

# LOCTITE®



## STRENGTH ON ZINC FLAKE COATINGS

LOCTITE Health & Safety Threadlockers



LOCTITE products have always stood for maximum performance and reliability in industry. Classified as non-hazardous products that require no labeling, LOCTITE 2400 and 2700 offer users ideal protection and meet the highest occupational health and safety standards.

We have further developed these two threadlocking products to enable their use in an even wider range of applications without compromising any key properties. For technical details please refer to the following pages.

Henkel

# The New Formulation's Improvements

## LOCTITE 2400 and 2700 Now Offering Increased Cure Speed and Strength for

- Zinc flake anti corrosion coatings such as Geomet™ 500A
- Passive materials such as stainless steel and zinc dichromate

Profit by that improvement enabling a wider range of applications without compromising any key properties.

The drinking water approvals continue to be valid:

- LOCTITE 2400 – WRAS approval (BS 6920): 1104507
- LOCTITE 2700 – WRAS approval (BS 6920): 1104508

## PERFORMANCE TESTED HEAD TO HEAD VERSUS LEAD COMPETITIVE PRODUCTS

	Product	Competitive product			Best	Average	Poor
	LOCTITE 2400 New	A	B	C			
<b>Application to customer parts</b> (Thixotropic Ratio – non-drip)	●	●	●	●	● > 5	● 3–5	● < 3
<b>Cure Speed:</b> Stainless Steel in N.m (after one hour)	●	●	●	●	● > 5	● 3–5	● < 3
<b>Cure Speed:</b> Zinc Flake Coated Steel (Geomet™) in N.m (after one hour)	●	●	●	●	● > 5	● 3–5	● < 3
<b>Cure Speed:</b> Zinc-Dichromate in N.m (after one hour)	●	●	●	●	● > 5	● 3–5	● < 3
<b>Breakaway Strength:</b> Stainless Steel in N.m	●	●	●	●	● > 10	● 6–9	● < 6
<b>Breakaway Strength:</b> Zinc Flake Coated Steel (Geomet™) in N.m	●	●	●	●	● > 20	● 10–19	● < 10
<b>Breakaway Strength:</b> Zinc-Dichromate in N.m	●	●	●	●	● > 10	● 6–9	● < 6
<b>Breakaway Strength:</b> BO Mild Steel in N.m	●	●	●	●	● > 25	● 15–25	● < 15
<b>Disassembly</b> (Prevail Torque) in N.m	●	●	●	●	● < 5	● 5–6	● > 7
<b>Cure Through Gap</b> – % Retention of Strength	●	●	●	●	● > 70	● 40–60	● < 40
<b>Hot Strength (150 °C)</b> – % Retention of Strength	●	●	●	●	● > 50	● 30–40	● < 30
<b>Heat Aging (1000 H @ 150 °C)</b> – % Retention of Strength	●	●	●	●	● > 100	● 50–99	● < 50
<b>Approvals</b>	●	●	●	●	● DVGW, WRAS, German Water	● DVGW	● No approvals
<b>Health &amp; Safety (SDS)</b>	●	●	●	●	● No pictograms or product H-phrases.	● No pictograms or product H-phrases, hazardous substances mentioned in section 3 of SDS.	● Pictograms and/or H-phrases present, hazardous substances mentioned in section 3 of SDS.



Optimised Health & Safety products focusing on people safety. Enhancing safety in production, application and end-use.

### Definition of Health & Safety Products

- Health and safety products do not have pictograms in the SDS or on the label relating to health and safety.
- Products without pictograms relating to the environment are also classed as eco-friendly e.g. LOCTITE 2400/2700/5400/5800.

## PERFORMANCE TESTED HEAD TO HEAD VERSUS LEAD COMPETITIVE PRODUCTS

	Product	Competitive product				Best	Average	Poor
	LOCTITE 2700 New	A	B	C	D			
<b>Cure Speed:</b> Stainless Steel in N.m	●	●	●	●	●	● > 5	● 3-5	● < 3
<b>Cure Speed:</b> Zinc Flake Coated Steel (Geomet™) in N.m (after one hour)	●	●	●	●	●	● > 5	● 3-5	● < 3
<b>Cure Speed:</b> Zinc-Dichromate in N.m (after one hour)	●	●	●	●	●	● > 5	● 3-5	● < 3
<b>Breakaway Strength:</b> Stainless Steel in N.m (after one hour)	●	●	●	●	●	● > 10	● 5-10	● < 5
<b>Breakaway Strength:</b> Zinc Flake Coated Steel (Geomet™) in N.m	●	●	●	●	●	● > 25	● 15-25	● < 15
<b>Breakaway Strength:</b> Zinc-Dichromate in N.m	●	●	●	●	●	● > 10	● 5-10	● < 5
<b>Breakaway Strength:</b> BO Mild Steel in N.m	●	●	●	●	●	● > 37	● 15-25	● < 15
<b>Cure Through Gap –</b> % Retention of Strength	●	●	●	●	●	● > 50	● 30-50	● < 30
<b>Hot Strength (150 °C) –</b> % Retention of Strength	●	●	●	●	●	● > 75	● 50-75	● < 50
<b>Heat Aging (1000 H @ 150 °C) –</b> % Retention of Strength	●	●	●	●	●	● > 100	● 50-100	● < 50
<b>Approvals</b>	●	●	●	●	●	● DVGW, WRAS, German Water	● DVGW	● No approvals
<b>Health &amp; Safety (SDS)</b>	●	●	●	●	●	● No pictograms or product H-phrases.	● No pictograms or product H-phrases, hazardous substances mentioned in section 3 of SDS.	● Pictograms and/or H-phrases present, hazardous substances mentioned in section 3 of SDS.

## A Complete Range of LOCTITE Anaerobic Health & Safety Products

- Threadlockers
- Thread sealant
- Retaining compound for cylindrical assemblies
- Flange sealant



### TECHNICAL INFORMATION

Product	LOCTITE 2400	LOCTITE 2700	LOCTITE 5400	LOCTITE 5800	LOCTITE 6300
Application	Threadlocker	Threadlocker	Thread sealant	Flange sealant	Retaining compound for cylindrical assemblies
Strength	Medium	High	Medium	Medium	High
Colour	Fluorescent blue	Fluorescent green	Fluorescent yellow	Fluorescent red	Fluorescent green
Viscosity (Cone & Plate)	225 – 475 mPa·s	350 – 550 mPa·s	5,000 – 20,000 mPa·s	11,000 – 32,000 mPa·s	250 – 550 mPa·s
Thixotropic	Yes	No	Yes	Yes	No
Adhesive properties	25 N.m*	37 N.m*	19 N.m*	5 N/mm <sup>2</sup> **	15 N/mm <sup>2</sup> ***
Heat resistance	Up to 150°C	Up to 150°C	Up to 150°C	Up to 180°C	Up to 180°C
Packaging	5ml, 50ml, 250ml	5ml, 50ml, 250ml	50ml, 250ml	50ml, 300ml cartridge	50ml, 250ml

\* Breakaway torque, ISO 10964, M10 black oxide steel nuts and bolts

\*\* Lap shear strength, ISO 4587, sandblasted steel surfaces

\*\*\* Compressive shear strength, ISO 10123, steel shaft-hub assemblies

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