr>
<td></td>
<td>No</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Operating Temperature</th>
<th>Paintable</th>
<th>Cure Method</th>
<th>Skin Over Time</th>
<th>Viscosity</th>
<th>Especially for</th>
<th>Colour Variations</th>
<th>Pack Sizes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Up to 200°C</td>
<td>No</td>
<td>Moisture</td>
<td>70 min.</td>
<td>Paste</td>
<td>Electrical components</td>
<td>Translucent</td>
<td>40 ml kit, 300 ml</td>
</tr>
<tr>
<td>Up to 250°C</td>
<td>No</td>
<td>Moisture</td>
<td>5 min.</td>
<td>Liquid</td>
<td>Glass</td>
<td>5366 - Clear</td>
<td>310 ml</td>
</tr>
<tr>
<td>350°C</td>
<td>No</td>
<td>Moisture</td>
<td>8 - 10 min.</td>
<td>Paste</td>
<td>Sealing/Potting</td>
<td>5367 - White</td>
<td>310 ml</td>
</tr>
<tr>
<td>Up to 350°C</td>
<td>No</td>
<td>Moisture</td>
<td>5 min.</td>
<td>Paste</td>
<td>Oven door seals</td>
<td>Red</td>
<td>310 ml</td>
</tr>
<tr>
<td>Up to 80°C</td>
<td>Yes</td>
<td>Moisture</td>
<td>70 min.</td>
<td>Paste</td>
<td>heat source sealing</td>
<td>Red</td>
<td>310 ml</td>
</tr>
<tr>
<td>Up to 100°C</td>
<td>Yes</td>
<td>Moisture</td>
<td>15 min.</td>
<td>Paste</td>
<td>Flexible, medium strength bonds</td>
<td>5226 - Black</td>
<td>300 ml</td>
</tr>
</tbody>
</table>

Application Examples:
- **Loctite® 5145**
  - Flexible non-corrosive electrical grade Adhesive/Sealant
  - Low odour, neutral cure that does not corrode electrical and electronic components.

- **Loctite® 5366/5367/5368**
  - Flexible Adhesive
  - Cures to a flexible rubber.
  - Recommended for bonding, sealing and protecting components subjected to vibration.
  - Suitable for glass, metal, ceramics, composites, and most plastics.

- **Loctite® 5398**
  - Flexible Adhesive/Sealant
  - Food grade
  - Recommended for sealing heat exchangers, steam circuits, water heaters, and equipment such as turbines, pumps, and other areas within the food processing environment. The product may also be used for protection and insulation of electrical boxes.

- **Loctite® 5399**
  - Flexible high temperature Adhesive/Sealant
  - Food grade
  - Suitable for bonding and sealing glass, metal, and ceramics, where temperature can reach 350°C, e.g., sealing of stove flues, chimneys, industrial ovens, and ventilation systems.

- **Loctite® 5221/5225/5226**
  - Flexible Adhesive/Sealant
  - Paintable, with good chemical resistance.
  - Recommended for bonding materials with different coefficients of thermal expansion.
  - See handy hints.

- **Loctite® 5069**
  - MS Polymer Adhesive/Sealant
  - Permanently join and seal bare and painted metals, plastics, wood, and many other materials, without the need for primers.
  - Good UV resistance.

- **Loctite® 5065-Black**
  - Medium: 5064-White
  - High Strength: 5069-Black

Handy Hints:
- To improve adhesion of Loctite® 5221/5225/5226 use the following primers:
  - Loctite® 7251 - Glass
  - Loctite® 7252 - Plastic and paint
  - Loctite® 7253 - Metal
## Lubrication - Oils

- Prevent seizing and galling during assembly and operation
- Inhibit corrosion and oxidation in chemically and thermally aggressive environments
- Penetrate and free corroded assemblies

### Application Examples

**Loctite® 8001**
Food grade mineral oil spray
- Food approved
- Multi-purpose penetrating oil
- Used in the food, pharmaceutical, and textile industries.
- Ideal for lubricating valve seats, collars, chains, hinges, cutting links in food transport equipment, and sewing machines.

**Loctite® 8011**
High temperature chain oil spray
- Not available in UK
- Oxidation resistance prolongs lubricant service life.
- Used for lubricating of open mechanisms, conveyors, and chains at elevated temperatures up to 250°C.

**Loctite® 8018**
Solvo Rust
- Releases rusted, corroded, and seized components.
- A penetrating oil to free rusted nuts, bolts, screws, fittings, other fasteners, as well as metal components in industrial equipment.
- Also recommended for cleaning parts before lubrication and as light lubricant and rust inhibitor.

**Loctite® 8021**
Silicone oil
- Ideal for lubricating plastics and elastomers.
- NSF Reg. No.: 122978

**Loctite® 8031**
Cutting oil
- Not available in UK
- Oxidation resistance prolongs lubricant service life.
- Suitable for lubrication of open mechanisms, conveyors, and chains at elevated temperatures up to 250°C.

**Loctite® 8201**
Five way spray
- Free, lubricates, cleans.
- Ideal for light lubrication of metals and freezing assemblies.

### Lubrication - Oils Table

<table>
<thead>
<tr>
<th>Solution</th>
<th>8001</th>
<th>8011</th>
<th>8018</th>
<th>8021</th>
<th>8031</th>
<th>8201</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Appearance</strong></td>
<td>Colourless</td>
<td>Colourless</td>
<td>Colourless</td>
<td>Colourless</td>
<td>Colourless</td>
<td>Light yellow liquid</td>
</tr>
<tr>
<td><strong>Base Oil and Additives</strong></td>
<td>Mineral oil</td>
<td>Synthetic</td>
<td>Mineral Silicone</td>
<td>Mineral Silicone</td>
<td>Mineral Silicone</td>
<td>Mineral</td>
</tr>
<tr>
<td><strong>Viscosity</strong></td>
<td>11 mm²/s</td>
<td>11 mm²/s</td>
<td>&lt; 100 mPa.s</td>
<td>350 mPa.s</td>
<td>46 mm²/s</td>
<td>17.5 mm²/s</td>
</tr>
<tr>
<td><strong>Temperature Range</strong></td>
<td>-20 to +120 °C</td>
<td>-20 to +120 °C</td>
<td>N.A.</td>
<td>-30 to +50 °C</td>
<td>N.A.</td>
<td>-20 to +120 °C</td>
</tr>
<tr>
<td><strong>Load Test 4 Ball N</strong></td>
<td>1800</td>
<td>1260</td>
<td>N.A.</td>
<td>N.A.</td>
<td>5000</td>
<td>–</td>
</tr>
<tr>
<td><strong>Pack Sizes</strong></td>
<td>400 ml</td>
<td>400 ml</td>
<td>300 ml</td>
<td>400 ml aerosol</td>
<td>400 ml aerosol</td>
<td>400 ml aerosol</td>
</tr>
</tbody>
</table>
### Appearance
<table>
<thead>
<tr>
<th>Grease</th>
<th>White paste</th>
<th>Colourless smooth paste</th>
<th>White</th>
<th>Beige high tack paste</th>
<th>Black smooth paste</th>
<th>Amber high tack paste</th>
</tr>
</thead>
</table>

### Base Oil and Additives
|-------------|---------|----------|---------|--------------|--------------------|------------------|

### Viscosity
<table>
<thead>
<tr>
<th>Grease</th>
<th>Paste</th>
<th>Paste</th>
<th>Paste</th>
<th>Paste</th>
<th>Paste</th>
<th>Paste</th>
</tr>
</thead>
</table>

### Thickener
<table>
<thead>
<tr>
<th>Grease</th>
<th>Silica Gel</th>
<th>Inorganic Gel</th>
<th>Lithium soap complex</th>
<th>Lithium soap</th>
<th>Lithium soap</th>
</tr>
</thead>
</table>

### Drop Point
<table>
<thead>
<tr>
<th>Grease</th>
<th>None</th>
<th>290 °C</th>
<th>&gt;190 °C</th>
<th>&gt;190 °C</th>
<th>&gt;190 °C</th>
</tr>
</thead>
</table>

### N.L.G.I. Class
<table>
<thead>
<tr>
<th>Grease</th>
<th>2</th>
<th>2/3</th>
<th>2</th>
<th>2</th>
<th>2</th>
</tr>
</thead>
</table>

### Speed Characteristics
<table>
<thead>
<tr>
<th>Grease</th>
<th>DN Factor</th>
<th>-30 to +130 °C</th>
<th>-50 to +200 °C</th>
<th>-50 to +350 °C</th>
<th>-30 to +350 °C</th>
<th>-20 to +350 °C</th>
<th>-25 to +170 °C</th>
</tr>
</thead>
</table>

### Load Test 4 Ball N
<table>
<thead>
<tr>
<th>Grease</th>
<th>N.A.</th>
<th>150,000</th>
<th>500,000</th>
<th>500,000</th>
<th>N.A.</th>
</tr>
</thead>
</table>

### Pack Sizes
<table>
<thead>
<tr>
<th>Grease</th>
<th>400g</th>
<th>1 litre can</th>
<th>1600 Weld load</th>
<th>400 g cartridge</th>
<th>400 g cartridge</th>
<th>400 ml aerosol</th>
</tr>
</thead>
</table>

### Lubrication - Greases
- **Prevent seizing and galling during assembly and operation**
- **Inhibit corrosion and oxidation in chemically and thermally aggressive environments**
- **Withstand high temperatures and extreme pressures**

### Application Examples

#### **Loctite® 8015**
**Food grade grease**
- Multi-purpose:
  - White mineral grease for bearings, slides, bushes and linkages.

#### **Loctite® 8104**
**Food grade silicone grease**
- Recommended for lubrication of most elastomeric and plastic parts.
  - Food approved:
    - NSF Reg. No.: 122960.

#### **Loctite® 8105**
**Food grade mineral grease**
- (Not available in UK):
  - Lubricant for moving parts:
    - Recommended for use on equipment in food processing and pharmaceutical industries.
    - It is ideally suited for bearings, cams, valves and conveyors for food and pharmaceutical products.
    - NSF Reg. No.: 122960.

#### **Loctite® 8102**
**High performance grease**
- (Not available in UK):
  - Can be used in humid conditions and withstands heavy loads at medium and high speeds.
  - Use for lubrication of bearings, open gears and slide ways.

#### **Loctite® 8103**
**MoS₂ grease**
- (Not available in UK):
  - Typical used on cylindrical taper, roller and plain bearings.

#### **Loctite® 8101**
**Chain lubricant**
- (Not available in UK):
  - Water resistant.
  - Chain lubricant with anti-fog properties.
  - Use on open mechanisms such as chains and gears.
Lubrication - Anti-seize

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

<table>
<thead>
<tr>
<th>Solution</th>
<th>Food grade</th>
<th>Copper base up to 980 °C</th>
<th>General purpose up to 1300 °C</th>
<th>Electrical contacts</th>
<th>Assembly Paste</th>
</tr>
</thead>
<tbody>
<tr>
<td>Loctite® 8009</td>
<td>8009</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Loctite® 8007</td>
<td>8007</td>
<td>Copper up to 980 °C</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Loctite® 8152</td>
<td>8152</td>
<td>Copper paste</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Loctite® 8154</td>
<td>8154</td>
<td>MoS₂</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Loctite® 8013</td>
<td>8013</td>
<td>Black paste</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Loctite® 8007/8008</td>
<td>8007/8008</td>
<td>Dark grey paste</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

- **Food grade**
  - Loctite® 8014
    - Food grade Anti-seize-brush top
    - White, metal free Anti-seize paste
    - For use on stainless steel components in food processing and packaging
    - H1 NSF Reg. No.: 122982

- **Copper base up to 980 °C**
  - Loctite® 8007
    - CU-A® - Aerosol
  - Loctite® 8008
    - CU-A® - Brush Top
  - A general purpose Anti-seize lubricant which protects metal parts from corrosion, galling, and seizing and ensures easy dismantling
  - Do not use on stainless steel

- **General purpose up to 1300 °C**
  - Loctite® 8013
    - Heavy duty Anti-seize-brush top
    - A high purity metal free Anti-seize with excellent chemical resistance
    - Recommended for use in all power stations including nuclear plants
    - Do not use on stainless steel

- **Electrical contacts**
  - Loctite® 8009
    - Heavy duty Anti-seize-brush top
    - A high purity metal free Anti-seize pastes
    - Provides long term lubrication on all metals
    - Valuable used in petrochemical plants and where copper based Anti-seize is not permitted
    - Do not use on stainless steel

- **Assembly Paste**
  - Loctite® 8152
    - Copper paste Anti-seize (Not available in UK)
    - Ideal for static and slow moving assemblies
    - Prevents arcing making it ideal for electrical contacts, switches and isolators
    - Do not use on stainless steel

- **Assemble paste**
  - Loctite® 8154
    - Spray assembly paste with MoS₂ (Not available in UK)
    - Assists the assembly of cylindrical parts, bearings, wheels, gears, splined shafts, etc
    - Prevents fretting and galling
    - This spray protects components during the running in periods
    - MoS₂ can provide emergency lubrication
    - H1 NSF Reg. No: 122982

**Solid Lubricating Agent**
- Mineral
- Copper
- Mineral/Graphite
- Copper
- MoS₂

**Torque Coefficient**
- 1 - 0.16
- 0.16
- 0.16
- 0.16
- N.A.

**N.L.G.I. Class**
- 1
- 1
- 1
- 2
- N.A.

**Temperature Range**
- -30 to +400 °C
- up to 980 °C
- -30 to +1300 °C
- -50 to +1300 °C
- -35 to +1100 °C
- -35 to +450 °C

**Pack Sizes**
- 250 g
- Aerosol 400 ml, Brush top 500 g
- Brush top 500 g
- Brush top 500 g
- 1 litre can
- 400 ml
**Lubrication – Dry Film**

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

### Solution

<table>
<thead>
<tr>
<th></th>
<th>Lubricant up to 400 °C and Anti-seize up to 1300 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>General purpose</td>
</tr>
<tr>
<td><strong>Food grade</strong></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Lubricant up to 400 °C and Anti-seize up to 1300 °C</td>
</tr>
<tr>
<td><strong>8192</strong></td>
<td></td>
</tr>
<tr>
<td><strong>8016</strong></td>
<td></td>
</tr>
<tr>
<td><strong>8017</strong></td>
<td></td>
</tr>
<tr>
<td><strong>8191</strong></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Dry film lubricant</strong></th>
<th><strong>Appearance</strong></th>
<th><strong>Solid Lubricating Agent</strong></th>
<th><strong>Torque Coefficient</strong></th>
<th><strong>Temperature Range</strong></th>
<th><strong>Pack Sizes:</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>PTFE</td>
<td>0.06-0.12</td>
<td>-180 to +260 °C</td>
<td>400 ml aerosol</td>
</tr>
<tr>
<td><strong>8192</strong></td>
<td><strong>Food grade</strong></td>
<td>Black</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>MoS₂</td>
<td>0.06-0.12</td>
<td>-30 to +400/1300 °C</td>
<td>340 g aerosol</td>
</tr>
<tr>
<td><strong>8016</strong></td>
<td><strong>General purpose</strong></td>
<td>Black</td>
<td></td>
<td></td>
<td>500 g</td>
</tr>
<tr>
<td></td>
<td></td>
<td>MoS₂</td>
<td></td>
<td></td>
<td>400 ml aerosol</td>
</tr>
<tr>
<td><strong>8017</strong></td>
<td></td>
<td>MoS₂</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>8191</strong></td>
<td></td>
<td>MoS₂</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* on steel, nuts and bolts

### Application Examples

- **Loctite® 8192**
  - PTFE coating
  - Food approved coating.
  - Ideal for use on conveyor belts, slideways and cams.
  - H2 NSF Reg. No.: 122380

- **Loctite® 8016**
  - Moly dry film – aerosol
  - Contains MoS₂.
  - Copper-free.
  - Fast air-dries to protect sliding surfaces and slow moving parts.
  - Recommended for use in dusty environments.

- **Loctite® 8017**
  - Moly dry film-Tin
  - Contains MoS₂.
  - Copper-free.
  - Fast air-dries to protect sliding surfaces and slow moving parts.
  - Recommended for use in dusty environments.

- **Loctite® 8191**
  - MoS₂, Anti-friction coating – aerosol
  - Not available in UK.
  - Rapidly air-dries to protect surfaces from fretting and corrosion.
  - Enhances the performance of oils and greases.
# Surface Treatment and Rust Prevention

- **Stabilize existing rust**
- **Guard against corrosion**
- **Prevent electro-chemical corrosion**
- **Increase belt friction**

## Loctite® 7500 Rust Treatment
- **Description**: Converts existing rust into a stable base.
- **Cured product**: Acts as a primer ready for painting.
- **Protect surfaces from corrosion.**
- **Use on metal pipes, valves, fittings, storage tanks, fences, guard rails, conveyors, construction and agricultural equipment.**

## Loctite® 8005 Belt Dressing
- **Recommended to prevent slippage and increase friction for all types of belts.**
- **It extends belt life.**

---

### Application Examples

<table>
<thead>
<tr>
<th>Description</th>
<th>Colour</th>
<th>Temperature Range</th>
<th>Pack Sizes</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Loctite® 8005</strong></td>
<td>Liquid spray</td>
<td>-30 to +250°C</td>
<td>400 ml aerosol</td>
</tr>
<tr>
<td><strong>Belt dressing</strong></td>
<td>Colourless</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Loctite® 7500</strong></td>
<td>Matt black</td>
<td></td>
<td>1 litre can</td>
</tr>
<tr>
<td><strong>Rust treatment</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Loctite® 7800</strong></td>
<td>Grey spray</td>
<td>-50 to +550°C</td>
<td>400 ml aerosol</td>
</tr>
<tr>
<td><strong>Zinc spray shiny</strong></td>
<td>Grey</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Loctite® 7922</strong></td>
<td>Blue</td>
<td>-10 to +80°C</td>
<td>400 ml aerosol</td>
</tr>
<tr>
<td><strong>Zinc spray matt</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>(Loctite® 7922 is not available in UK.)</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Loctite® 7802</strong></td>
<td>Blue</td>
<td>-10 to +40°C</td>
<td>400 ml aerosol</td>
</tr>
<tr>
<td><strong>Varnish spray</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>(Not available in UK.)</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Loctite® 7803</strong></td>
<td>Amber</td>
<td></td>
<td>400 ml aerosol</td>
</tr>
<tr>
<td><strong>Metal protection coating</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

---

### Description Table

<table>
<thead>
<tr>
<th>Solution</th>
<th>Belt dressing</th>
<th>Rust treatment</th>
<th>Corrosion protection</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Loctite® 8005</strong></td>
<td>Liquid spray</td>
<td>Matt black</td>
<td>General purpose</td>
</tr>
<tr>
<td><strong>Loctite® 7500</strong></td>
<td>Rust treatment</td>
<td>Grey spray</td>
<td>Cathodic protection</td>
</tr>
<tr>
<td><strong>Loctite® 7800</strong></td>
<td>Zinc spray shiny</td>
<td>Grey</td>
<td>Removable</td>
</tr>
<tr>
<td><strong>Loctite® 7922</strong></td>
<td>Zinc spray matt</td>
<td>Blue</td>
<td>Non Drying</td>
</tr>
<tr>
<td><strong>Loctite® 7802</strong></td>
<td></td>
<td>-10 to +80°C</td>
<td></td>
</tr>
<tr>
<td><strong>Loctite® 7803</strong></td>
<td></td>
<td>-10 to +40°C</td>
<td></td>
</tr>
</tbody>
</table>

---

### Application Details

- **Loctite® 8005 Belt dressing**: Recommended to prevent slippage and increase friction for all types of belts. It extends belt life.
- **Loctite® 7500 Rust treatment**: Converts existing rust into a stable base. Cured product acts as a primer ready for painting. Protects surfaces from corrosion. Use on metal pipes, valves, fittings, storage tanks, fences, guard rails, conveyors, construction and agricultural equipment.
- **Loctite® 7800 Zinc spray shiny**: Easy to remove coating that provides long term protection. Protects equipment such as cutting and stamping tools in perfect condition during indoor and outdoor storage. Especially suitable for protecting welds from corrosion on galvanised parts.
- **Loctite® 7802 Varnish spray (Not available in UK)**: Non drying, tack free coating which provides long term corrosion protection. Is compatible with most plastics and elastomeric materials. Long term protection of metal assemblies such as moulds, machines and outdoor installations.
- **Loctite® 7803 Metal protection coating spray (Not available in UK)**: Non drying, tack free coating which provides long term corrosion protection. Is compatible with most plastics and elastomeric materials. Long term protection of metal assemblies such as moulds, machines and outdoor installations.
# Handy Hints:
- Use Loctite® 3029 Hardener
- Loctite® 3029 Hardener initiates and speeds the cure of Loctite® Polyester resin based products
- Add the hardener to the resin in the recommended proportions and mix thoroughly

---

## Repair, rebuild or join Fibre Reinforced Plastic parts

<table>
<thead>
<tr>
<th>Description</th>
<th>Glass Fibre Paste</th>
<th>Gelcoat Filler</th>
<th>Marine Filler</th>
<th>Marine Epoxy</th>
<th>Glass Fibre Resin Kit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Blue/Green</td>
<td>White</td>
<td>White</td>
<td>White/Grey</td>
<td>Semitransparent Gold</td>
</tr>
<tr>
<td>GRP*, Steel, Aluminium</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td>Enamel</td>
<td>No</td>
<td>Yes</td>
<td>No</td>
<td>No</td>
<td>No</td>
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<tr>
<td>Wood</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td>Mix Ratio by wt.</td>
<td>97 to 3</td>
<td>96 to 4</td>
<td>97 to 3</td>
<td>1 to 1</td>
<td>96 to 4</td>
</tr>
<tr>
<td>Working time</td>
<td>8 min.</td>
<td>8 min.</td>
<td>6 min.</td>
<td>15 min.</td>
<td>5 min.</td>
</tr>
<tr>
<td>Setting time at 20 °C</td>
<td>10 min.</td>
<td>10 min.</td>
<td>10 min.</td>
<td>60 min.</td>
<td>10 min.</td>
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<tr>
<td>Sandable after at 20 °C</td>
<td>20 min.</td>
<td>60 min.</td>
<td>20 min.</td>
<td>Cure time 240 min.</td>
<td>20 min.</td>
</tr>
<tr>
<td>Pack Sizes</td>
<td>165g, 750g</td>
<td>165g</td>
<td>150g, 665 g</td>
<td>150g</td>
<td>Kit</td>
</tr>
</tbody>
</table>

*GRP* – Glass Fibre Reinforced Plastic

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## Application Examples

**Loctite® 3022 Glass Fibre Paste**
- Two part, glass fibre reinforced Polyester paste.
- High strength bond for structural repair.
- Extremely water resistant.
- Sets in 10 min.; can be sanded after another 10 min.
- Recommended for repairing holes and gaps up to 50 mm in GRP®, aluminium steel and wood.

**Loctite® 3024 Gelcoat Filler**
- Two part Polyester paste.
- Can be over-painted to match topside colour schemes.
- Can be combined with Loctite® 3025 for larger repairs.
- Fully cured in 60 min., to a water-resistant, high white finish.
- Specially formulated for minor damage (osmosis blisters, scratches and small holes) in glass fibre and enamelled surface finishes.

**Loctite® 3025 Marine Filler**
- Two part paste.
- Water resistant and can be over-painted if used below the waterline.
- Paint compatible.
- Sets in 10 min.; can be machined, drilled, tapped and sanded in further 10 min.
- Recommended for filling and sealing large holes and cracks in hull materials such as glass fibre, steel, aluminium and wood.

**Loctite® 3026 Marine Epoxy**
- Two part epoxy.
- Water resistant and can be over-painted if used below the waterline.
- Paint compatible.
- Sets in 60 min., fully cured in 4 hrs.
- Do not apply a polyester directly to Loctite® 3026 Marine Epoxy. Seal the epoxy surface first, using a primer paint. Ideal for between-tides repairs to ferrocement and fibre-reinforced hulls, will also repair wood, steel, stainless steel, cast iron and aluminium components.

**Loctite® 3028 Glass Fibre Resin Kit**
- Two part Polyester resin with reinforcing glass fibre mat.
- The kit contains resin, hardener, glass fibre mat, mixing cup, spatula and brush.
- Sets in 10 min.; fully cured after 30 min.
- Recommended for joining different materials such as wooden bulhead to GRP® hulls or metals and plastics. Enables the formation of a tough, gap-filling fillet where stiffeners and panels are pinned.
Metal-filled Compounds

- High compressive strength
- Choice of mild steel, aluminium or non-metallic fillers
- Can be machined, drilled or tapped after cure
- Excellent resistance to aggressive chemicals

**Repair or rebuild damaged parts?**

<table>
<thead>
<tr>
<th>Solution</th>
<th>Steel liquid</th>
<th>Steel putty</th>
<th>Fast set steel putty</th>
<th>Metal Magic Steel™ stick</th>
<th>Aluminium liquid</th>
<th>Aluminium putty</th>
<th>Superior metal putty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Description</td>
<td>Steel liquid</td>
<td>Steel putty</td>
<td>Fast set steel putty</td>
<td>Metal Magic Steel™ stick</td>
<td>Aluminium liquid</td>
<td>Aluminium putty</td>
<td>Superior metal putty</td>
</tr>
<tr>
<td>Colour</td>
<td>Grey</td>
<td>Grey</td>
<td>Grey</td>
<td>Dark grey</td>
<td>Light grey</td>
<td>Light grey</td>
<td>Grey</td>
</tr>
<tr>
<td>Maximum Temperature</td>
<td>105 °C</td>
<td>105 °C</td>
<td>90 °C</td>
<td>120 °C</td>
<td>90 °C</td>
<td>90 °C</td>
<td>120 °C</td>
</tr>
<tr>
<td>Mix Ratio by Vol</td>
<td>4 to 1</td>
<td>2.5 to 1</td>
<td>1 to 1</td>
<td>5 to 1</td>
<td>4 to 1</td>
<td>4 to 1</td>
<td></td>
</tr>
<tr>
<td>Working Time</td>
<td>25 min.</td>
<td>30 min.</td>
<td>3 min.</td>
<td>3 min.</td>
<td>20 min.</td>
<td>20 min.</td>
<td></td>
</tr>
<tr>
<td>Cure Time</td>
<td>6 hrs</td>
<td>6 hrs</td>
<td>10 min.</td>
<td>10 min.</td>
<td>6 hrs</td>
<td>6 hrs</td>
<td></td>
</tr>
<tr>
<td>Pack Sizes</td>
<td>1 kg Kit</td>
<td>1 kg Kit</td>
<td>1 kg Kit</td>
<td>114 g stick</td>
<td>1 kg Kit</td>
<td>1 kg Kit</td>
<td></td>
</tr>
</tbody>
</table>

**Application Examples**

- **Loctite® 3461**: Steel liquid
  - High steel content, pourable filler. Can be used for making fixtures and mouldings.

- **Loctite® 3460**: Steel putty
  - High steel content putty. Recommended for repairing and rebuilding worn steel components, such as bearings and fan housings.

- **Loctite® 3462**: Fast set steel putty
  - A fast setting version of steel putty. Recommended for repairing pipes and other emergency repairs.

- **Loctite® 3463**: Metal Magic Steel™ stick
  - A fast setting two-part paste. Excellent for repairing and rebuilding worn steel components. Can be used on damp surfaces.

- **Loctite® 3466**: Aluminium liquid
  - Fluid, self-leveling aluminium filler. Can be poured into moulds and cavities. Recommended for casting replacement parts and for making moulds.

- **Loctite® 3465**: Aluminium putty
  - General purpose, aluminium putty for repair of all-aluminium alloy components.

- **Loctite® 3464**: Superior metal putty
  - Metal-free filler with high compressive strength and chemical resistance. Recommended for use on all metals.
**Wearing Compounds**

- Restores worn surfaces
- Wear resistant coating
- Use on new parts to extend life
- Available in both trowelable and brushable forms

---

**Repair or rebuild worn surfaces**

<table>
<thead>
<tr>
<th>Solution</th>
<th>High temperature up to 230 °C</th>
<th>High impact</th>
<th>High temperature up to 230 °C</th>
<th>High temperature up to 205 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>7230</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>7219</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>7229</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>7234</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Description**
- High temperature wearing compound
- High impact wearing compound
- High temperature pneu wear
- High temperature brushable ceramic

<table>
<thead>
<tr>
<th>Colour</th>
<th>Grey</th>
<th>Grey</th>
<th>Grey</th>
<th>Grey</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum Temperature</td>
<td>230 °C</td>
<td>120 °C</td>
<td>230 °C</td>
<td>205 °C</td>
</tr>
<tr>
<td>Mix Ratio by Volume</td>
<td>4 to 1</td>
<td>2 to 1</td>
<td>4 to 1</td>
<td>2.75 to 1</td>
</tr>
<tr>
<td>Working Time</td>
<td>30 min.</td>
<td>30 min.</td>
<td>30 min.</td>
<td>30 min.</td>
</tr>
<tr>
<td>Cure Time</td>
<td>7 to 9 hrs*</td>
<td>6 hrs</td>
<td>6 to 8 hrs*</td>
<td>8 to 14 hrs*</td>
</tr>
<tr>
<td>Pack Sizes</td>
<td>10 kg Kit</td>
<td>1 kg Kit</td>
<td>10 kg Kit</td>
<td>1 kg Kit</td>
</tr>
</tbody>
</table>

* Require heat cure for maximum temperature resistance

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**Application Examples**

- **Loctite® 7230**
  - High temperature wearing compound
  - Trowelable compound that protects against sliding abrasion.
  - Use to rebuild and protect chutes, pump housings, elbows, cyclones and material handling equipment.

- **Loctite® 7219**
  - High impact wearing compound
  - Toughened adhesive absorbs impacts.
  - Recommended where both sliding abrasion and impacts are present.

- **Loctite® 7229**
  - High temperature pneu wear
  - Resists fine particle abrasion caused in pipe elbows of pneumatic conveyors systems.

- **Loctite® 7234**
  - High temperature brushable ceramic
  - Smooth, wear resistant, low friction coating to combat turbulence and cavitation on components such as pump housings and impellers.
Cleaning

Clean components prior to using Henkel Loctite Adhesives/Sealants

- Clean and degrease worktops and parts
- Remove cured Sealant residue
- The hand cleaner sub-section includes two very effective, gentle and biodegradable hand cleaners

### Hand cleaners

- **Loctite® 7039 Contact cleaner spray**
  - Does not affect insulating varnishes.
  - For cleaning electrical contacts, relays, switchgear etc. without affecting insulating varnishes.
  - Displaces moisture and forms a water repellent film.

- **Loctite® 7063 Cleaner & degreaser**
  - General parts cleaner which leaves no residue - ideal for use prior to adhesive bonding and sealing applications.
  - Compatible with metal, glass, rubber, most plastics and painted surfaces.

- **Loctite® 7200 Gasket remover**
  - Removes cured gasket sealants and traditional gaskets from most types of surfaces in 10 to 15 minutes without scraping.

- **Loctite® 7063 Cleaner & degreaser**
  - General parts cleaner which leaves no residue - ideal for use prior to adhesive bonding and sealing applications.
  - Compatible with metal, glass, rubber, most plastics and painted surfaces.

- **Loctite® 7044 U-PVC pipe cleaner**
  - Biodegradable, solvent free, non-toxic and non flammable, diluted with water.
  - Rated UFA-C1.
  - Removes grease, oil, cutting fluids and workshop grime.

### Parts/surface cleaners

- **Loctite® 7840 Cleaner & degreaser**
  - Biodegradable, solvent free, non-toxic and non flammable, diluted with water.
  - Rated USFA-C1.
  - Removes grease, oil, cutting fluids and workshop grime.

### Large surfaces i.e. worktops

- **Loctite® 7850 Hand cleaner**
  - Hand cleaner made from natural extracts and free from mineral oils.
  - Biodegradable. Contains premium skin conditioners.
  - Works with or without water.
  - Removes ground-in dirt, grease, grime, and oil.

- **Loctite® 7855 Hand cleaner**
  - Hand cleaner made from natural extracts and free from mineral oils.
  - Biodegradable. Contains premium skin conditioners.
  - Works with or without water.
  - Removes ground-in dirt, grease, grime, and oil.

### Application Examples

- **Loctite® 7855 Hand cleaner**
  - Removes paint, resin and adhesives.
  - Biodegradable and non toxic.

- **Loctite® 7850 Hand cleaner**
  - Hand cleaner made from natural extracts and free from mineral oils.
  - Biodegradable. Contains premium skin conditioners.
  - Works with or without water.
  - Removes ground-in dirt, grease, grime, and oil.

- **Loctite® 7039 Contact cleaner spray**
  - Does not affect insulating varnishes.
  - For cleaning electrical contacts, relays, switchgear etc. without affecting insulating varnishes.
  - Displaces moisture and forms a water repellent film.

- **Loctite® 7200 Gasket remover**
  - Removes cured gasket sealants and traditional gaskets from most types of surfaces in 10 to 15 minutes without scraping.

- **Loctite® 7063 Cleaner & degreaser**
  - General parts cleaner which leaves no residue - ideal for use prior to adhesive bonding and sealing applications.
  - Compatible with metal, glass, rubber, most plastics and painted surfaces.

- **Loctite® 7044 U-PVC pipe cleaner**
  - Biodegradable, solvent free, non-toxic and non flammable, diluted with water.
  - Rated UFA-C1.
  - Removes grease, oil, cutting fluids and workshop grime.

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*For best product performance clean parts with Loctite® 7063 prior to adhesive application*
# Surface Preparation –
## Activators and Primers

- Accelerate cure of Henkel Loctite products even at low temperatures
- Improve adhesion to non-wetting surfaces

## Do you need an activator or primer?

- Improve adhesion to specific surfaces
- Improve adhesion to difficult-to-bond materials e.g. PE, PP, PTFE, Santoprene* or thermoplastic rubbers
- Increase cure speed of Instant Adhesives such as, 401, 406, 431, 454, 480 or 4850

### Solution

<table>
<thead>
<tr>
<th>Description</th>
<th>Primer</th>
<th>Primer</th>
<th>Primer</th>
<th>Primer</th>
<th>Activator</th>
<th>Activator</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
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<td>Colourless</td>
<td>Colourless</td>
<td>Colourless</td>
<td>Colourless</td>
</tr>
<tr>
<td>Pack Sizes</td>
<td>25 ml, 200 ml</td>
<td>25 ml, 200 ml</td>
<td>25 ml, 200 ml</td>
<td>4 ml</td>
<td>18 g pump</td>
<td>90 ml pump</td>
</tr>
</tbody>
</table>

### Application Examples

- **Primer Loctite® 7251**: Bonding/welding plastics, painted materials and wood.
- **Primer Loctite® 7252**: Bonding/welding glass & glazed materials.
- **Primer Loctite® 7253**: Bonding/welding bare metallic surfaces.
- **Loctite® 7239**: In a general purpose Primer, suitable for use on all industrial plastics, which will improve the adhesion of Instant adhesives.
- **Loctite® 7458**: Cures excess adhesive. Minimizes post cure blooming and optimizes bond strength. Low odour. Recommended for any areas where the speed of cure and aesthetics requirements are critical to ensure a neat and consistent bond line.
- **Loctite® 7240**: Is a solvent-free activator that increases cure speed on passive surfaces such as, stainless steel, aluminum and plated or passivated metals.
Emergency Repair Products

- Enables rapid repair of damaged or burst pipes, conveyor or drive belts and similar rubber-based components
- Will seal leaks in tanks and other containment vessels in addition to repairing metal parts
- Includes a kit for repairing or replacing damaged O-ring seals and a gas leak detector

Loctite® 3463 Metal Magic Steel™ stick
- Working time: 3 minutes - sets in 10 minutes.
- Adheres to damp surfaces and cures underwater.
- Chemical and corrosion resistant.
- Can be drilled, filed and painted.
- Ideal for emergency sealing of leaking tanks and pipes (i.e. lead, plastic, copper).

Loctite® 5007 PU-Foam
- Is a moisture-curing polyurethane foam, which expands to fill and seal gaps and voids.
- Recommended for sealing pipe entries in walls, insulating pipe-work and tanks, filling gaps around doors and windows, draught-proofing around pipework and cable runs.
- Cured material can be machined, sanded and painted.

Loctite® O-Ring Kit
- Saves the need for complete disassembly.
- Eliminates the need for an inventory of different sized O-rings, joints resist water 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 underwater.
- Chemical and corrosion resistant.
- Can be drilled, filed and painted.
- Ideal for emergency sealing of leaking tanks and pipes (i.e. lead, plastic, copper).

Loctite® 7100 Leak Detector
- Facilitates the detection of both micro-leaks and larger leaks in gas handling systems.
- It will not cause subsequent corrosion and is recommended for use with all gases and gas mixtures except pure oxygen.

Loctite® 5070 Pipe Repair Kit
- Repairs pipe leaks in 1 hour.
- No tools required.
- Maximum temperature: 120°C.
- Easy-to-use repair kit.

Loctite® 3902 Rapid Rubber Repair Kit
- Fast, long-term repairs of rubber materials.
- Remains flexible.
- Easy application.

Handy Hints:
- Use Rapid Rubber Repair Gun with product Loctite® 3902
Equipment

Henkel Loctite dispensing equipment is specially designed to make application and use of Henkel Loctite products fast, precise, clean and economical. The following is a selection, from an extensive equipment range, of items most relevant to the products in this guide.

Loctite® 97001 Peristaltic Hand Pump
This hand-held applicator is a low-cost, precision bottle top applicator that mounts easily on the top of any Loctite® 50 ml or 250 ml bottle.

Loctite® 97002 Hand-Held Cartridge Dispenser System
This is a fully-integrated system that will dispense products from water-thin to paste-thick from 30 ml plastic syringes.

Loctite® 97006 Digital Syringe Applicator (pneumatic)
Dispenses all Henkel Loctite products packaged in a 250 ml squeeze tube or in a 300 ml cartridge.

Loctite® 97262 Needle Selection Pack
Selection of dispensing needles which are used for the application of Henkel Loctite products.

Loctite® 96001 Mixpac 50
Mixpac DM 200-01 Epoxy Twin Syringe Dispenser
Automatically mixes Loctite® structural adhesives in their correct proportions. Application is done without waste, in quantities determined by production needs.

Loctite® 97008 Semi-automatic Controller

Loctite® 97009 Semi-automatic Controller
Fully integrated semi-automatic adhesive dispensing systems.

Loctite® 97121 Pinch Valve Applicator
A pinch-valve with a pneumatic actuator for use with Loctite® 97008 and 97029.

Loctite® 97261 Rapid Rubber Repair Gun
Easy to use applicator for the Rapid Rubber Repair Kit.

Loctite® 96003 Mixpac DM 200-01 Epoxy Twin Syringe Dispenser

Equipment Ordering Information

Look for Henkel Loctite Product number on these pages!

<table>
<thead>
<tr>
<th>Pr.-No.</th>
<th>Product Name</th>
<th>Pack-Size</th>
<th>Order-No.</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>222</td>
<td>Threadlocker, Low Strength*</td>
<td>12x25ml</td>
<td>0301314</td>
<td>11</td>
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<td>223</td>
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<tr>
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Product Ordering Information

[Image] Products with NSF approval
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<th>Pack-Size</th>
<th>Order-No.</th>
<th>Page</th>
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</thead>
<tbody>
<tr>
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<td>3028</td>
<td></td>
<td></td>
<td>36</td>
</tr>
<tr>
<td><strong>Semi-automatic Dispenser</strong></td>
<td>3029</td>
<td></td>
<td></td>
<td>36</td>
</tr>
<tr>
<td><strong>Small Parts Cleaner</strong></td>
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**Please contact Henkel Loctite for further product information.**