

LOCTITE[®] Essentials





LOCTITE 243

... secures bolts
from loosening.
Medium strength.



What does it do & where to use?

- General purpose, medium strength threadlocker.
- Works on all metals.
- Oil tolerant.
- Size of thread up to M36.
- Cures when confined in the absence of air between close-fitting metal surfaces.
- Service temperature range -55 to +180 °C.
- Approvals: P1 NSF.

Why use ...?

- Resistant to vibration loosening.
- Threads are completely sealed eliminating fretting corrosion.
- Clean and easy to apply.
- Replaces mechanical threadlocking devices.
- Lower costs and inventory.
- Can be disassembled with hand tools.



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1. Preparation

Cleaning

It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive.



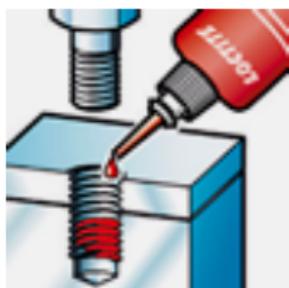
Activation

If cure speed is too slow due to passive metals or low temperature (below 5 °C), use activator LOCTITE SF 7649 (see cure speed vs. activator graph in the TDS).



2. Application

Apply liquid threadlocker on the targeted area.



Through hole:

Assemble bolt first and then apply threadlocker.

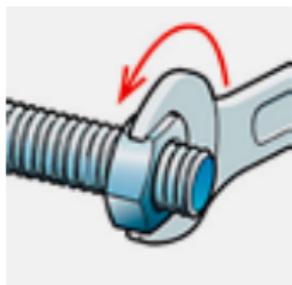
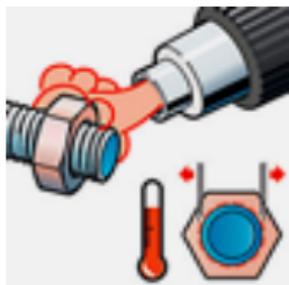
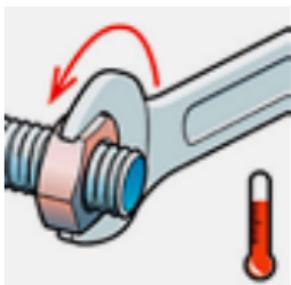
Blind hole:

Apply into lower third of blind hole.

3. Assembly

- Assemble and tighten
- If several bolts are pre-tightened first, fully tighten them within the fixture time of the product or use a slow curing product

4. Disassembly



- Disassemble with standard hand tools
- If not possible, apply localised heat to approximately 250 °C, disassemble while hot



LOCTITE 270

... secures bolts
from loosening.
High strength.



What does it do & where to use?

- General purpose, high strength threadlocker.
- Works on all metals.
- Oil tolerant.
- Size of thread up to M20.
- Cures when confined in the absence of air between close-fitting metal surfaces.
- Service temperature range -55 to +180 °C.
- Approvals: P1 NSF.

Why use ...?

- Resistant to vibration loosening.
- Threads are completely sealed eliminating fretting corrosion.
- Clean and easy to apply.
- Replaces mechanical threadlocking devices.
- Lower costs and inventory.
- Can be disassembled with hand tools.



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1. Preparation

Cleaning

It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive.



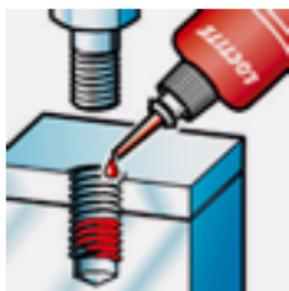
Activation

If cure speed is too slow due to passive metals or low temperature (below 5 °C), use activator LOCTITE SF 7649 (see cure speed vs. Activator graph in the TDS).



2. Application

Apply liquid threadlocker on the targeted area.



Through hole:

Assemble bolt first and then apply threadlocker.

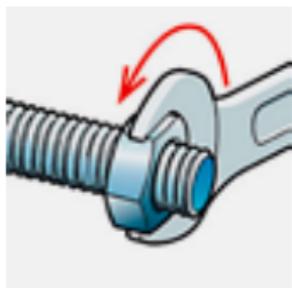
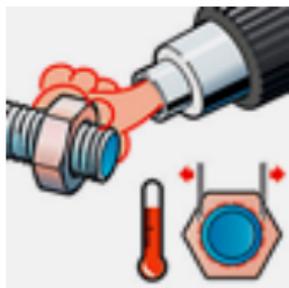
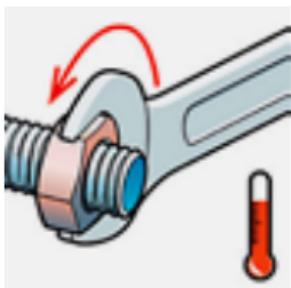
Blind hole:

Apply into lower third of blind hole.

3. Assembly

- Assemble and tighten.
- If several bolts are pre-tightened first, fully tighten them within the fixture time of the product or use a slow curing product.

4. Disassembly



- Disassemble with standard hand tools.
- If not possible, apply localised heat to approximately 250 °C, disassemble while hot.



LOCTITE 577

... reliably seals
coarse threaded
metal pipe joints.
Medium strength.



What does it do & where to use?

- General purpose, medium strength thread sealing product.
- Works on all metals.
- Size of thread up to 3".
- Cures when confined in the absence of air between close-fitting metal surfaces.
- Excellent chemical resistance.
- Service temperature range -55 to +150 °C.
- Approvals: NSF P1, DVGW.

Why use ...?

- Fills the space between threaded parts and seals and locks at the same time.
- Clean and easy to apply
- Provides instant low pressure seal
- Replaces traditional thread sealing products (hemp, tape, paste...)



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1. Preparation

Cleaning

It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive.

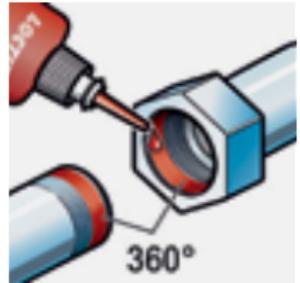


Activation

If cure speed is too slow due to passive metals or low temperature (below 5 °C), use activator LOCTITE SF 7649 (see cure speed vs. activator graph in TDS).

2. Application

- Apply a 360° bead to the leading male thread, leaving the first thread free
- For bigger threads, apply both on male and female thread



3. Assembly

Assemble fittings using wrench tightening in accordance to manufacturers' recommendations.

4. Disassembly

Disassemble with standard hand tools. If not possible, apply localised heat to approximately 250 °C, disassemble while hot



LOCTITE 55

... immediately seals coarse threaded pipe joints.



What does it do & where to use?

- General purpose thread sealing product.
- For gas & water systems.
- Seals threads on metal and plastic pipes and fittings.
- Size of thread up to 4" (straight/taper).
- Service temperature range -55 to +149 °C.
- Approvals: DVGW, KTW, WRAS.

Why use ...?

- Quick, easy and reliable seal.
- Non-curing, immediate, full pressure seal.
- Allows for reliable re-adjustments after assembly of the joint.
- Replaces traditional thread sealing products (hemp, tape, paste...).



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1. Preparation

Cleaning

Clean threads if necessary and roughen smooth threads.



2. Application

- Wind the cord onto the pipe thread in the same direction as the thread, starting from the end of the pipe. For recommended number of wraps see label. For optimised performance apply criss-cross.
- Cut off the cord with the integrated cutting tool at the top of the tube.



3. Assembly

- Assemble using accepted trade practices.
- Adjustment of 45° is possible after tightening.





LOCTITE 518

... reliably seals most common metal flanges. Medium strength.



What does it do & where to use?

- General purpose gasketing product.
- Semi-flexible, medium strength.
- Ideal for use on cast iron, steel and aluminum flanges.
- Fills gaps up to 0,25 mm.
- Cures through minor surface contamination.
- Service temperature range -55 to +150 °C.
- Approvals: NSF P1.

Why use ...?

- Seals instantly against low pressure.
- Resists high pressure when fully cured.
- No compression set or misaligned gaskets.
- Reduces inventory costs – no need for large inventory of cut gaskets.
- Reduces process costs – eliminates manual assembly of conventional gaskets.

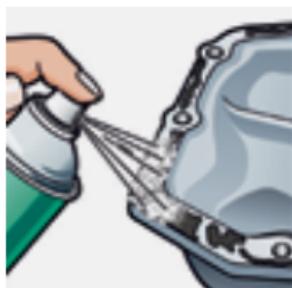


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1. Preparation

Cleaning

- Apply LOCTITE SF 7200 on old gasketing adhesive and use a wood or plastic scraper to remove residues. Remove burrs.
- It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive.

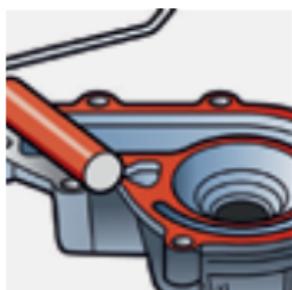


Activation

If cure speed of LOCTITE 518 is too slow due to passive metals and low temperature (below 5 °C), use activator LOCTITE SF 7649 (see cure speed vs. activator graph in the TDS).

2. Application

- Apply as a continuous closed bead onto one flange surface. Place the bead close to the inner rim of the flange and encircle all holes. Small scratches can be filled by the adhesive.
- LOCTITE 518 can also be applied by roller onto large flanges.



3. Assembly

Assemble flanges and tighten bolts as soon as possible.

4. Disassembly

- Disassemble bolts with standard hand tools.
- Use lifting-screws, casted-on bosses or recesses to lift flanges apart. For corroded or seized parts, use LOCTITE LB 8040 Freeze & Release.



LOCTITE SI 5910

... seals flexible flanges with machined or cast surfaces.



What does it do & where to use?

- Silicone based gasketing product.
- For flexible flanges, low strength.
- Typically used on stamped sheet metal covers.
- Suitable for gaps up to 1 mm.
- Cures through volume of 2,75 mm in 24 h.
- Service temperature range -55 to +200 °C.

Why use ...?

- Good resistance to oil and joint movement.
- Reduces migration of fluid after application.

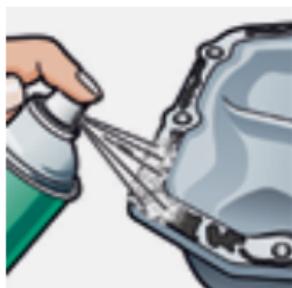


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1. Preparation

Cleaning

- Apply LOCTITE® 7200 on old gasketing adhesive and use a wood or plastic scraper to remove residues. Remove burrs. For thicker layers, several applications may be necessary. Ensure compliance with application instructions on the technical data sheet.
- It is recommended to use LOCTITE® 7063 to degrease and clean surfaces prior to applying the adhesive.



2. Application

- Apply as a continuous closed bead onto one flange surface. Place the bead close to the inner rim of the flange and encircle all holes.



3. Assembly

Assemble flanges and tighten bolts as soon as possible.

4. Disassembly

- Disassemble bolts with standard hand tools.
- Use jacking-screws, cast-on bosses or recesses to lift flanges apart.



LOCTITE 638

... fast curing
retaining compound.
High strength.



What does it do & where to use?

- General purpose, high strength retaining compound.
- For the bonding of cylindrical fitting parts (shafts, gears or pulleys).
- For bond gaps up to 0,25 mm.
- Cures when confined in the absence of air between close-fitting metal surfaces.
- Service temperature range -55 to +180 °C.
- Approvals: P1 NSF, DVGW, WRAS.

Why use ...?

- Fills all voids to prevent loosening, corrosion and fretting.
- High temperature resistance.
- Tolerates minor contaminants, including industrial oils.
- High strength on all metals, including passive substrates (e.g. stainless steel).

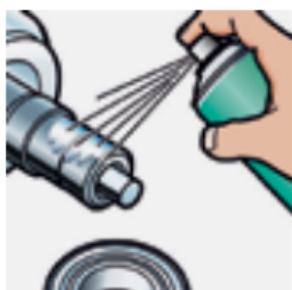


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1. Preparation

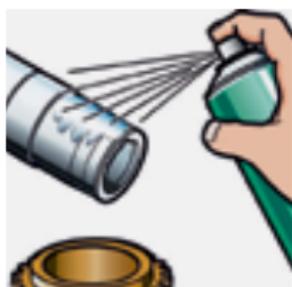
Cleaning

- Use LOCTITE SF 7200 for easier removal of residues in case of old retaining adhesive
- It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive
- For gaps larger than 0,5 mm or worn out shafts, bearing seats or keyways, use LOCTITE metal-filled compounds



Activation

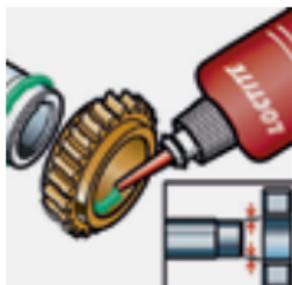
If cure speed is too slow due to passive metals or low temperature (below 5 °C), use activator LOCTITE SF 7649 (see cure speed vs. Activator graph in the TDS).



2. Application

A. For slip fitted assemblies: LOCTITE 638

Apply adhesive around the leading edge of the male component and the inside of the female component and use rotating motion during assembly to ensure good coverage.



B. For shrink fitted assemblies:

Apply the adhesive onto the pin, heat the collar to create sufficient clearance for free assembly. For product selection contact your Henkel Technical Service Team.



3. Disassembly

Apply localised heat to approximately 250 °C, disassemble while hot





LOCTITE 401

... bonds variety of substrates instantly.
Low viscosity.



What does it do & where to use?

- General purpose instant adhesive.
- Low viscosity.
- Ideal for porous substrates (paper, wood, leather, fabric...).
- Works on metals, plastics and elastomers.
- Fixture time 3 – 10 sec.
- Service temperature range -40 to +120 °C.
- Approvals: P1 NSF.

Why use ...?

- Cures rapidly.
- Very high strength on close-fitting parts.
- Perfect for all quick repairs and all types of small emergency repairs.



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1. Preparation

Cleaning

It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive.



Activation

If cure speed is too slow, use appropriate activator LOCTITE SF 7458 (see cure speed vs. activator graph in the TDS). Apply activator to one bond surface by spray, brush or dipping (not to primed surfaces). Allow the activator to dry.



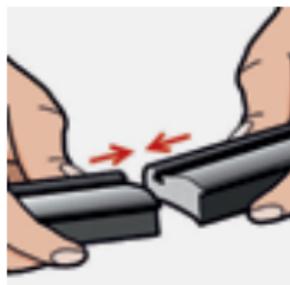
2. Application

Apply adhesive by drop or bead to one of the bond surfaces (not to activated surfaces).



3. Assembly

Assemble the parts immediately. The parts should be accurately located, as the short fixture time leaves little opportunity for adjustment. Bond should be held fixed or clamped until the adhesive has fixtured.



Hint:

If necessary excess product can be cured by activator LOCTITE SF 7458. Spray or drop activator onto excess product.



LOCTITE 406 / LOCTITE SF 770 KIT

... instantly bonds
difficult to bond
plastic materials.



What does it do & where to use?

- 2 part kit, instant adhesive LOCTITE 406 and primer LOCTITE SF 770.
- Designed for bonding Polyolefins and other low energy surfaces (PE, PP, PTFE or silicones).
- Low viscosity.
- Fixture time 2 – 10 sec.
- Service temperature range -40 °C to +120 °C.

Why use ...?

- LOCTITE 406 achieves very high strength on close-fitting parts.
- Primer LOCTITE SF 770 improves adhesion of instant adhesives to polyolefins and other low surface energy plastics.
- Perfect for all quick repairs and all types of small emergency repairs.



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1. Preparation

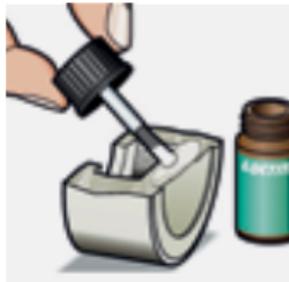
Cleaning

It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive.



Priming

To improve adhesion on difficult to bond plastic surfaces, apply LOCTITE SF 770 to the bond area by brushing. Avoid applying excess primer. Allow the primer to dry.



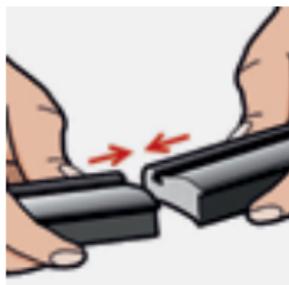
2. Application

Apply adhesive by drop or bead to one of the bond surfaces (not to activated surfaces).



3. Assembly

Assemble the parts immediately. The parts should be accurately located, as the short fixture time leaves little opportunity for adjustment. Bond should be held fixed or clamped until the adhesive has fixtured.



Hint:

If necessary excess product can be cured by activator LOCTITE SF 7458. Spray or drop activator onto excess product.



LOCTITE HY 4070

... quick, high strength, multiple substrate bonder.



What does it do & where to use?

- Two component hybrid adhesive.
- Suitable for various substrates (incl. most plastics, rubbers and metals).
- Provides fast fixture at room temperature.
- Fills gaps up to 5 mm.
- Temperature & moisture resistant.
- Fixture time 4 – 6 min, 2 mm gap.
- Lap Shear Strength Steel 25 N/mm².
- Service temperature range -40 °C to +100 °C.

Why use ...?

- Combines rapid cure with high structural strength of the bond.
- Bonds large number of very dissimilar substrates.
- Gel consistency prevents adhesive flow, even on vertical surfaces.



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1. Preparation

Cleaning

It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces prior to applying the adhesive.

Mixing

Mixing with static mixer (LOCTITE HY 4070): Before mounting the static mixer onto the cartridge, push out a small amount of product to equalize pistons. Mount static mixer and push some mixed product out. The static mixer will then dispense correctly mixed product.

2. Application

Apply product directly after mixing to the bonding area.



Hint:

After use, remove the static mixer and use cap to seal the cartridge.

3. Assembly

- Assemble the parts immediately.
- Prevent the assembled parts from moving during cure.
- The joint should be allowed to develop full strength before subjecting to any service load.



LOCTITE LB 8201

... multi-purpose
lubricating oil.



What does it do & where to use?

- Universal penetrating liquid.
- Frees, lubricates, cleans, dries and prevents corrosion on all machinery.
- Used to free seized or corroded parts such as threaded fasteners, hinges and cylindrical joints.
- Service temperature range -20 °C to +120 °C.

Why use ...?

- Silicone-free.
- Frees assemblies.
- Lubricates metal.
- Cleans parts.
- Displaces moisture.
- Prevents corrosion.
- Suitable for stream or spray application.

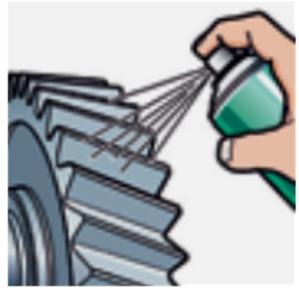


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1. Preparation

Cleaning

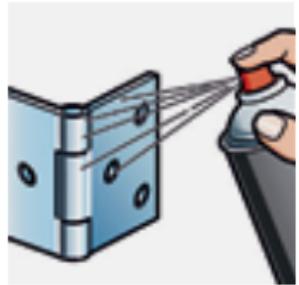
- It is recommended to use LOCTITE SF 7063 to degrease and clean surfaces.
- Surfaces should be free from scale, oxides and lubricant residues.



2. Application

LOCTITE LB 8201

- Choose between jet and spray (based on application needs).
- Spray consistently onto parts to give a uniform film.





LOCTITE EA 3463

... kneadable epoxy repair putty.



What does it do & where to use?

- Versatile, dual component, steel-filled, kneadable epoxy repair putty.
- Adheres to most types of clean surfaces.
- When cured exhibits high compressive strength.
- Stops leaks in pipes and tanks, fills oversized bolt holes, smooths welds, and repairs non-structural defects in castings or holes in tanks.
- Working time is between 2,5 and 5 minutes depending on the amount of product.
- Service temperature range -30 °C to +120 °C.

Why use ...?

- Quick and easy to use.
- Cures under water and will adhere to most damp surfaces.
- In emergency use can prevent bigger equipment damages and additional repair costs.



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1. Preparation

- Thoroughly clean and abrade surfaces. Finally clean with LOCTITE SF 7063.
- Cut required product quantity and then remove plastic film. Twist and knead until material is smooth and colour is consistent.



2. Application

Firmly apply to bond area and form to desired shape. For smooth finish wipe over with a wet cloth.



LOCTITE SF 7063

... cleans wide range of parts and surfaces.



What does it do & where to use?

- General-purpose cleaner and degreaser.
- For any kind of surface or machinery component before proceeding with a repair or assembly job involving LOCTITE® adhesives.
- Removes most greases, oils, lubrication fluids and metal cuttings and fines from all surfaces.

Why use ...?

- Solvent-based.
- Leaves no residue.
- Suitable for stream or spray application.



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1. Application

- Treat surfaces to be cleaned by generously spraying with LOCTITE SF 7063.
- Wipe surface when still wet with a clean paper towel.
- Repeat if necessary until contamination is removed.
- Allow solvent to evaporate until surface is completely dry.



Note:

LOCTITE SF 7063 can cause stress cracks on sensitive plastics.



LOCTITE SF 7900

... protects welding equipment from spatter.



What does it do & where to use?

- Silicone-free ceramic protective coating.
- Prevents metal spatter from adhering to welding equipment.
- Forms a dry film that repels spatter and ensures uninterrupted welding for up to 8 hours without the need for re-application.
- Suitable for manual MIG/MAG welding, laser and plasma cutting or for protecting jigs, fixtures and fittings.
- Cure time 5 – 10 sec.

Why use ...?

- Silicone-free.
- Up to 8 h protection.
- Excellent surface adhesion.
- Eliminates cleaning processes.



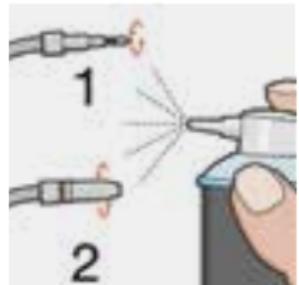
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1. Preparation

Clean contact tip and shroud from adhering spatter. For best results, use a new contact tip and shroud. Shake well before use.

2. Application

- Place the contact tip on the welding torch and apply from a distance of 10 – 15 cm. Fit the shroud to the welding torch and coat the exterior and interior. Let the coating dry for several seconds
- After the application reverse the can and spray for several seconds to prevent clogging of the nozzle.



The data contained herein are intended as reference only.
Please contact Henkel technical support for assistance and
recommendation on specifications for these products.

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