PRODUCT DESCRIPTION
LOCTITE® 2701 provides the following product characteristics:

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Technology</td>
<td>Acrylic</td>
</tr>
<tr>
<td>Chemical Type</td>
<td>Dimethacrylate ester</td>
</tr>
<tr>
<td>Appearance (uncured)</td>
<td>Green liquid MS</td>
</tr>
<tr>
<td>Fluorescence</td>
<td>Positive under UV light MS</td>
</tr>
<tr>
<td>Components</td>
<td>One component - requires no mixing</td>
</tr>
<tr>
<td>Viscosity</td>
<td>Low</td>
</tr>
<tr>
<td>Cure</td>
<td>Anaerobic</td>
</tr>
<tr>
<td>Secondary Cure</td>
<td>Activator</td>
</tr>
<tr>
<td>Application</td>
<td>Threadlocking</td>
</tr>
<tr>
<td>Strength</td>
<td>High</td>
</tr>
</tbody>
</table>

LOCTITE® 2701 is designed for the permanent locking and sealing of threaded fasteners. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. This product is particularly suited for use on inactive substrates and/or where maximum resistance to hot oil is required.

TYPICAL PROPERTIES OF UNCURED MATERIAL
Specific Gravity @ 25 °C 1.08
Flash Point - See SDS
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):
Spindle 2, speed 20 rpm 500 to 900 MS

TYPICAL CURING PERFORMANCE
Cure Speed vs. Substrate
The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on steel pins and collars compared to different materials and tested according to ISO 10123.

Cure Speed vs. Bond Gap
The rate of cure will depend on the bondline gap. The following graph shows shear strength developed with time on steel pins and collars at different controlled gaps and tested according to ISO 10123.

Cure Speed vs. Temperature
The rate of cure will depend on the temperature. The graph below shows the shear strength developed with time at different temperatures on steel pins and collars and tested according to ISO 10123.
Cure Speed vs. Activator
Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the shear strength developed with time on zinc dichromate steel pins and collars using and tested according to ISO 10123.

TYPICAL PROPERTIES OF CURED MATERIAL
Physical Properties:
- Coefficient of Thermal Expansion, $\text{ISO } 11359-2, \text{ K}^{-1}$: $100 \times 10^{-6}$
- Coefficient of Thermal Conductivity, $\text{ISO } 8302$, W/(m·K): 0.1
- Specific Heat, kJ/(kg·K): 0.3

TYPICAL PERFORMANCE OF CURED MATERIAL
Adhesive Properties
- After 24 hours @ 22 °C:
  - Breakaway Torque, $\text{ISO } 10964$: M10 black oxide steel nuts and bolts: 26 to 50 N·m (230 to 440 lb.in.)
  - Prevail Torque, $\text{ISO } 10964$: M10 black oxide steel nuts and bolts: $\geq 15^{\text{MS}}$ N·m (≥132 lb.in.)
  - Breakloose Torque, $\text{ISO } 10964$, Pre-torqued to 5 N·m: M10 black oxide steel nuts and bolts: 30 to 60 N·m (265 to 530 lb.in.)
  - Max. Prevail Torque, $\text{ISO } 10964$, Pre-torqued to 5 N·m: M10 black oxide steel: 36 to 60 N·m (320 to 530 lb.in.)
- Compressive Shear Strength, $\text{ISO } 10123$: Steel pins and collars: 18 to 30 N/mm² (2,610 to 4,350 psi)

Torque Augmentation
Breakloose torque of an uncoated fastener will normally be 15 to 30% less than the on-torque. The effect of LOCTITE® 2701 on the breakloose torque is shown in the graph below.

TYPICAL ENVIRONMENTAL RESISTANCE
Cured for 1 week @ 22 °C
Breakloose Torque, $\text{ISO } 10964$, Pre-torqued to 5 N·m:
M10 zinc phosphate steel nuts and bolts

Hot Strength
Tested at temperature

Heat Aging
Aged at temperature indicated and tested @ 22 °C
Chemical/Solvent Resistance
Aged under conditions indicated and tested @ 22°C.

<table>
<thead>
<tr>
<th>Environment</th>
<th>°C</th>
<th>100 h</th>
<th>500 h</th>
<th>1000 h</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor oil (MIL-L-46152)</td>
<td>125</td>
<td>95</td>
<td>100</td>
<td>110</td>
</tr>
<tr>
<td>Gasoline</td>
<td>22</td>
<td>100</td>
<td>110</td>
<td>115</td>
</tr>
<tr>
<td>Brake fluid</td>
<td>22</td>
<td>100</td>
<td>100</td>
<td>105</td>
</tr>
<tr>
<td>Ethanol</td>
<td>22</td>
<td>95</td>
<td>95</td>
<td>95</td>
</tr>
<tr>
<td>Acetone</td>
<td>22</td>
<td>100</td>
<td>100</td>
<td>100</td>
</tr>
<tr>
<td>1,1,1 Trichloroethane</td>
<td>22</td>
<td>100</td>
<td>110</td>
<td>110</td>
</tr>
<tr>
<td>Water/glycol 50/50</td>
<td>87</td>
<td>100</td>
<td>100</td>
<td>100</td>
</tr>
</tbody>
</table>

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 Safety Data Sheet (SDS).

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 all threads with primer and allow to dry.
3. To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during application.
4. For Thru Holes, apply several drops of the product onto the bolt at the nut engagement area.
5. For Blind Holes, apply several drops of the product down the internal threads to the bottom of the hole.
6. For Sealing Applications, 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.
7. Assemble and tighten as required.

For Disassembly
1. Apply localized heat to nut or bolt 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 dated February 27, 1998. 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

- (°C x 1.8) + 32 = °F
- kV/mm x 25.4 = V/mil
- mm / 25.4 = inches
- µm / 25.4 = mil
- N x 0.225 = lb
- N/mm x 5.71 = lb/in
- N/mm² x 145 = psi
- MPa x 145 = psi
- N·m x 8.851 = lb·in
- N·m x 0.738 = lb·ft
- N·mm x 0.142 = oz·in
- mPa·s = cP

Note:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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