



EUROPEAN PRODUCT CATALOGUE



Henkel Adhesive Technologies

Issue 2

LOCTITE Product Catalogue, Second Edition.

This is the second edition of our new-designed LOCTITE Product Catalogue. You will find here details about the products you most frequently need, making it easier than ever to find the right solutions for most of your tasks, from product design and industrial assembly, to maintenance, repair and operations.

LOCTITE® BEYOND THE BOND

LOCTITE - the world's leading brand for adhesives, sealants and coatings is committed to enable your long-term success, delivering top-performance solutions and extensive industrial expertise. Going beyond the top performance of our renown products, to make your work easier and most effective. From the smallest details to the biggest ambitions.

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Prevent fastener loosening and seizure

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Prevent leaks – air, hydraulic

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Optimise Assemblies, Reduce Unplanned Downtime, With LOCTITE Services.

HOW WE CAN HELP

LOCTITE Services include line audits, plant surveys, inventory assessments, and in-person and online training to make your design, production and maintenance processes much more efficient.

01.

DESIGN & ASSEMBLY

- Design guides
- Line surveys
- In-plant seminars
- Support through the developmental cycle

02.

MAINTENANCE REPAIR & OVERHAUL

- Repair guides
- Plant surveys
- Maintenance Reliability Workshops
- Inventory consolidation

loctite.com

LOCTITE[®] XPLORE



Become an Adhesive Pro!

LOCTITE XPLORE is our learning platform designed for **Assembly, Maintenance and Vehicle Repair Pros** – to help you make informed decisions within your area of expertise. The content is based on the accumulated knowledge of more than 70 years of practical experience – it's **available in multiple languages and it's 100% for free.**

Meet LOC and ROSON, who will drive you to the topic and start improving your skills – 15 minutes at a time. Learn more about our applications in a fun and engaging way!

**JOIN MORE THAN 40 000 LEARNERS WORLDWIDE!
IT'S 100% FREE!**

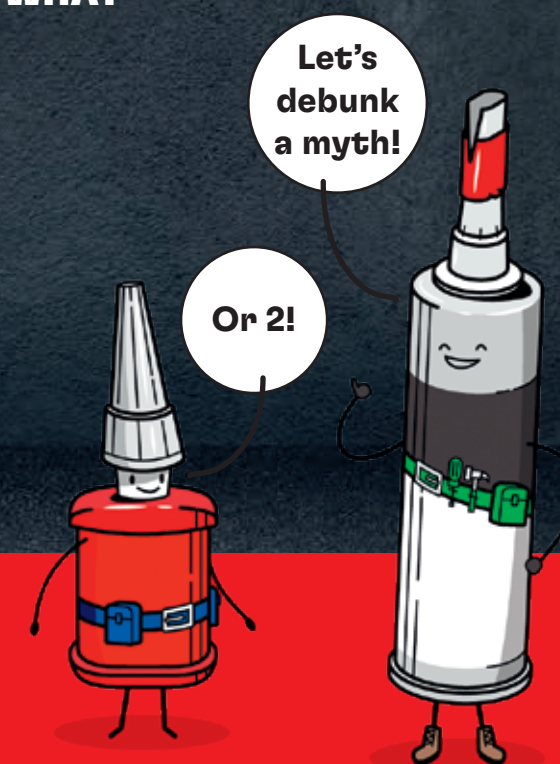
DON'T TAKE OUR WORD FOR IT – HERE'S WHAT YOUR PEERS HAVE TO SAY:

"You explained quickly and completely what each product does and how it did it without going over my head or talking too simple. Good job. Also, the graphics are great."

"I now understand how to use PU adhesives to install a replacement windshield. Very good training"

"Great learning experience for anyone who has not used any LOCTITE products."

"The content itself was really useful to support our customer product selection"

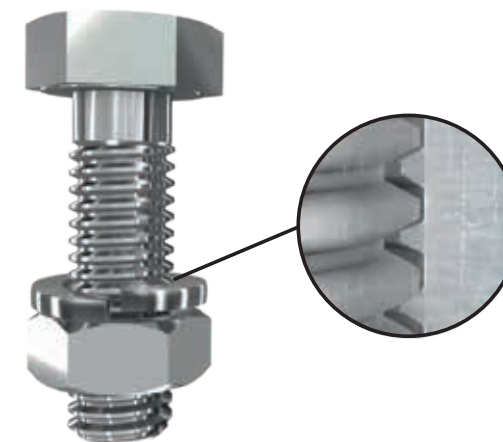


**REGISTER
NOW!**

THREADLOCKERS

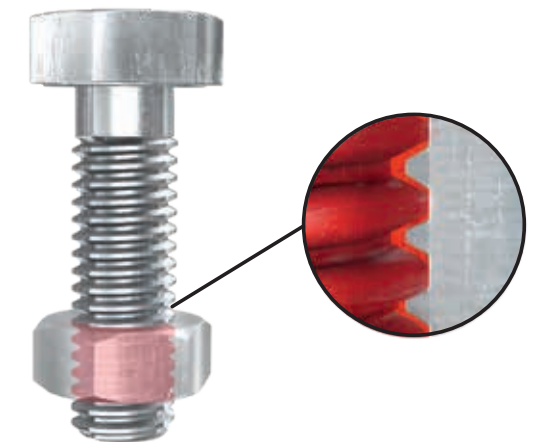
Traditional fastening methods have gaps.

Threadlockers fill them.



PROBLEM

Without Threadlockers:
Vibrational loosening due to 85 % air gap.



SOLUTION

With Threadlockers:
There's no vibrational loosening,
and no gaps.

Tighten your operation. Eliminate loosening.

Threadlockers lock and seal your threaded assemblies, protecting against vibration, corrosion and galling. But depending on your need, you have to choose the right Threadlocker and consider strength, form and removability. Which one will you need? LOCTITE makes your choice easy.



BEST SELLER

LOCTITE 243 Threadlocker

General Purpose, Medium Strength

LOCTITE 243 works on all metals, including passive substrates such as stainless steel, zinc plated bolts and plated bolts. Proven to be tolerant of minor contamination due to e.g. motor oils, corrosion prevention oils, cutting fluids.

Benefits:

- P1 NSF Reg. No.: 123000
- Fluorescent & thixotrop



Disassembly:
Removable with hand tools



Form:
Liquid



Temperature resistance:
180 °C



How to choose a threadlocker.



STRENGTH & DISASSEMBLY

From heavy equipment and permanent assemblies to mounting bolts and adjustment screws, LOCTITE has your Threadlocker.

LOW STRENGTH

Primarily used on adjustment screws, calibration screws, meters and gauges. They have high disassembly frequency and are removable with hand tools.

MEDIUM STRENGTH

Great for machine tools and presses, pumps and compressors, mounting bolts and gearboxes. They have normal disassembly frequency and are removable with hand tools.

HIGH STRENGTH

Used for more permanent assemblies, heavy equipment, suspension bolts, motor and pump mounts, cap bolts and studs. These are rarely disassembled and require localised heat for effective removal.



FORM

Threadlockers come in a variety of different forms ranging from liquid, which flow smoothly into gaps and spaces, to semi-solid, a no-drip, no-mess formulation ideal for overhead applications. Knowing your application will help you select the correct Threadlocker.



TEMPERATURE RESISTANCE

LOCTITE Threadlockers are formulated to have a good thermal performance for continuous service from application to removal.



BEST SELLER

LOCTITE 270 Threadlocker

General Purpose, High Strength

LOCTITE 270 works on all metals, including passive substrates such as stainless steel, zinc plated bolts and plated bolts. Proven to be tolerant of minor contamination due to e.g. motor oils, corrosion prevention oils, cutting fluids.

Benefits:

- P1 NSF Reg. No.: 123006



Disassembly:
Removable with hand tools



Form:
Liquid



Temperature resistance:
180 °C



Find the right product for your application



DISASSEMBLY

Medium Strength

LOCTITE 243
LOCTITE 248
LOCTITE 2400**
LOCTITE 290

Low Strength

LOCTITE 222

High Strength

LOCTITE 270
LOCTITE 277
LOCTITE 2700**
LOCTITE 2701



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



** Has been reformulated to offer improved cure on zinc-flake coatings, while maintaining a very reliable cure on active and passive metal surfaces. This upgrade has achieved this objective without compromising any key properties such as active substrate bond strength, inactive surface cure, chemical resistance or shelf life.

LOCTITE 2400 retains the WRAS, DVGW and German Hygiene Institute certifications and fully meets the LOCTITE Materials Specification of the former version.

LOCTITE 2700 retains the WRAS and German Hygiene Institute certifications and gains the DVGW approval. This upgraded product fully meets the LOCTITE Materials Specification of the former version.

Medium Strength



LOCTITE 243
General Purpose



Strength & disassembly:
Removable with hand tools



Form: Liquid



Temperature resistance:
180 °C

Viscosity: 2150 mPa·s
Breakaway torque: 26 Nm
Fixture speed: 10 min.
Full cure: 24 h



LOCTITE 248
No-Drip, No-Mess



Strength & disassembly:
Removable with hand tools



Form: Stick



Temperature resistance:
150 °C

Viscosity: Semi-solid
Breakaway torque: 25 Nm
Fixture speed: 5 min.
Full cure: 24 h



LOCTITE 2400**
Health & Safety*



Strength & disassembly:
Removable with hand tools



Form: Liquid



Temperature resistance:
150 °C

Viscosity: 350 mPa·s
Breakaway torque: 25 Nm
Fixture speed: 10 min.
Full cure: 24 h



LOCTITE 290
Wicking Grade



Strength & disassembly:
Removable with hand tools



Form: Liquid



Temperature resistance:
150 °C

Viscosity: 40 mPa·s
Breakaway torque: 10 Nm
Fixture speed: 20 min.
Full cure: 24 h

Low Strength



LOCTITE 222
General Purpose



Strength & disassembly:
Removable with hand tools



Form: Liquid



Temperature resistance:
150 °C

Viscosity: 1,200 mPa·s
Breakaway torque: 6 Nm
Fixture speed: 20 min.
Full cure: 24 h

High Strength



LOCTITE 270
General Purpose



Strength & disassembly:
Removable with standard hand tools, where hand tools do not work apply localised heat



Form: Liquid



Temperature resistance:
180 °C

Viscosity: 500 mPa·s
Breakaway torque: 33 Nm
Fixture speed: 10 min.
Full cure: 24 h



LOCTITE 277
Large Bolts



Strength & disassembly:
Removable with standard hand tools, where hand tools do not work apply localised heat



Form: Liquid



Temperature resistance:
150 °C

Viscosity: 7000 mPa·s
Breakaway torque: 32 Nm
Fixture speed: 45 min.
Full cure: 24 h



LOCTITE 2700**
Health & Safety*



Strength & disassembly:
Removable with standard hand tools, where hand tools do not work apply localised heat



Form: Liquid



Temperature resistance:
150 °C

Viscosity: 450 mPa·s
Breakaway torque: 37 Nm
Fixture speed: 5 min.
Full cure: 24 h



LOCTITE 2701
For passive surfaces



Strength & disassembly:
Removable with standard hand tools, where hand tools do not work, apply localized heat.



Form: Liquid



Temperature resistance:
150 °C

Viscosity: 700 mPa·s
Breakaway torque: 38 Nm
Fixture speed: 10 min.
Full cure: 24 h



LOCTITE SERVICES

STOP FASTENER FAILURE
BEFORE IT HAPPENS.



Surface Preparation



LOCTITE SF 7063
Cleaner

A solvent-based, general purpose parts cleaner formulated for metals. The product is able to remove most oils, greases, lubrication fluids, metal cuttings and dries residue-free.



LOCTITE SF 7649
Primer

Designed to promote the curing speed of LOCTITE anaerobic adhesives and sealants without any significant loss of joint strength. Especially recommended for applications with passive metals or inert surfaces and with large bond gaps.

NEW LOCTITE EQ PRO PUMP HANDHELD DISPENSER FOR EASY APPLICATION.

For a full lineup of equipment to support your needs visit equipment.loctite.com

Equipment



LOCTITE EQ RC50
Integrated Dispenser
IDH 2814024

The LOCTITE Pulse RC50 Integrated Dispenser, I4.0, is an enhanced version of the RC40 Integrated Dispenser and offers a digital touch screen for operation, as well as a precision regulator for low-viscosity dispensing. The dispenser is industry 4.0 compatible, providing enhanced communication / connectivity via ethernet or Wi-Fi. The reservoir can accommodate most standard LOCTITE adhesive bottles.



LOCTITE EQ RC40
Integrated Semi-Automatic Dispenser
IDH 2814025

The LOCTITE RC40 Integrated Semi-Automatic Dispenser combines a dual-channel dispense controller and a reservoir into a single unit. The controller provides two independent digital timing channels that provide control of two pneumatic outputs. These outputs can be used to control dispense valves or any other pneumatic device. The reservoir can accommodate most standard LOCTITE adhesive bottles



NEW LOCTITE EQ PRO PUMP
Handheld Dispenser
IDH 2564842

Our all-new easy to use, light-weight, durable applicator that allows for the precise application of 50 ml and 250 ml threadlockers, retaining compounds and thread sealants.



LOCTITE 97130
Ergoloc Valve
IDH 444643

It is a pneumatically operated handheld dispense valve, designed to be used in conjunction with pressure-time dispense systems.

Please refer to page 128 for additional equipment / information.



THREADLOCKERS

Product	Pack Size	Colour	Features	Viscosity (mPa·s)	Thixotropic (Yes / No)	Breakaway Torque / Preval Torque (Nm)	Temperature Range (°C)	Fixture Time (min.)
LOW STRENGTH								
LOCTITE 222	10 ml, 50 ml, 250 ml	Purple	Small screw, general purpose	1.200	Yes	6 / 4	-55 to +150	20
MEDIUM STRENGTH								
LOCTITE 243	5 ml, 10 ml, 24 ml, 50 ml, 250 ml	Blue	General purpose, inactive cure	2.150	Yes	26 / 5	-55 to +180	10
LOCTITE 248	9 g, 19 g	Blue	Easy application, semi-solid stick	Semi-solid	–	23 / n.a.	-55 to +150	5
LOCTITE 2400	50 ml, 250 ml	Blue	General purpose	350	Yes	25 / 2	-55 to +150	10
LOCTITE 290	50 ml, 250 ml	Green	Post application, wicking capability	40	No	10 / 29	-55 to +150	20
HIGH STRENGTH								
LOCTITE 270	10 ml, 50 ml, 250 ml	Green	General purpose, inactive cure	500	No	33 / 33	-55 to +180	10
LOCTITE 2700	50 ml, 250 ml	Green	General purpose	450	No	37 / 45	-55 to +150	5
LOCTITE 2701	5 ml, 250 ml	Green	For passive surfaces	700	No	38/40	-55 to +150	10
LOCTITE 277	50 ml, 250 ml	Red	Ideal for large bolts with coarse threads	7.000	Yes	32 / 32	-55 to +150	45

SEE THE FULL LINE OF THREADLOCKERS AT:



Keeping a Wind Generator Operating Safely

“Thanks to our LOCTITE Engineering Solutions Expert, we don’t have to worry about corrosion or catastrophic fastener failure.”



A wind farm erecting its first wind generator wanted to insure that the bolts attaching the blade to the hub maintained the designed torque and were protected from the corrosion that can occur with exposure to the elements. The ideal solution was **LOCTITE 243** Threadlocker, which helps prevent catastrophic failure by resisting vibrational loosening, preventing thread corrosion and maintaining fastener torque in the wing to hub assembly.

A LOCTITE Engineering Solutions Expert helped the team remove the protective shipping covers from the exposed bolt threads and clean the steel fasteners. They then inserted the blade into the main hub applied **LOCTITE 243** Threadlocker to the fasteners, torqued the blade to hub assembly to specification and mounted the hub to the generator drive system. Now, with corrosion free fasteners that maintain clamp load, and that are easily disassembled at a predictable break loose torque, the wind farm is assured of safe, maintenance-free wind turbine operation until scheduled downtime.

BENEFITS

LOCTITE 243 Threadlocker:

- Fills the gaps between threads to prevent movement between the nut and bolt
- Eliminates vibrational loosening, maintaining the original fastener torque and insuring safe operation
- Prevents corrosion that makes disassembly difficult

THREAD SEALANTS

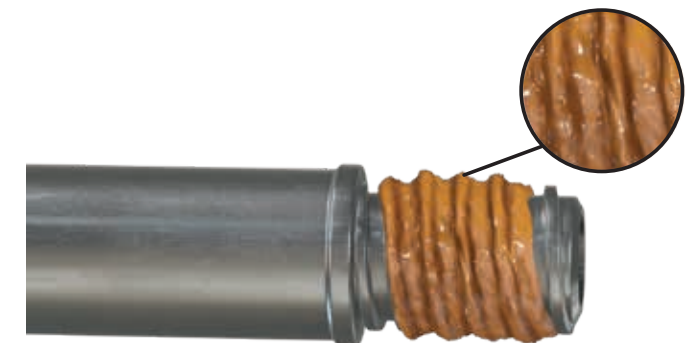
Leaks cause downtime.

Liquid thread sealants prevent them.



PROBLEM

With conventional thread sealants:
Pressurised fluids and gas can cause costly leaks and downtime.



SOLUTION

With liquid thread sealants:
Joints are sealed to the burst point of most piping systems.

Seal out leaks. Seal in productivity.

Thread sealants fill the space between threaded parts and provide an instant, low pressure seal that prevents fluid and gas leaks which can cause costly downtime. LOCTITE has a variety of thread sealants, and the one you need will depend on your system material and thread type.



BEST SELLER

LOCTITE 577

General Purpose

LOCTITE 577 is a general purpose thread sealant which provides an instant seal. Tolerates minor surface contaminants, rated up to 150 °C operating temperature.

Benefits:

- P1 NSF Reg. No.: 123001
- DVGW (EN 751-1): NG-5146CQ0312
- WRAS (BS 6920): 2003511



Substrate:
Metal



Thread type:
Straight



Form:
Anaerobic liquid



How to choose a thread sealant.



SUBSTRATE

There's a LOCTITE thread sealant for any type of piping system.

METAL

For metal-to-metal pipe connections and fittings, use LOCTITE anaerobic thread sealants. They cure in the absence of air and by contact with metals.

PLASTIC

Ideal for use on threaded plastic or plastic / metal substrate combinations.



THREAD TYPE

There are two types of threads to consider. The National Pipe Taper (NPT) seal, most widely used in the United States and Canada, which requires a lower strength thread sealant for disassembly. The British Standard Pipe Taper (BSPT), more common in other countries, requires a higher strength thread sealant in order to seal the connection properly.



FORM

Thread sealants are available in a variety of forms, from liquid to paste to solid. Each is suited to different applications. Liquids are ideal for flowing into gaps in threaded connections. Pastes and solids are best for overhead applications where it's necessary to prevent drips, or an instant seal is needed.



BEST SELLER

LOCTITE 542

Hydraulic and Pneumatic

LOCTITE 542 is a pipe thread sealant designed for locking and sealing of metal pipes and fittings. It is specially formulated to offer high lubricity for easy assembly and removal. Recommended for fine threaded fittings as used in hydraulic and pneumatic installations and small fittings in general.

Benefits:

- DVGW (EN 751-1): NG-5146AR0855
- WRAS (BS 6920) for potable water: 1512515



Substrate:
Metal



Thread type:
Fine



Form:
Anaerobic liquid



Find the right product for your application



SUBSTRATE

Metal

LOCTITE 577
LOCTITE 5400
LOCTITE 542
LOCTITE 55

Plastic

LOCTITE SI 5331

SEE OUR FULL LINE OF
THREAD SEALANTS:



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

Metal



LOCTITE 577
General Purpose



Substrate: Metal



Thread type: Straight



Form: Liquid

Viscosity: 25.000 mPa·s
Temperature resistance: 180 °C



LOCTITE 5400
Health & Safety*



Substrate: Metal



Thread type: Straight



Form: Liquid

Viscosity: 12.500 mPa·s
Temperature resistance: 150 °C



LOCTITE 542
Hydraulic and Pneumatic



Substrate: Metal



Thread type: Fine



Form: Liquid

Viscosity: 600 mPa·s
Temperature resistance: 150 °C



LOCTITE 55
Sealing Cord



Substrate: Metal, Plastic



Thread type: Straight



Form: Cord

Viscosity: Cord
Temperature resistance: 150 °C

Plastic



LOCTITE SI 5331
General Purpose



Substrate: Plastic, Metal



Thread type: Straight



Form: Paste

Viscosity: 50.000 mPa·s
Temperature resistance: 150 °C

Surface Preparation



LOCTITE SF 7063
Cleaner

A solvent-based, general purpose parts cleaner formulated for metals. The product is able to remove most oils, greases, lubrication fluids, metal cuttings and dries residue-free.



LOCTITE SF 7649
Activator

Designed to promote the curing speed of LOCTITE anaerobic adhesives and sealants without any significant loss of joint strength. Especially recommended for applications with passive metals or inert surfaces and with large bond gaps.

Equipment



LOCTITE EQ RC50
Integrated Dispenser
IDH 2814024

The LOCTITE Pulse RC50 Integrated Dispenser, I4.0, is an enhanced version of the RC40 Integrated Dispenser and offers a digital touch screen for operation, as well as a precision regulator for low-viscosity dispensing. The dispenser is industry 4.0 compatible, providing enhanced communication / connectivity via ethernet or Wi-Fi. The reservoir can accommodate most standard LOCTITE adhesive bottles.



NEW LOCTITE EQ PRO PUMP
Handheld Dispenser
IDH 2564842

Our all-new easy to use, light-weight, durable applicator that allows for precision application of threadlockers, retaining compounds and thread sealants in 50 and 250 ml bottles.



LOCTITE EQ RC40
Integrated Semi-Automatic Dispenser
IDH 2814025

The LOCTITE RC40 Integrated Semi-Automatic Dispenser combines a dual-channel dispense controller and a reservoir into a single unit. The controller provides two independent digital timing channels that provide control of two pneumatic outputs. These outputs can be used to control dispense valves or any other pneumatic device. The reservoir can accommodate most standard LOCTITE adhesive bottles



LOCTITE 97130
Ergoloc Valve
IDH 444643

It is a pneumatically operated handheld dispense valve, designed to be used in conjunction with pressure-time dispense systems.

Please refer to page 128 for additional equipment / information.

THREAD SEALANTS

Product	Pack Size	Features	Colour	Viscosity (mPa·s) 20 RPM	Thixotropic (Yes / No)	Temperature Range (°C)	Breakaway Torque, Steel M10 (Nm)
METAL							
LOCTITE 542	10 ml, 50 ml, 250 ml	Pneumatic / hydraulic sealant	Brown	600	No	-55 to +150	15
LOCTITE 577	50 ml, 250 ml	Medium strength, general purpose	Yellow	25.000	Yes	-55 to +180	33
LOCTITE 5400	50 ml, 250 ml	Enhanced health and safety	Yellow to dark orange	12.500	No	-55 to +150	19
METAL OR PLASTIC							
LOCTITE 55	24 x 160 m, 48 x 160 m	Metal and plastic compatible, allows post-adjustment	White	Cord	–	-55 to +150	N/A
LOCTITE SI 5331	100 ml	For plastic and metal, silicone-based	White	50.000	No	-55 to +150	1,5

LOCTITE SERVICES

PREVENT COSTLY LEAKS AND
UNPLANNED DOWNTIME.





Putting a Stop to Leaking Fittings

“LOCTITE helped us reduce downtime and labour costs with a better, longer-lasting solution, even on stainless steel.”



A vapor abrasive blast equipment manufacturer was dissatisfied with the rework required on leaking threaded pipe fittings prior to product shipment. A stainless steel pipe thread sealant is needed to improve sealing reliability on coarse threads. Slow curing competitive sealant had difficulty filling coarse thread gaps leading to fitting leaks. The assembly technician response to thread leaks was to use more sealant increasing product costs.

No cleaning or use of an additional activator is required for the stainless steel threaded pipe and fittings prior to the application of LOCTITE 577. Parts are used as received from the manufacturer.

Adjustments can be made to ensure proper piping alignment beneath the equipment cover.

The Henkel solution reduces manufacturing costs by eliminating post production repairs to leaking fittings. Stocking distributor services insure on-time product delivery to meet production schedules.

BENEFITS

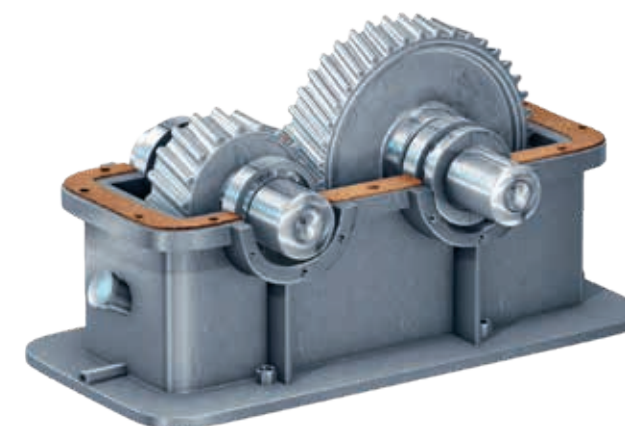
LOCTITE 577 Thread Sealant:

- Very good inactive cure – cures on passive metals, like stainless steel without use of additional activators
- Excellent oil tolerance – cures on pipes with light oily contamination or not properly cleaned parts
- Easily seals coarse stainless steel threads to eliminate post production rework
- Henkel on-site application training reduces product over use to lower material usage costs

GASKETING PRODUCTS

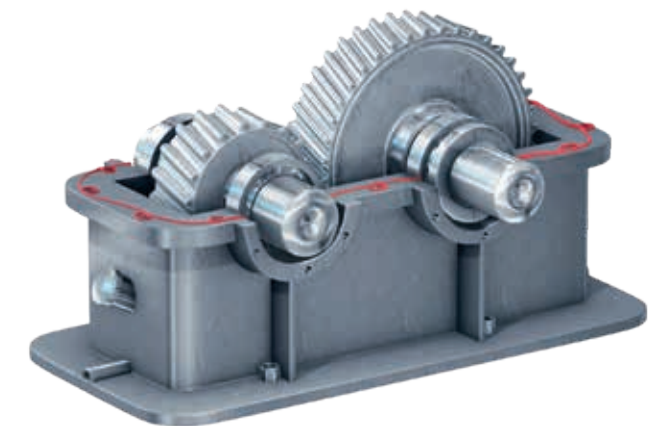
Cut gaskets leak.

Liquid gaskets seal.



PROBLEM

With compression gaskets:
Not all surface imperfections are filled.
They distort, relax under compression
and displace from the joint.



SOLUTION

With liquid gaskets:
When assembled, all surface imperfections
are filled, adding structural stiffness and
eliminating micromovement and slipping. They
do not shrink, crack or suffer from relaxation.

Liquid gaskets hold up better. For longer lasting seals.

To provide a leak-free seal over a long period of time, gaskets must fill voids and be resistant to liquids and / or gases, while withstanding the operating temperatures and pressures to which they are subjected. LOCTITE offers a range of gasketing products designed for any flange type, gap size or material.



BEST SELLER

LOCTITE 518

No-Drip, No-Mess

LOCTITE® 518 is a general purpose, primerless, semi-flexible, form-in-place anaerobic flange sealant. It cures – even in the presence of minor surface contaminants – to seal close fitting joints between rigid metal flanges (iron, steel or aluminum), and will flex with minor flange movements. It provides resistance to low pressures immediately after assembly of flanges, and is ideal for use on aluminum substrates where you need very good flexibility. Typically used as a form-in-place gasket for pumps, thermostats, compressors, transmission housings and axle covers, it not only works on active metals (e.g. mild steel) but also on passive substrates, such as aluminum with a low copper content. You can expect gap performance to 0.01" (0.25mm).

Benefits:

- P1 NSF Reg. No.: 123758
- Semi-flexible anaerobic flange sealant
- Adapts to surface irregularities & gap fill up to 0.01" (0.25mm)
- Forms an instant low-pressure seal
- Cures on inactive surfaces without primer



Flange type:
Rigid machined flange



BEST SELLER

LOCTITE SI 5910

High Adhesion

LOCTITE SI 5910 is a low strength, silicone-based gasketing product designed for use on flexible flanges with machined or cast surfaces. It has good resistance against oil and joint movement. Typical applications include stamped sheet metal covers. Typically thinner, stamped metal flanges can have larger gaps that need to be filled. They are also subject to more flex in service. For these types of assemblies, silicone liquid gasketing products provide the best seal.

Benefits:

- 1K silicone, requires no mixing
- Excellent resistance to automotive engine oils
- The thixotropic nature reduces the migration of liquid product after application to the substrate



Flange type:
Stamped / flexible flange

How to choose a gasketing product.



FLANGE TYPE

RIGID MACHINED FLANGES

Rigid, machined flange surfaces typically are designed for no gap, allowing for metal to metal contact. For these assemblies anaerobic liquid gaskets are the best choice because they provide the highest strength seal.

STAMPED OR FLEXIBLE FLANGES

Typically thinner, stamped metal flanges can have larger gaps that need to be filled. They are also subject to more flex in service. For these types of assemblies, silicone liquid gasketing products provide the best seal.



Find the right product for your application



FLANGE TYPE

Rigid Machined Flange

LOCTITE 518
LOCTITE 510
LOCTITE 5188
LOCTITE 574
LOCTITE 5800

Stamped Flange

LOCTITE SI 5699
LOCTITE SI 5900
LOCTITE SI 5910
LOCTITE SI 5970
LOCTITE SI 5980
LOCTITE SI 5300
LOCTITE SI 5367
LOCTITE SI 596



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

Rigid Machined Flange



LOCTITE 518
General Purpose

Colour: Red
Viscosity: 750.000 mPa·s thixotropic
Temperature resistance: 150 °C
Cure Method: Anaerobic



LOCTITE 5188
Flexible

Colour: Red
Viscosity: 21.000 mPa·s
Temperature resistance: 150 °C
Cure Method: Anaerobic



LOCTITE 510
High Temperature

Colour: Pink
Viscosity: 90.000 mPa·s thixotropic
Temperature resistance: 200 °C
Cure Method: Anaerobic



LOCTITE 574
General Purpose

Colour: Orange
Viscosity: 29.000 mPa·s
Temperature resistance: 150 °C
Cure Method: Anaerobic



LOCTITE 5800
Health & Safety*

Colour: Red
Viscosity: 22.000 mPa·s thixotropic
Temperature resistance: 180 °C
Cure Method: Anaerobic

Stamped Flange



LOCTITE SI 5699
Chemical Resistant

Colour: Grey
Viscosity: Paste
Temperature resistance: 200 °C
Cure Method: Moisture



LOCTITE SI 5900
Instant Seal

Colour: Black
Viscosity: Paste
Temperature resistance: 200 °C
Cure Method: Moisture



LOCTITE SI 5910
High Adhesion

Colour: Black
Viscosity: Paste
Temperature resistance: 200 °C
Cure Method: Moisture



LOCTITE SI 5970
Flexible

Colour: Black
Viscosity: Paste
Temperature resistance: 200 °C
Cure Method: Moisture



LOCTITE SI 5980
Large Gap

Colour: Black
Viscosity: Paste
Temperature resistance: 200 °C
Cure Method: Moisture



LOCTITE SI 5300
High Temperature

Colour: Red
Viscosity: Paste
Temperature resistance: 300 °C
Cure Method: Moisture



LOCTITE SI 5367
High Adhesion

Colour: White
Viscosity: Paste
Temperature resistance: 250 °C
Cure Method: Moisture



LOCTITE SI 596
High Temperature

Colour: Red
Viscosity: Paste
Temperature resistance: 315 °C
Cure Method: Moisture

Surface Preparation



LOCTITE SF 7063
Cleaner

A solvent-based, general purpose parts cleaner formulated for metals. The product is able to remove most oils, greases, lubrication fluids, metal cuttings and dries residue-free.



LOCTITE SF 7200
Parts Cleaner, Gasket Remover

Designed to remove dried chemical gaskets by softening the material on the flanges. Once applied, the product develops a foam-like layer on the gasket, preventing the agent from running off the desired location, thus working for the entire duration. Typical applications include removal of all types of chemical gaskets from metal flanges. It is particularly suitable for aluminium or other soft metal flanges where scraping could lead to surface damage.



LOCTITE SF 7649
Activator

Designed to promote the curing speed of LOCTITE anaerobic adhesives and sealants without any significant loss of joint strength. Especially recommended for applications with passive metals or inert surfaces and with large bond gaps.

Equipment



LOCTITE 97002
300 ml Pneumatic Cartridge Dispenser
IDH 88632

It is a pneumatic dispenser for applying products from 300 ml cartridges. Pneumatic pressurisation minimises operator fatigue. Flow rate is controlled via the integrated pressure regulator. The operator controls the amount by holding down the trigger.



LOCTITE
300 ml Manual Cartridge Dispenser
IDH 142240

Dispenser for adhesives and sealants in 290 ml, 300 ml and 310 ml plastic and aluminium cartridges.

Please refer to page 128 for additional equipment / information.

RIGID MACHINED FLANGES

Product	Pack Size	Colour	Features	Max Gap Fill, Unprimed* (mm)	Viscosity (mPa·s)	Thixotropic (Yes / No)	Temperature Range (°C)	Fixture Time on Steel (min.)
LOCTITE 518	25 ml, 50 ml, 300 ml	Red	Semi-flexible, for use on rigid iron, steel and aluminium flanges	0,25	750.000	Yes	-55 to +150	25
LOCTITE 510	50 ml, 160 ml, 250 ml, 300 ml	Opaque pink	High temperature applications	0,25	90.000**	Yes	-55 to +200	25
LOCTITE 5188	50 ml, 300 ml	Red	Flexible, for steel and aluminium flanges	0,25	21.000	No	-55 to +150	25
LOCTITE 574	50 ml, 250 ml	Orange	High oil resistance, excellent water and glycol resistance	0,25	29.000	Yes	-55 to +150	15
LOCTITE 5800	50 ml, 300 ml	Red	For rigid flanges, enhanced health and safety	0,25	22.000	Yes	-55 to +180	25

* Note: To increase gap fill, use a primer
** Different viscosity test used

STAMPED OR FLEXIBLE FLANGES

Product	Pack Size	Colour	Features	Extrusion Rate (g / min.)	Temperature Range (°C)	Tack Free Time (min.)
LOCTITE SI 5300	310 ml	Red	High temperature	250	-55 to +300	8
LOCTITE SI 5367	310 ml	White	For bonding and sealing applications; rapid skin formation	100	-55 to +250	5
LOCTITE SI 596	80 ml, 300 ml	Red	Excellent heat resistant, for automotive applications	min 250	-55 to +315	60
LOCTITE SI 5699	80 ml, 300 ml	Grey	For flexible flanges, machined or cast surfaces, metal or plastic, increased oil resistance	200	-55 to +200	30
LOCTITE SI 5900	300 ml	Black	Excellent oil resistance, high adhesion, high joint movement, excellent in water / glycol	30	-55 to +200	15
LOCTITE SI 5910	300 ml	Black	High joint movement, oil resistance, good on wide variety of plastics, glasses, ceramic, metals	500	-55 to +200	40
LOCTITE SI 5970	300 ml	Black	Excellent oil resistance, high joint movement, can be used with painted parts	60	-55 to +200	25
LOCTITE SI 5980	100 ml	Black	Excellent oil resistance, ideal for applications with large gaps	220	-55 to +200	30

A Costly 5 % Leakage Rate Eliminated

“A high leakage rate was causing warranty claims and production delays. LOCTITE’s Engineering Solutions Expert helped us completely eliminate the problem.”



A manufacturer of cast iron gear boxes and geared motors experienced a 5 % leakage rate using a competitor’s liquid gasket on the adapter assembly flange. This was costly due to both leakage-related warranty claims on purchased units and testing and production delays caused by the slow cure rate. The competitive product also made it difficult to disassemble and repair the gearbox. **LOCTITE 518** Gasket Sealant was an ideal solution, offering a complete seal, quick curing, and easy disassembly.

A LOCTITE Engineering Solutions Expert showed the plant’s team how to clean flange surfaces and dispense **LOCTITE 518** in a continuous bead. Immediately following assembly, **LOCTITE 518** fills the gaps between the flange surfaces and the products can be instantly pressure tested to 40 psi. Leaks have now been eliminated and disassembly is easier for customers.

BENEFITS

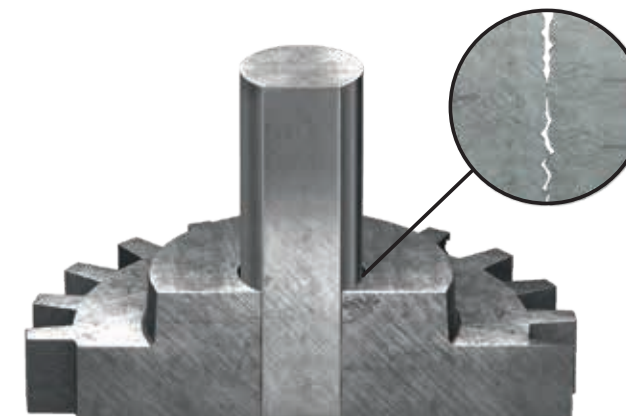
LOCTITE 518 Gasket Sealant:

- Seals more effectively, eliminating leakage during operation
- Sustains low pressure testing of 1,35 bar immediately upon assembly
- Easily disassembles with a small amount of cleavage force

RETAINING COMPOUNDS

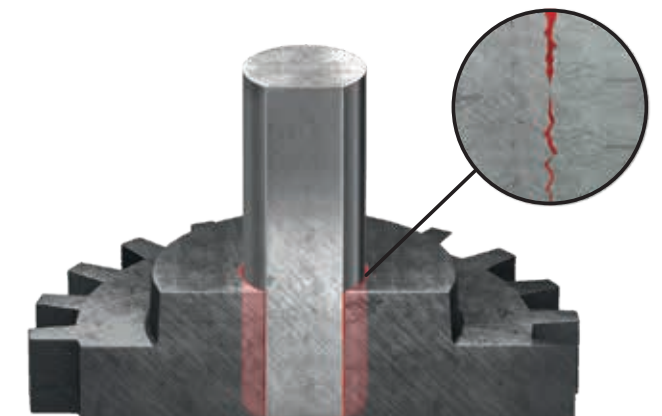
LOCTITE retaining compounds secure components.

For strong reliable assemblies.



PROBLEM

Without retaining compounds:
Mechanical fitting methods leave gaps between fitted parts which cause cylindrical assembly failure.



SOLUTION

With retaining compounds:
Gaps are unitised to provide higher torsional loads and prevent fretting corrosion.

High loads

High strength products

Retaining compounds secure bearings, keyways and cylindrical parts into housings or onto shafts, forming strong assemblies. LOCTITE retaining compounds offer an effective and economical method to eliminate challenges like loosening, corrosion, backlash and wearing by unitising the assembly and providing uniform stress distribution. LOCTITE retaining compounds enable higher load transmission with existing design and geometry. Equal performance and lighter construction can be achieved with lower interference. At the same time component stress of interference fits can be reduced, which might lead to failure, particularly when combined with operational stresses.



BEST SELLER

LOCTITE 638

General Purpose, Slip Fit

LOCTITE 638 is recommended for slip fit parts with larger gaps. Excellent performance for dynamic, axial and radial loads. Tolerates minor surface contaminants and cures on inactive metals without an activator.

Benefits:

- P1 NSF Reg. No. 123010
- DVGW (EN 751-1): NG-5146AR0619
- WRAS (BS 6920): 0511518

 **Gap:**
Up to 0,25 mm

 **Temperature Resistance:**
180 °C

 **Strength:**
29 N/mm²



How to choose a retaining compound.



GAP SIZE

UP TO 0,15 MM

Typically, lower viscosity retaining compounds are used for gaps up to 0,15 mm. These are typically tight fitting interference fits like those found in shrink fits.

0,15 TO 0,25 MM

For gaps above 0,15 mm retaining compounds with higher viscosities that allow for better gap fill are used. These include bonded slip fits.

0,25 TO 0,5 MM

For assemblies with large gaps that are badly worn, special paste-like retaining compounds should be used.



TEMPERATURE RESISTANCE

Most LOCTITE retaining compounds are able to withstand temperatures of -55 to +150 °C. However, certain chemistries are available that withstand temperatures up to +180 to +230 °C for assemblies which see higher service temperatures.



STRENGTH

A high-strength retaining compound is recommended for applications that do not need to be disassembled or require extremely high torsional loads. If parts need to be taken apart for maintenance, a lower strength product should be used to aid in disassembly.



BEST SELLER

LOCTITE 660

Badly Worn Assemblies*

LOCTITE 660 is designed for repairing worn coaxial parts without remachining. Enables re-use of worn bearing seats, keys, splines or tapers, or for retaining shims.

Benefits:

- P1 NSF Reg. Nr.: 123704

* In combination with activator

 **Gap:**
Up to 0,5 mm

 **Temperature Resistance:**
150 °C

 **Strength:**
17,2 N/mm²



Find the right product for your application



 GAP SIZE

Up to 0,15 mm

LOCTITE 603
LOCTITE 641
LOCTITE 648

0,15 to 0,25 mm

LOCTITE 620
LOCTITE 638
LOCTITE 6300

0,25 to 0,5 mm

LOCTITE 660

Gap Size up to 0,15 mm



LOCTITE 603
General Purpose



Temperature resistance:
150 °C



Strength: 22,5 N/mm²

Cure speed: 24 h
Fixture time: 8 min.



LOCTITE 641
Medium Strength



Temperature resistance:
150 °C



Strength: 6,5 N/mm²

Cure speed: 24 h
Fixture time: 25 min.



LOCTITE 648
High Strength



Temperature resistance:
180 °C



Strength: 31 N/mm²

Cure speed: 24 h
Fixture time: 3 min.

Gap Size 0,15 to 0,25 mm



LOCTITE 620
High Temperature



Temperature resistance:
230 °C*



Strength: 17,2 N/mm²

Cure speed: 24 h
Fixture time: 60 min.



LOCTITE 638
General Purpose



Temperature resistance:
180 °C



Strength: 29 N/mm²

Cure speed: 24 h
Fixture time: 4 min.



LOCTITE 6300
Health & Safety**



Temperature resistance:
180 °C



Strength: 15 N/mm²

Cure speed: 24 h
Fixture time: 10 min.

* After 30 min. heat cure at 180 °C

Gap Size 0,25 to 0,5 mm



LOCTITE 660
Badly Worn Assemblies



Temperature resistance:
150 °C



Strength: 17,2 N/mm²

Cure speed: 24 h
Fixture time: 15 min.

**SEE THE FULL PORTFOLIO
OF RETAINING COMPOUNDS AT:**



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



LOCTITE SERVICES

**PREVENT FRETTING CORROSION
AND STRENGTHEN ASSEMBLIES.**



Surface Preparation



LOCTITE SF 7063
Cleaner

A solvent-based, general purpose parts cleaner formulated for metals. The product is able to remove most oils, greases, lubrication fluids, metal cuttings and dries residue-free.



LOCTITE SF 7649
Activator

Designed to promote the curing speed of LOCTITE anaerobic adhesives and sealants without any significant loss of joint strength. Especially recommended for applications with passive metals or inert surfaces and with large bond gaps.

Equipment

Pressure / Time System



LOCTITE 97152
Dual Channel Controller
IDH 1275665

It is a versatile multi-functional controller for actuating 1 – 2 dispensing valves as well as appropriate peripheral equipment such as reservoir, advancing slide, rotorspray and on-line flow monitor.



LOCTITE 97113
Stationary Applicator valve
IDH 88644

97113 / 97114 are designed for pressure-time applications with anaerobic and light cure adhesives up to viscosities of 15.000 mPa·s for the 97113 or higher viscosities for the 97114.

Volumetric System



LOCTITE EQ RC15
Pump Controller
IDH 1880232

It provides all control required for both the 97611 and 97621 Compact Rotor Pumps. This controls all the dispensing parameters such as pump speed, volume dispense, reservoir pressure and rotorspray control.



LOCTITE 97611
Compact Rotor Pump 4.0
IDH 1196160

It is a precision volumetric dispenser for accurate dispensing applications suitable for anaerobic, light cure and acrylic adhesives with flow rates from 500 to 6.000 µl/min.



LOCTITE EQ RC34
Automatic Reservoir
IDH 2830690

The LOCTITE RC32 and RC34 Automatic Reservoirs are suitable for the application of LOCTITE adhesives in semi- or fully-automated assembly processes where a LOCTITE controller is already in use. They allow for pressure adjustment and/or management directly from the LOCTITE controller, and include a low-level sensor. The reservoirs can accommodate most standard LOCTITE adhesive bottles.



LOCTITE 97115
Rotorspray
IDH 135557

It is used to apply anaerobic adhesives to the interior cylindrical surfaces of work pieces. The rotorspray enables high speed rotation for large and small rotor disks.

The 2 l Reservoir and Rotorspray can be used with either the Pressure / Time System or the Volumetric System.

Please refer to page 128 for additional equipment / information.

RETAINING COMPOUNDS

Product	Pack Size	Colour	Features	Viscosity (mPa·s)	Thixotropic (Yes / No)	Compressive Shear Strength, Steel to Steel (N/mm²)	Fixture Time (min.)	Temperature Range (°C)
GAP SIZE UP TO 0,15 MM								
LOCTITE 603	50 ml, 250 ml	Green	Oil tolerant for press fit, low viscosity	125	No	22,5	8	-55 to +150
LOCTITE 641	50 ml, 250 ml	Yellow	Medium strength for disassembly	600	No	6,5	25	-55 to +150
LOCTITE 648	50 ml, 250 ml	Green	High strength, temperature resistance, can be applied to slightly oily surfaces	500	No	31	3	-55 to +180
GAP SIZE 0,15 TO 0,25 MM								
LOCTITE 620	10 ml, 50 ml, 250 ml	Green	Slow fixture, high strength, temperature resistance	8.000	No	17,2	60	-55 to +230*
LOCTITE 638	50 ml, 250 ml	Green	High strength, high temperature resistance for slip-fitted parts, can be applied to slightly oily surfaces	2.500	No	29	4	-55 to +180
LOCTITE 6300	50 ml, 250 ml	Green	High strength with enhanced health & safety	350	No	15	10	-55 to +180
GAP SIZE 0,25 TO 0,5 MM								
LOCTITE 660	50 ml	Silver	High strength, large gap fill for repair	250.000	Yes	17,2	15	-55 to +150

* After 30 min. heat cure at 180 °C



A 5 Day Repair Reduced to 8 Hours

“We not only minimised our plant downtime on this repair, we also reduced the likelihood of future repairs and downtime.”



A loose, spinning bearing had damaged a large fan shaft at a cement manufacturer. Hardfacing and machining the shaft would have taken five days of downtime, and it could have led to future weakening and damage from distortion and fretting corrosion. The solution: **LOCTITE 638** Retaining Compound. It fills voids, prevents fretting corrosion and evenly distributes high load stress.

A LOCTITE Engineering Solutions Expert provided training on this new repair method, and in just 8 hours, maintenance personnel cleaned and removed the main bearing, applied **LOCTITE 638** to the shaft, slipped the bearing into the proper position and the fan was up and running.

BENEFITS

LOCTITE 638 Retaining Compound:

- Allows maintenance personnel to make efficient, in-plant repairs
- Reduces downtime
- Prevents future damage and maintains long-term repair viability

INSTANT ADHESIVES

Fast, lightweight,
multi-material bonding.

For more design options.



PROBLEM

Without instant adhesives:
Fastening options that add complexity,
slow production or limit materials.



SOLUTION

With instant adhesives:
Strong, fast lightweight bonding
of a wide range of materials.

Bonds more material. Faster.

Instant adhesives are ideal for bonding small to medium-size parts with close fitting, smooth surfaces. They provide fast cure speeds and excellent bond strengths to a wide variety of substrates. LOCTITE instant adhesives are available in a range of formulations for anything from general purpose repairs to specialty high-performance assembly applications.



BEST SELLER

LOCTITE 401

Fast, Medium Viscosity

LOCTITE 401 is designed for the assembly of difficult-to-bond materials requiring uniform stress distribution and high tensile and /or shear strength. It provides for the rapid bonding of e.g. metals, plastics and elastomers. LOCTITE 401 is also suited to bonding porous materials such as wood, paper, leather and fabric. Perfect for all quick repairs and all types of small emergency repairs.

Benefits:

- P1 NSF Reg. No.: 123011



Viscosity:
100 mPa·s



Fixture speed: 3 – 10 sec.
Full cure: 24 h



Strength:
20 N/mm²

How to choose an instant adhesive.

GENERAL PURPOSE VS. SPECIALTY ADHESIVES

LOCTITE has an instant adhesive formulated for any application.

GENERAL PURPOSE

Strong and versatile enough for the vast majority of applications, including acidic surfaces such as chromated or galvanised metals and porous substrates such as wood, paper, leather, cork and fabric.

TOUGHENED

Elastomer modified adhesives for applications subjected to high shock, impact and humidity.

FLEXIBLE

For bonding materials subjected to bending or distortion, as well as flexible components.

HIGH TEMPERATURE

For operating temperatures up to 120 °C.

LOW ODOUR / LOW BLOOM

Low volatile adhesives for applications where cosmetic appearance, minimal frosting and low odour are required.

HIGH GAP FILL

For applications with gaps up to 0,15 mm. 2-K technologies provide fast cure independent of gaps up to 5 mm.

LIGHT CURE

Designed to cure very rapidly upon exposure to UV /visible light of the proper intensity.



VISCOSITY

Available in viscosities from thin liquids to thixotropic, no-run gels.



FIXTURE SPEED

Available in various fixture speeds to accommodate applications that may require instant set times to those that may require minor adjustment time.



STRENGTH

Available in shear resistant, general purpose formulations to toughened, high impact, high peel resistant formulations to meet the specific strength requirements of your application.



BEST SELLER

LOCTITE 454

Gel

LOCTITE 454 is designed for the assembly of difficult-to-bond materials which require uniform stress distribution and high tensile and /or shear strength. It provides for the rapid bonding of e.g. metals, plastics and elastomers. The gel consistency enables overhead and vertical application without dripping. LOCTITE 454 is also suited to bonding porous materials such as wood, paper, leather and fabric. Perfect for all quick repair jobs.

Benefits:

- P1 NSF Reg. No.: 123009



Viscosity:
Gel



Fixture speed: 5 – 10 sec.
Full cure: 24 h



Strength:
20,9 N/mm²



Find the right product for your application



General Purpose

LOCTITE 401
LOCTITE 402
LOCTITE 406
LOCTITE 454
LOCTITE 495

Toughened

LOCTITE 435
LOCTITE 480

Low Odour / Low Bloom

LOCTITE 460

High Gap Fill

LOCTITE 3090

General Purpose



LOCTITE 401
Medium Viscosity



Viscosity: 100 mPa·s



Fixture speed: 3 – 10 sec.
Full cure: 24 h



Strength: 20 N/mm²

Colour: Clear
Temperature resistance: 120 °C



LOCTITE 402
Medium Viscosity



Viscosity: 80 mPa·s



Fixture speed: 3 – 10 sec.
Full cure: 24 h



Strength: >15 N/mm²

Colour: Clear
Temperature resistance: -40 - +135 °C



LOCTITE 406
Wicking Grade



Viscosity: 20 mPa·s



Fixture speed: 2 – 10 sec.
Full cure: 24 h



Strength: 15,5 N/mm²

Colour: Clear
Temperature resistance: 120 °C



LOCTITE 454
Gel



Viscosity: Gel



Fixture speed: 5 – 10 sec.
Full cure: 24 h



Strength: 20,9 N/mm²

Colour: Clear
Temperature resistance: 120 °C



LOCTITE 495
Low-Medium Viscosity



Viscosity: 30 mPa·s



Fixture speed: 5 – 20 sec.
Full cure: 24 h



Strength: 14,2 N/mm²

Colour: Clear
Temperature resistance: 120 °C

Toughened



LOCTITE 435
Surface Insensitive



Viscosity: 200 mPa·s



Fixture speed: 10 – 20 sec.
Full cure: 24 h



Strength: 18,5 N/mm²

Colour: Clear
Temperature resistance: 100 °C



LOCTITE 480
Black, High Strength



Viscosity: 200 mPa·s



Fixture speed: 20 – 50 sec.
Full cure: 24 h



Strength: 26 N/mm²

Colour: Black
Temperature resistance: 100 °C



LOCTITE 460
Close Fitting Parts



Viscosity: 40 mPa·s



Fixture speed: 5 – 20 sec.
Full cure: 24 h



Strength: 21 N/mm²

Colour: Colourless to straw
Temperature resistance: 80 °C



LOCTITE 3090
2K Gel



Viscosity: Gel



Fixture speed: 120 sec.*
Full cure: 24 h



Strength: 21 N/mm²

Colour: Clear to slightly cloudy
Temperature resistance: 80 °C

HAVE A UNIQUE APPLICATION?
SEE THE FULL LINE:



* For varying or undefined bond gaps up to 5 mm
** UV / Visible Light Sources: Electrodeless, H bulb: 30 mW/cm², measured @ 365 nm

Surface Preparation



LOCTITE SF 7063
Cleaner

Colour: Colourless
Viscosity: 2,0 mPa·s
Base: Isoparaffine, Dimethoxymethan, Ethanol
Dry time: 60 sec.



LOCTITE SF 770
Polyolephin Primer

Colour: Clear
Viscosity: 1,25 mPa·s
Base: n-Heptane
Dry time: <30 sec.
On-part life: 8 h



LOCTITE SF 7455
Accelerator

Colour: Clear
Viscosity: 0,5 mPa·s
Base: n-Heptane
Dry time: ≥60 sec.
On-part life: 1 min.

Equipment



LOCTITE EQ PU20
Digital Peristaltic Dispenser
IDH 2265279

The LOCTITE EQ PU20 Digital Peristaltic Dispenser is a reliable and effective volumetric dispenser for single-component, low viscosity adhesives. It is great for precise dosing or applications that require a specific flow rate.



LOCTITE EQ RC50
Integrated Dispenser
IDH 2814024

The LOCTITE Pulse RC50 Integrated Dispenser, I4.0, is an enhanced version of the RC40 Integrated Dispenser and offers a digital touch screen for operation, as well as a precision regulator for low-viscosity dispensing. The dispenser is industry 4.0 compatible, providing enhanced communication / connectivity via ethernet or Wi-Fi. The reservoir can accommodate most standard LOCTITE adhesive bottles.



LOCTITE EQ RC40
Integrated Semi-Automatic Dispenser
IDH 2814025

The LOCTITE RC40 Integrated Semi-Automatic Dispenser combines a dual-channel dispense controller and a reservoir into a single unit. The controller provides two independent digital timing channels that provide control of two pneumatic outputs. These outputs can be used to control dispense valves or any other pneumatic device. The reservoir can accommodate most standard LOCTITE adhesive bottles



LOCTITE EQ VA40
CA Volumetric Valve
IDH 2333708

It is a positive displacement metering valve designed for dispensing precise volumetric drops of CA's with each cycle. Positive displacement dispensing is not influenced by variations in pressure, time, temperature or adhesive viscosity therefore making the EQ VA40 an excellent choice for low to medium viscosity drop applications where accuracy and precision are required.



LOCTITE 98009
Light Cure Diaphragm Dispense Valve
IDH 218280

It is a normally closed diaphragm valve that provides high-resolution stroke adjustment and results in consistent flow control.



LOCTITE 98013
CA Diaphragm Dispense Valve
IDH 318654

It is a normally closed diaphragm valve that provides high-resolution stroke adjustment and results in consistent flow control.



LOCTITE 97130
Ergoloc Valve
IDH 444643

It is a pneumatically operated handheld dispense valve, designed to be used in conjunction with pressure-time dispense systems.

Please refer to page 128 for additional equipment / information.

INSTANT ADHESIVES

Product	Pack Size	Colour	Gap Fill (mm)	Viscosity (mPa·s)	Shear Strength, GBMS (N/mm²)	Temperature Range (°C)	Fixture Speed, Steel (sec.)
GENERAL PURPOSE							
LOCTITE 401	20 g, 500 g	Clear	0,15	100	20	-40 to +120	3 – 10
LOCTITE 402	20 g, 500 g	Clear	0,15	80	>15	-40 - +132	3 – 10
LOCTITE 406	20 g, 500 g	Clear	0,15	20	15,5	-40 to +120	2 – 10
LOCTITE 454	20 g	Clear	0,15	Gel	20,9	-40 to +120	5 – 10
LOCTITE 495	20 g, 500 g	Clear	0,15	30	14,2	-40 to +120	5 – 20
TOUGHENED							
LOCTITE 435	20 g, 500 g	Clear	0,15	200	18,5	-40 to +100	10 – 20
LOCTITE 480	20 g, 500 g	Black	0,15	200	26	-40 to +100	20 – 50
LOW ODOUR / LOW BLOOM							
LOCTITE 460	20 g, 500 g	Colourless to straw	0,15	40	21	-40 to +80	5 – 20
HIGH GAP FILL							
LOCTITE 3090	11 g	Clear to slightly cloudy	5	Gel	21	-40 to +80	120

* Note: Faster fixture times can be achieved with light cure.

LOCTITE SERVICES

REDUCE COMPLEXITY AND TIME WHILE EXPANDING DESIGN.





Improved Appearance, Durability and Production Speed



“LOCTITE helped make our signs more aesthetically pleasing and stronger while enabling us to ship more product faster.”

The thick bond lines and slow curing speed of a high-viscosity RTV used to bond aluminium letters to PVC sign boards was causing aesthetic issues and delaying production for a retail sign manufacturer. In addition, letters were sometimes lost due to the low bond strength of the RTV. **LOCTITE 401** Instant Adhesive, which cures more quickly and minimises the gap between the letters and the sign board, was an ideal solution.

A LOCTITE Engineering Solutions Expert showed how just a few small drops of **LOCTITE 401** on each sign letter, which was then applied to the sign board with light hand pressure, allowed the sign company to manufacture signs more quickly and provide customers with a higher quality product.

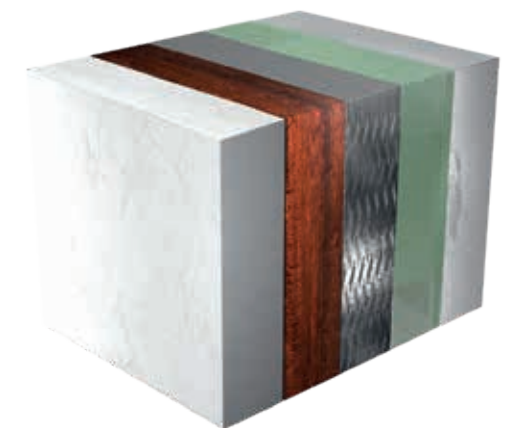
BENEFITS

LOCTITE 401 Instant Adhesive:

- Minimises gap and improves aesthetic appeal with thin bond lines
- Cures fast, maximising production output and lowering overall production costs
- Has high bond strength that eliminates loss of sign letters and addresses customer complaints

UNIVERSAL BONDERS

Fast fixing on multiple substrates.
Almost nothing they can't do.



PROBLEM

Without Universal Bonders:
Multiple material assemblies require additional primers, more cure time and are susceptible to vibration, temperature changes and humidity.

SOLUTION

With Universal Bonders:
Strong, durable, fast bonding of multiple materials.

The most versatile adhesive. In your toolbox.

Faster fixture. Faster repairs.



BEST SELLER



LOCTITE HY 4070

Universal Bonder,
Ultra Fast Structural Adhesive

LOCTITE HY 4070 is a 2K, transparent, colourless to pale yellow cyanoacrylate / acrylic hybrid gel adhesive that provides a fast fixture at room temperature in bond gaps up to 5 mm. It suits various substrates including most plastics, rubbers and metals. It is used where complete cure of excess adhesive as well as temperature and moisture resistance is required.

Benefits:

- Non-sag
- Gel consistency prevents adhesive flow



Fixture time:
<60 sec.



Strength:
25 N/mm²



Substrate:
Plastic, rubber, metal, wood



DISPENSERS

LOCTITE 96001
50 ml Dual Cartridge
Manual Handgun
IDH 267452

NOZZLES

11 g
IDH 1453183

45 g
IDH 1509102

Please refer to page 128 for additional equipment / information.



UNIVERSAL BONDERS									
Product	Pack Size	Colour	Features	Gap Fill	Viscosity (mPa·s)	Mix Ratio	Temperature Range	Fixture Time	Lap Shear Strength, GBMS
LOCTITE HY 4070	11 g, 45 g	Transparent to pale yellow	Ultra-fast, multi-substrate bonder	5 mm	Gel	10:1	-40 to +100 °C	<60 sec. (aluminium, 0,05 mm gap)	25 N/mm ²



UNIVERSAL BONDERS

Product	Pack Size	Colour	Features	Gap Fill	Viscosity (mPa·s)	Mix Ratio	Temperature Range	Fixture Time	Lap Shear Strength, GBMS
LOCTITE HY 4090 / HY 4090 GY	50 ml, 400 ml	Off-white to light yellow	Multi-material bonder, fast strength build, good environmental resistance	5 mm	Gel	1:1	-40 to +150 °C	<180 sec.	17 N/mm²
LOCTITE HY 4080	50 g	Opaque to slightly yellow	Structural bonding adhesive that provides toughness and excellent adhesion to metals, composites and plastics.	5 mm	Thixotropic	1:1	-40 to +120 °C	10 min	25 N/mm²

Fast curing adhesives. For industrial design solutions.

Create strong and reliable bonds with LOCTITE HY 4090.



BEST SELLER



LOCTITE HY 4090 / HY 4090 GY

Universal Bonder, Fast & Versatile Structural Adhesive

LOCTITE HY 4090 is an off-white to light yellow (gray for LOCTITE HY 4090 GY) gel with high viscosity. It opens up new application areas in structural bonding by combining instant adhesive properties with those of epoxies to give more striking benefits:

- Fixture time of 90 – 180 seconds and suitable for gaps up to 5 mm
- Resistant to vibration, shock loads and impacts



Fixture time: <180 sec.



Strength: 17 N/mm²



Substrate: Plastic, rubber, metal, wood



LOCTITE HY 4080

Universal Bonder, Structural Adhesive

LOCTITE HY 4080 is a 2-part, opaque to slightly yellow, cyanoacrylate/acrylic hybrid structural bonding adhesive. Provides toughness and excellent adhesion. It shows high operational strength within the first hour of cure. Specific benefits:

- High viscosity (thixotropic)
- Good resistance to peel and impact loads



Fixture time: 10 – 12 min



Strength: 25 N/mm²



Substrate: Metals, composites, plastics



DISPENSERS

LOCTITE 96001
50 ml Dual Cartridge Manual Handgun
IDH 267452

LOCTITE 97042
50 ml Dual Cartridge Pneumatic Handgun
IDH 478698

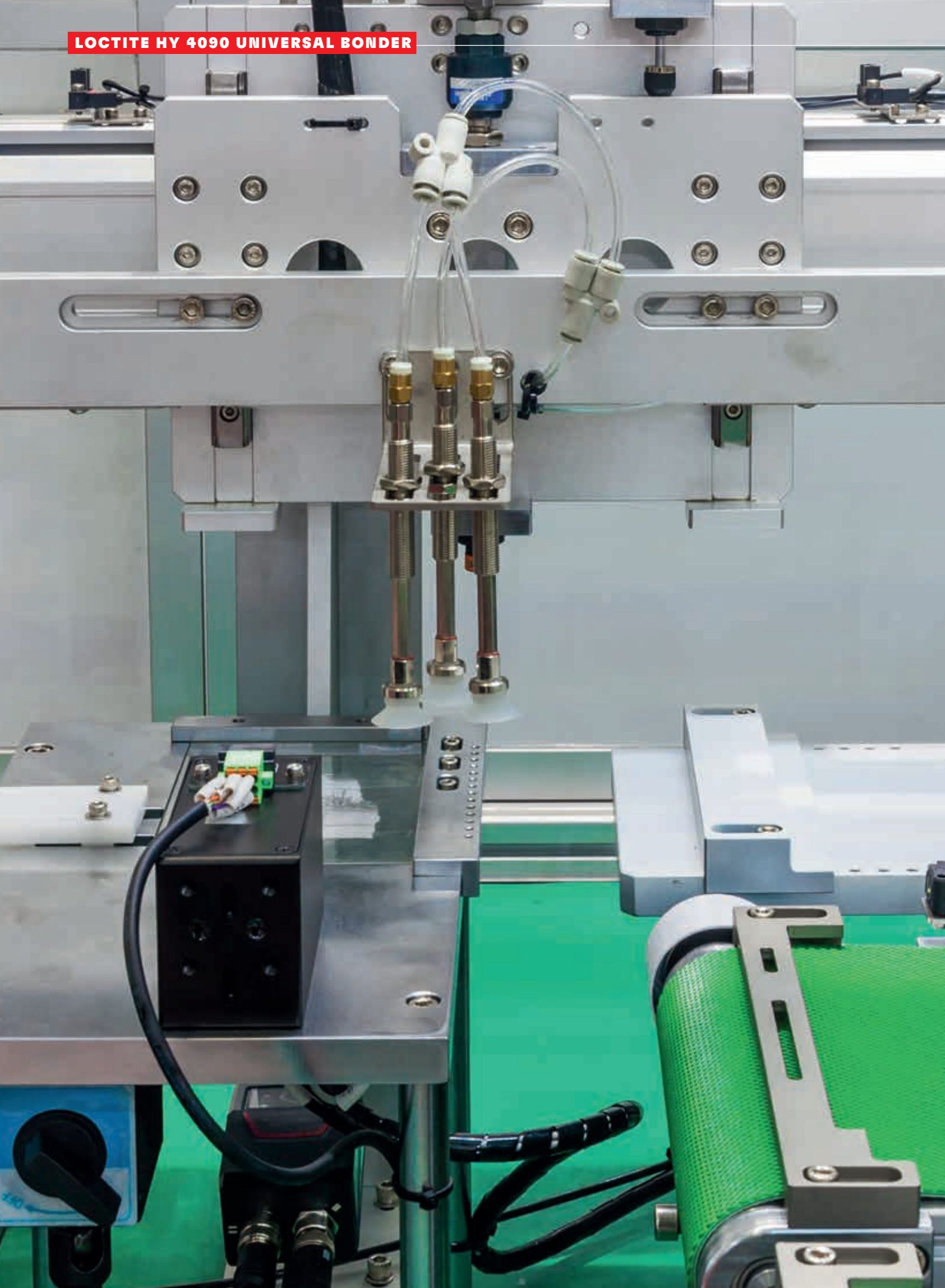
LOCTITE EQ HD14
400 ml Dual Cartridge Pneumatic Dispenser
IDH 2693825

NOZZLES

50 ml
IDH 1826921

400 ml
IDH 1573135

Please refer to page 128 for additional equipment / information.



Fast, Durable Bonding of High Volume PA and ABS Components



“LOCTITE had the perfect adhesive solution to help bring our new product to life.”

A designer and manufacturer of battery packs for electronic devices was designing a new product and searching for an adhesive to bond PA and ABS plastics. The adhesive needed to allow for projected production line volumes and be resistant to vibration, temperature and humidity variances. **LOCTITE HY 4090**, a fast curing universal bonder that provides strong bonds without primers or other surface treatments, was a perfect candidate.

A LOCTITE Engineering Solutions Expert showed them how to clean battery pack parts with LOCTITE SF 7063 to remove molding compounds that may inhibit final bond strengths, then dispense **LOCTITE HY 4090** from the dual cartridge packaging using the LOCTITE manual applicator equipped with a mixer nozzle. The hybrid adhesive fixtured in just 3 minutes, minimising any potential blooming from exposed fillets of the cyanoacrylate based product, and provided a bond to PA and ABS plastics that withstood vibration, temperature and humidity variances.

BENEFITS

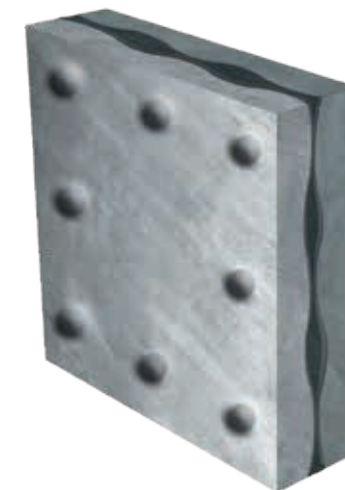
LOCTITE HY 4090 Universal Bonder:

- Generates strong, multi-material bonds without requiring additional surface primers
- Provides a fast fixture rate of 3 minutes that will not impede the proposed line speed
- Results in assemblies that resist vibration, temperature changes and attack by high humidity

STRUCTURAL ADHESIVES

Superior speed,
aesthetics and strength.

Without the weight.



PROBLEM

With traditional fastening:
Added weight, time, cost and difficulty.



SOLUTION

With structural adhesives:
Lightweight, strong, durable, less expensive
fastening with better end product aesthetics.

Take off the weight. Take on the load.

Structural adhesives join two materials firmly and permanently. The adhesive is the “bridge” between the substrates and provides advantages such as:

- Uniform stress distribution for better product reliability
- Design freedom for light weight constructions

Adhesives are easy to apply and assemble. The selection of the right adhesive depends on some factors like adhesive-material compatibility and joint requirements.



BEST SELLER

LOCTITE AA 326

Fast Fixture, Small Gaps, 2-Step

LOCTITE AA 326 is a yellow to amber, 2K no mix, medium viscosity (thixotropic) structural and magnet bonder which is activated with LOCTITE SF 7649. It has good adhesion to different types of ferrites, a fixture time of 3 minutes and a shear strength of 15 N/mm². It can be used in temperature up to 120 °C.

Benefits:

- Fast fixture
- High strength
- All purpose bonder



Fixture speed:
3 min.



Substrate:
Aluminium, steel, ferrite



BEST SELLER

LOCTITE EA 3430

Optically Clear, Water-Resistant

LOCTITE EA 3430 is a 2K, clear epoxy adhesive which cures rapidly at room temperature after mixing. It is a general purpose adhesive which develops high strength on a wide range of substrates. The gap filling properties make this adhesive system suitable for rough and poorly fitting surfaces.

Benefits:

- High transparent
- Water resistance
- Fast curing



Fixture speed:
15 min.



Substrate:
Metal, glass, ceramic, rigid plastic

How to choose a structural adhesive.

GENERAL PURPOSE VS. SPECIALTY ADHESIVES

LOCTITE has a wide range of structural adhesives, from general purpose – strong and versatile enough to cover the majority of applications, to specialty – formulated for cases where special properties are needed.

HIGH PERFORMANCE

Solutions designed for a range of product needs, with respect to impact strength, peel strength, durability, working time etc.

FLEXIBLE SOLUTIONS

Offering excellent shock absorption, elasticity and adhesion to plastics, metals and glass.

SPECIAL SUBSTRATES

From epoxies designed to be safe for food and water contact to acrylics and polyurethanes for bonding e-coated metals, rigid foams, plastics and glass.

BONDING FERRITE COMPONENTS

Epoxies and acrylics designed for the specific requirements of bonding ferrite (magnets).

POTTING

Flowable epoxies designed for filling cavities and protecting components.

Legend for your adhesive choice:



FIXTURE SPEED

A range of fixture times from ultra fast to slow to meet your process requirements.



SUBSTRATE

LOCTITE structural adhesives can bond most materials.



Find the right product for your application



GENERAL PURPOSE

LOCTITE AA 330
LOCTITE EA 3421

LOCTITE AA 326
LOCTITE EA 3423

SPECIALTY

Working Life / Heat Cure

WORKING LIFE

Time ranges (before assembly) from fast to slow to meet your process requirements.

< 1 Hour ≥ 1 Hour

LOCTITE EA 3450
LOCTITE EA 9450
LOCTITE EA 9461
LOCTITE EA 3430

LOCTITE EA 9483
LOCTITE EA 9497

Heat Cure

LOCTITE EA 9514

High Performance

LOCTITE AA 3342
LOCTITE EA 9492

LOCTITE AA 3298
LOCTITE EA 9466

Plastic Repair

TEROSON PU 9225
TEROSON PU 9225 SF ME

TEROSON PU 9225 SF
TEROSON PU 9225 UF ME

Multi-Substrate Repair Bonder

TEROSON PU 6700
TEROSON PU 6700 ME

General Purpose



**LOCTITE
AA 330**
Small Gap



Fixture speed: 3 min.



Substrate: Metals, ceramic, plastics

Gap: 0,5 mm
Temperature resistance: 120 °C
Colour: Pale yellow
Chemistry: Two-step acrylic
Activator: LOCTITE SF 7388



**LOCTITE
AA 326**
Magnet Bonding,
High Viscosity



Fixture speed: 3 min.



Substrate: Aluminium, steel, ferrite

Gap: 0,5 mm
Temperature resistance: 120 °C
Colour: Light amber
Chemistry: Two-step acrylic
Activator: LOCTITE SF 7649



**LOCTITE
EA 3421**
Slow Curing



Working life: 30 – 150 min.



Substrate: Metals, ceramics,
rigid plastics, wood

Temperature resistance: 120 °C
Colour: Clear amber
Chemistry: 2K Epoxy



**LOCTITE
EA 3423**
Non-Sag



Working life: 30 – 60 min.



Substrate: Metals (can be sanded)

Temperature resistance: 120 °C
Colour: Grey
Chemistry: 2K Epoxy

Work Life / Heat Cure

WORKING LIFE* < 1 HOUR



**LOCTITE
EA 3450**
Rapid Cure,
High Strength



Working life: 4 – 6 min.



Substrate: Metals, ceramics,
rigid plastics, wood

Temperature resistance: 100 °C
Colour: Grey
Chemistry: 2K Epoxy



**LOCTITE
EA 9450**
Fast Cure,
Non-Sag



Working life: 2 – 7 min.



Substrate: Metals, ceramic,
glass, most plastics

Temperature resistance: 100 °C
Colour: Translucent
Chemistry: 2K Epoxy



**LOCTITE
EA 9461**
Toughened



Working life: 40 min.



Substrate: Metals, ceramics,
rigid plastics, thermoset
laminates

Temperature resistance: 120 °C
Colour: Grey
Chemistry: 2K Epoxy



**LOCTITE
EA 3430**
Optically Clear,
Water-Resistant



Working life: 5 – 10 min.



Substrate: Glass, metals,
ceramics, rigid plastics, wood

Temperature resistance: 100 °C
Colour: Ultra clear
Chemistry: 2K Epoxy

WORKING LIFE* ≥ 1 HOUR



**LOCTITE
EA 9483**
High Strength,
Optically Clear



Working life: 25 – 60 min.



Substrate: Glass, metals,
ceramics, rigid plastics, wood,
magnets

Temperature resistance: 150 °C
Colour: Ultra clear
Chemistry: 2K Epoxy



**LOCTITE
EA 9497**
Thermally Conductive,
High Compression
Strength



Working life: 165 – 255 min.



Substrate: Metals, ceramics

Temperature resistance: 180 °C
Colour: Grey
Chemistry: 2K Epoxy

HEAT CURE



**LOCTITE
EA 9514**
Toughened,
Induction Cure



Working life:
5 min. gel time at 120 °C



Substrate: Metals, ceramics,
magnets

Temperature resistance: 200 °C
Colour: Grey
Chemistry: 1K Epoxy

LOCTITE SERVICES

IMPROVE STRENGTH AND
AESTHETICS IN REDUCED TIME.



* Working life = maximum time before assembly

High Performance



**LOCTITE
EA 9492**
High Temperature,
Chemical Resistance



Working life: 15 min.



Substrate: Metals, ceramics,
rigid plastics

Temperature resistance: 180 °C
Colour: White
Chemistry: 2K Epoxy



**LOCTITE
EA 9466**
High Peel Resistance,
High Shear Strength



Working life: 60 min.



Substrate: Metals, ceramics,
plastics

Temperature resistance: 120 °C
Colour: Off-white
Chemistry: 2K Epoxy

Plastic Repair



**TEROSON
PU 9225 SF**
Fast Cure, Holes <5 cm



Pot life / Working life: 2 min.



Substrate: Paintable plastic
parts

Colour: Dark grey
Chemistry: 2K Polyurethane
Primer: TEROSON 150



**TEROSON
PU 9225 SF ME**
MicroEmission™



Pot life / Working life: 2 min.



Substrate: Paintable plastic
parts

Colour: Dark grey
Chemistry: 2K Polyurethane
Primer: TEROSON 150

Multi-Substrate Repair Bonder



**TEROSON
PU 6700**
Solvent-Free



Pot life / Working life: 10 min.



Substrate: Metals, plastics,
painted surfaces, wood

Colour: Dark grey
Chemistry: 2K Polyurethane
Paintable / Sandable: Yes



**TEROSON
PU 6700 ME**
Fast Curing,
MicroEmission™



Pot life / Working life: 5 min.



Substrate: Metals, plastics,
painted surfaces, wood

Colour: Dark grey
Chemistry: 2K Polyurethane
Paintable / Sandable: Yes

Equipment

DISPENSERS

Pneumatic



Manual



NOZZLES

 IDH 1487440

 IDH 1487439

 IDH 2900614

50 ml

LOCTITE 96001
50 ml 1:1 / 2:1
Dual Cartridge
Applicator
Manual
IDH 26745

LOCTITE 97042
50 ml 1:1 / 2:1
Dual Cartridge
Applicator
Pneumatic
IDH 476898

50 ml 10:1
Dual Cartridge
Applicator
Manual
IDH 1034026

50 ml 10:1
Dual Cartridge
Applicator
Pneumatic
IDH 1493310

200 ml

LOCTITE EQ HD14
200 ml
Dual Cartridge
Manual Dispenser
1:1 – 10:1
IDH 2693822

LOCTITE EQ HD14
200 ml
Dual Cartridge
Pneumatic
Dispenser
1:1 – 10:1
IDH 2693824

400 ml

LOCTITE EQ HD14
400 ml
Dual Cartridge
Manual Dispenser
1:1 – 10:1
IDH2693823

LOCTITE EQ HD14
400 ml
Dual Cartridge
Pneumatic
Dispenser
1:1 – 10:1
IDH2693825

50 ml
Epoxy Nozzle

400 ml
Epoxy Nozzle

50 ml
Polyurethane Nozzle

**HAVE A UNIQUE
APPLICATION?
SEE THE FULL LINE:**

structurals.loctite.us

Please refer to page 128 for additional equipment / information.



2-STEP ACRYLICS

Product	Pack Size	Features	Colour	Viscosity (mPa•s)	Gap Fill (mm)	Fixture Time (min.)	Shear Strength, GBMS (N/mm²)	Temperature Resistance (°C)
GENERAL PURPOSE								
LOCTITE AA 330	50 ml kit	General purpose adhesive for metals, ceramic, plastics	Pale yellow	67500	0,5	3	23	120
MAGNET BONDING								
LOCTITE AA 326	50 ml	Ferrites to plated materials in electric motors, loudspeakers hardware, jewellery	Light amber	18.000	0,5	3	15	120

EPOXIES

Product	Pack Size	Features	Colour	Viscosity (mPa•s)	Mix Ratio	Fixture Time (min.)	Shear Strength, GBMS (N/mm²)	Temperature Resistance (°C)
HIGH PERFORMANCE								
LOCTITE EA 3421	50 ml	Universal adhesive with long working time	Clear amber-yellow	37.000	1:1	240	22	120
LOCTITE EA 3423	50 ml, 200 ml	Universal adhesive, excellent for metals, good moisture resistance	Grey	300.000	1:1	180	17	120
LOCTITE EA 9461	50 ml	High impact resistant, gap filling	Grey	72.000	1:1	240	25	120
LOCTITE EA 9466	50 ml, 400 ml	High impact and peel resistance, excellent bond strength to a wide variety of plastics and metals	Off-White	35.000	2:1	180	37	120
LOCTITE EA 9483	50 ml, 400 ml	Optical clarity and high strength, ideal for bonding decorative panels and displays	Ultra Clear	7.000	2:1	210	23	150
LOCTITE EA 9492	50 ml, 400 ml	High temperature and chemical resistance	White	30.000	2:1	75	20	180
LOCTITE EA 9497	50 ml	High temperature, thermally conductive, room temperature cure	Grey	12.000	2:1	480	20	180
FAST FIXTURE								
LOCTITE EA 3430	24 ml, 50 ml	Universal, fast curing	Ultra Clear	23.000	1:1	15	22	100
LOCTITE EA 3450	25 ml	Fast curing, ideal for metal repairs	Grey	35.000	1:1	15	25	100
LOCTITE EA 9450	50 ml	Fast curing, gap filling	Translucent	200.000	1:1	13	23	100
ONE PART / HEAT CURE								
LOCTITE EA 9514	300 ml	High temperature resistance and mechanical strength, excellent impact resistance	Grey opaque paste	45	–	–	44	200

POLYURETHANES

Product	Pack Size	Features	Colour	Pot Life / Working Time (min.)	Cure Time @ RT (h)	Paintable?	Sandable?	MicroEmission™?
TEROSON PU 6700	50 ml, 310 ml, 400 ml	Solvent-free, multi-purpose bonder for metals, plastics, wood, painted surfaces	Grey	10	6	Yes	Yes	No
TEROSON PU 6700 ME	50 ml, 400 ml	Solvent-free, multi-purpose bonder for metals, plastics, wood, painted surfaces	Grey	5	5	Yes	Yes	Yes
TEROSON PU 9225 SF	50 ml	Fast curing repair adhesive, in combination with plastics the use of an approved Henkel primer is absolutely necessary	Dark Grey	2	1,5	Yes	Yes	No
TEROSON PU 9225 SF ME	50 ml	Fast curing repair adhesive, in combination with plastics the use of an approved Henkel primer is absolutely necessary	Dark Grey	2	1,5	Yes	Yes	Yes



A Long-Lasting Alternative to Welding

“LOCTITE helped us find a solution to constant spot weld failures that were costing us equipment downtime and repair costs.”



A paper recycler's stainless steel filter screens failed regularly in service – every 6 to 8 weeks – due to the erosion of spot welds that caused the mesh to fall into the rotating screen system. The frequent replacement required by these failures caused equipment downtime and labour costs. **LOCTITE EA 9466**, a structural adhesive that is resistant to peel and shear forces, was the perfect solution.

A LOCTITE Engineering Solutions Expert walked the team through the process, from ground washing the screen mesh and filter to remove any paper recycling debris and chemical residues, to dispensing from a 50 ml dual cartridge, to positioning and weighting the replacement mesh. The new process has lowered filter replacement costs, labour repair costs and doubled uptime between process downtime, thereby increasing recycling production output.

BENEFITS

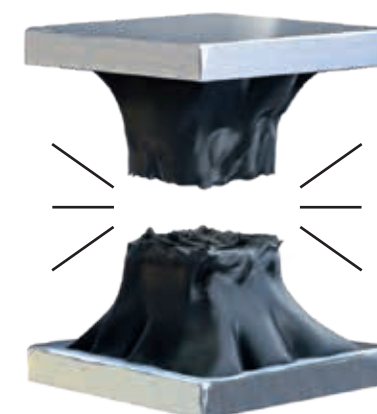
LOCTITE EA 9466 Structural Adhesive:

- Provides the needed durability to withstand the abrasive forces in the filter process
- Replaces spot welds and holds the fine filter mesh in place for more than 16 weeks
- Offers cost savings by reducing equipment down time and labour costs

FLEXIBLE ADHESIVES AND SEALANTS

High elongation. Durable adhesion.
Varied substrates.

For joints with high movement.



PROBLEM

With rigid adhesives:
Joints may fail under dynamic stresses.

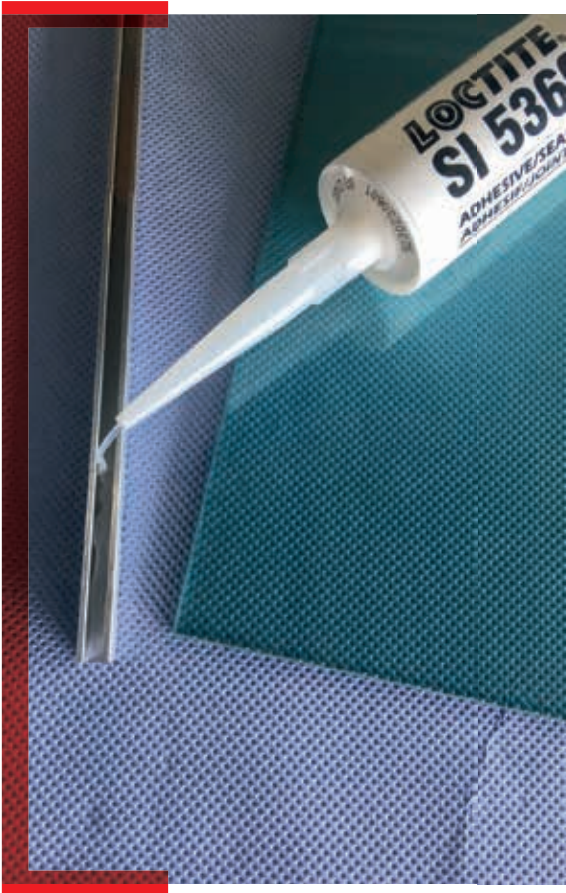


SOLUTION

With flexible adhesives:
Joints tolerate movements.

Bonding and sealing for dynamic loads.

Flexible adhesives and sealants are ideal for applications that are subjected to dynamic forces and require durable adhesion to a variety of substrates. They fill large gaps and once cured, their resilient properties provide UV-resistant, waterproof seals and strong bonds that withstand high tensile and impact forces, as well as cold and hot temperature cycles, where substrates expand and contract at different rates.



BEST SELLER

TEROSON MS 939

Primerless, Multi-Purpose Adhesive

TEROSON MS 939 is an industrial elastomeric bonding adhesive that offers high versatility. It demonstrates both high strength and good elasticity. It meets the damp heat test for the solar industry and the UL listing for electrical equipment. It has excellent weathering resistance.

Benefits:

- Free of solvents, isocyanates, silicones and PVC
- Allows accelerated curing as 2K material



Paintability:
Yes



Temperature resistance:
100 °C



Cure speed:
24 h



BEST SELLER

TEROSON MS 930

Primerless Sealant / Adhesive

TEROSON MS 930 is a moisture-cured, thixotropic silane modified polymer sealant / adhesive. Suitable for various applications involving a wide range of substrate materials. It forms a soft elastic product and provides excellent UV and weathering resistance. It complies with UL QMFZ2 for electrical safety.

Benefits:

- Free of solvents, isocyanates, silicones and PVC
- Allows accelerated curing as 2K material



Paintability:
Yes



Temperature resistance:
80 °C



Cure speed:
24 h

How to choose a flexible adhesive or sealant.

BONDING VS. SEALING

While all of the flexible adhesives and sealants provide both a bond and a seal, some are formulated with higher tensile strengths which make them better suited for bonding applications. Alternatively, others are developed with higher elongation properties, which make them ideally suited for sealing applications.



PAINTABILITY

SMP*-based adhesives and sealants are paintable after application (skin formation), while silicone-based adhesives and sealants are not compatible with paint.



TEMPERATURE

The operating temperature requirements of your end device may have an impact on which flexible adhesive and sealant is best suited for your application.



CURE SPEED

2K flexible adhesive and sealants provide fast cure times, while 1K products rely on ambient moisture and require longer times to cure.

* Silane Modified Polymer

Find the right product for your application



Flexible Adhesives

TEROSON MS 939
TEROSON MS 9399
TEROSON MS 9220

Flexible Sealants

TEROSON MS 930
TEROSON MS 9360
LOCTITE SI 5366
LOCTITE SI 5368

PLEASE CONTACT YOUR
HENKEL REPRESENTATIVE
FOR MORE INFORMATION

on the full range
of Flexible Adhesives and Sealants

* To improve adhesion of TEROSON MS products on difficult-to-bond materials, we recommend cleaner/adhesion promoter TEROSON SB 450 or Corona / Plasma treatment.

Flexible Adhesives



**TEROSON
MS 939***
1K Silane Modified Polymer



Paintability: Yes



Temperature resistance: 100 °C



Cure speed: 24 h

Skin over time: 5 min.
Colour: Black, white, grey
Cure method: Moisture
Tensile strength: 3 N/mm²



**TEROSON
MS 9399***
2K Silane Modified Polymer



Paintability: Yes



Temperature resistance: 100 °C



Cure speed: 3 h

Skin over time: 25 min.
Colour: Black, white, grey
Cure method: 2K mix
Tensile strength: 3 N/mm²



**TEROSON
MS 9220**
1K Silane Modified Polymer



Paintability: Yes



Temperature resistance: 100 °C



Cure speed: 24 h

Skin over time: 6 min.
Colour: Black
Cure method: Moisture
Tensile strength: 3 N/mm²

Equipment



LOCTITE
300 ml Manual Cartridge Dispenser
IDH 142240

Dispenser for adhesives and sealants in 290 ml, 300 ml and 310 ml plastic and aluminium cartridges.



LOCTITE 97002
300 ml Pneumatic Cartridge Dispenser
IDH 88632

It is a pneumatic dispenser for applying products from 300 ml cartridges. Pneumatic pressurisation minimises operator fatigue. Flow rate is controlled via the integrated pressure regulator. The operator controls the amount by holding down the trigger.

ADDITIONAL EQUIPMENT

**400 ml
LOCTITE EQ HD14
400 ml Dual Cartridge Dispenser**
1:1, 2:1, 4:1, 10:1
Manual: IDH 2693823
Pneumatic: IDH 2693825

Please refer to page 128 for additional equipment / information.

Flexible Sealants



**TEROSON
MS 9360**
1K Silane Modified Polymer



Paintability: Yes



Temperature resistance: 100 °C



Cure speed: 24 h

Skin over time: 5 min.
Colour: Black
Cure method: Moisture
Tensile strength: 3,5 N/mm²



**TEROSON
MS 930***
1K Silane Modified Polymer



Paintability: Yes



Temperature resistance: 80 °C



Cure speed: 24 h

Skin over time: 25 min.
Colour: Black, white, grey
Cure method: Moisture
Tensile strength: 1 N/mm²



**LOCTITE
SI 5366**
1K Silicone



Paintability: No



Temperature resistance: 200 °C



Cure speed: 24 h

Skin over time: 5 min.
Colour: Clear
Cure method: Moisture
Tensile strength: 2 N/mm²



**LOCTITE
SI 5368**
1K Silicone



Paintability: No



Temperature resistance: 200 °C



Cure speed: 24 h

Skin over time: 5 min.
Colour: Black
Cure method: Moisture
Tensile strength: 2 N/mm²

FLEXIBLE ADHESIVES

Product	Pack Size	Colour	Features	Extrusion Rate (g/min)	Technology	Skin Over Time (min.)	Temperature Range (°C)	Shore Hardness	Tensile Strength (N/mm²)	Elongation at Break (%)
TEROSON MS 939	290 ml	Black, white, grey	Primerless, good UV / weather resistance, paintable, solvent / isocyanate-free	N/A	Silane Modified Polymer	5	-40 to +100	A 55	3	250
TEROSON MS 9399	400 ml	Part A: Black, white, grey; Part B: Black, white, grey	2K, non-sag, high tack, fast set time	N/A	Silane Modified Polymer	25	-40 to +100	A 55	3	150
TEROSON MS 9220	80 ml, 310 ml	Black	Body Repair – Bonding: for all areas where bonding and sealing is required.	N/A	Silane Modified Polymer	6	-40 to +100	A 60	3	N/A

FLEXIBLE SEALANTS

TEROSON MS 930	310 ml	Black, white, grey	Primerless, good UV / weather resistance, paintable, solvent / isocyanate-free	300	Silicone	25	-50 to +80	A 30	1	250
TEROSON MS 9360	310 ml, 570 ml	Black	Free of solvents, isocyanates, silicones and PVC. The product is odorless and demonstrates good adhesion to many substrates. It is compatible with suitable paint systems.	N/A	Silane Modified Polymer	4 - 10	-40 to +100	A 60	3,5	200
LOCTITE SI 5366	310 ml	Clear	Good resistance to extreme thermal and UV cycling without hardening, shrinking or cracking	40	Silicone	5	-50 to +200	A 25	2	530
LOCTITE SI 5368	310 ml	Black	Good resistance to extreme thermal and UV cycling without hardening, shrinking or cracking	100	Silicone	5	-50 to +200	A 25	2	435

A Single Flexible Option to Replace Other Elevator Joint Methods

“TEROSON MS 930 reduced our elevator door production time and cost, while improving product quality.”



Manufacturers of elevators and elevator components have discovered that **Teroson MS 930** Flexible Adhesive allows them to replace everything from other adhesives to welded connections with a single solution that performs better and is faster, easier and safer to apply.

A LOCTITE Engineering Solutions Expert helped one elevator door manufacturer replace spot welding operations for internal door supports with **Teroson MS 930** to improve product quality and simplify the assembly process. Another manufacturer designing a new elevator door jamb learned how to use **Teroson MS 930** to replace a competitor's adhesive tape that required a flammable solvent primer to apply, resulting in improved plant safety and increased production output. Both manufacturers substantially reduced materials cost as well.

BENEFITS

Teroson MS 930 Flexible Adhesive:

- Disperses joint load distribution over the entire flange versus spot weld contact points
- Reduces plant power consumption compared to welding
- Does not deform the metal surface and eliminates refinishing required after welding operations
- Improves plant safety by eliminating flammable solvent primer
- Increases production output by up to 90 % with faster dispensing speed and assembly
- Provides material cost savings of as much as 27 % compared to adhesive tape

Strength.
Transparency.
Rapid curing.

For faster process speeds.

LIGHT CURE ADHESIVES



PROBLEM

Without light cure adhesives:
Longer cure times and slower processing.

SOLUTION

With light cure adhesives:
High speed cure on demand.

Excellent bonding.
Fast processing.

Light cure adhesives are ideal for applications requiring fast production speeds and are commonly used in the assembly of glass-ware, loudspeakers, optical instruments, electrical components, and disposable medical devices. To help select the best product for your application, key considerations include the ability of the assembled parts to transmit the UV / visible light to the bond line, whether a rigid or flexible bond line is required, and the types of substrates being bonded.



BEST SELLER

LOCTITE AA 3494

Glass Bonding

LOCTITE 3494 is a clear, medium viscosity, acrylic-based adhesive that sets in seconds when exposed to the proper UV / visible light intensity. The adhesive is ideal for bonding glass, plastic and metal parts, and provides an impact resistant bond that withstands prolonged exposure to humidity and water immersion.



Bond type:

Semi-rigid



Substrate:

Glass, metals, plastics



How to choose a light cure adhesive.



LIGHT TRANSPARENT SUBSTRATE VS. OPAQUE

Use visible light cure adhesives for UV-stabilised, transparent substrates. For opaque substrates, dual cure adhesives expand the benefits of light cure technology to non-transparent substrates and other application areas.



BOND TYPE

FLEXIBLE

Highly flexible bonds that offer high thermal cycle resistance and are suitable for elastic bonding, sealing and leak-proofing.

RIGID

High-strength adhesives that cure quickly and provide tough bond lines that are suitable for bonding rigid plastics and metals.



SUBSTRATE

Many light cure adhesives are specially formulated to provide optimum performance on specific substrates, so the adhesive is best suited for the intended application.

Find the right
product for
your application



Transparent Substrates

LOCTITE AA 3951
LOCTITE AA 3953
LOCTITE AA 3922

Opaque Substrates

LOCTITE AA 352
LOCTITE AA 3504

Transparent Substrates



**LOCTITE
AA 3951**
Ultra Fast, Plastic Bonding,
Low Viscosity



Bond type: Flexible



Substrate: Plasticised PVC, TPEs,
thermoset rubbers, polycarbonate,
ABS, acrylic, HDPE, PP

Chemistry: Acrylic
Viscosity: 150 mPa·s
Compliant with ISO 10993: Yes
Fluorescence: Yes
Colour: Transparent, colourless to straw



**LOCTITE
AA 3953**
Ultra Fast, Plastic Bonding,
Medium Viscosity



Bond type: Flexible



Substrate: Plasticised PVC, TPEs,
thermoset rubbers, polycarbonate,
ABS, acrylic, HDPE, PP

Chemistry: Acrylic
Viscosity: 550 mPa·s
Compliant with ISO 10993: Yes
Fluorescence: Yes
Colour: Transparent, colourless to straw



**LOCTITE
AA 3922**
General Purpose,
Medium Viscosity



Bond type: Semi-rigid



Substrate: Metals, plastics

Chemistry: Acrylic
Viscosity: 300 mPa·s
Compliant with ISO 10993: Yes
Fluorescence: Yes
Colour: Transparent to hazy

Opaque Substrates



**LOCTITE
AA 352**
Toughened



Bond type: Rigid



Substrate: Metal, glass

Chemistry: Acrylic
Viscosity: 20.500 mPa·s
Compliant with ISO 10993: No
Fluorescence: No
Colour: Clear / light amber



**LOCTITE
AA 3504**
Magnet Bonding



Bond type: Rigid



Substrate: Metals, magnets

Chemistry: Acrylic
Viscosity: 1.000 mPa·s
Compliant with ISO 10993: No
Fluorescence: No
Colour: Amber



Equipment

Dispensing



LOCTITE 98815
 Manual Syringe Dispenser 30 ml
 IDH 1544934

A hand-held, manually operated dispenser, for any product packaged in a standard 30 ml syringe. This dispenser provides a convenient, cost-effective method to apply product.



LOCTITE 97006
 Digital Syringe Dispenser
 IDH 88633

A semi-automatic dispensing system designed to dispense LOCTITE adhesives and fluids packaged in 3, 5, 10, 30, 55 syringes and 300 ml cartridges. The unit has digital timing control with decimal settings to 0,001 seconds for increased precision over typical pressure-time systems. An adjustable pressure regulator controls a pulse of air, and when used in conjunctions with an air line adapter attached to an adhesive syringe barrel, will provide a controlled dispensed amount of adhesive.

Equipment

Curing



LOCTITE EQ CL32
 LED Spot

A high powered, portable LED light source that offers a high level of flexibility for all UV or visible light curing needs. The light weight, compact design helps minimise operator fatigue, while its small size and long focus length make it perfect for applications in crowded areas and hard to reach bond areas.

EQ CL32 405 nm LED Spot
 IDH 2182207

EQ CL32 365 nm LED Spot
 IDH 2182210



LOCTITE EQ CL40
 LED Light-Curing Systems

The LOCTITE CL40 LED Spot-Cure System offers a cost-effective, high-output solution for all your light-curing needs. Its compact size and multi-channel design offer a high level of flexibility for integrating into most manufacturing processes. The system provides all the benefits of LED technology while maintaining one of the highest intensity outputs available.

CL40 LED Spot Quad Controller
 IDH 2804936

CL40 LED Spot Light 405 nm
 IDH 2804937

CL40 LED Spot Light 365 nm
 IDH 2804938

ADDITIONAL EQUIPMENT

LOCTITE 97009
Semi Automatic Dispensing
System HP (High Pressure)

IDH 215845

LOCTITE 97113
Stationary Applicator Valve

IDH 88644

LOCTITE 98009
Light Cure Diaphragm
Dispense Valve

IDH 218280

LOCTITE EQ VA20
Volumetric Valve

IDH 2084141

Please refer to page 128 for additional equipment / information.

LIGHT CURE ADHESIVES

Product	Pack Size	Appearance	Cure Type	Key Substrates	Viscosity (mPa•s)	Temperature Range (°C)	Hardness	Block Shear Strength, PC (N/mm²)
TRANSPARENT SUBSTRATES								
LOCTITE AA 3922	25 ml, 1 l	Transparent to hazy liquid	Ultraviolet (UV) / visible light	Metals, plastics	300	-55 to +130	D 66	23
LOCTITE AA 3951	25 ml, 1 l	Transparent, colourless to straw coloured liquid	Ultraviolet (UV) / visible light	Plasticised PVC, TPES, thermoset rubbers, polycarbonate, ABS, acrylic, HDPE, PP	150	-55 to +100	D 62	22
LOCTITE AA 3953	25 ml, 1 l	Transparent, colourless to straw coloured liquid	Ultraviolet (UV) / visible light	Plasticised PVC, TPES, thermoset rubbers, polycarbonate, ABS, acrylic, HDPE, PP	550	-55 to +100	D 56	22
OPAQUE SUBSTRATES – ABILITY TO CURE IN AREAS SHADOWED FROM LIGHT								
LOCTITE AA 352	250 ml, 1 l	Transparent light amber liquid	Dual Cure (Ultraviolet (UV) light & activator cure)	Metal, glass	20.500	-55 to +150	D 60	8*
LOCTITE AA 3504	250 ml	Amber liquid	Dual Cure (Ultraviolet (UV) light & anaerobic cure)	Metals, magnets	1.000	-55 to +150	D 45	N/A

* PC to glass

ADDITIONAL EQUIPMENT

LOCTITE EQ CL42
LED Light-Curing Systems

CL42 Dual LED Controller
 IDH 2804957

CL42 LED Spot Light 365 nm
 IDH 2804955

CL42 LED Spot Light 405 nm
 IDH 2804956

CLEANERS

Over 60 years of experience
with cleaners and degreasers.

For safe, effective cleaning.

PROBLEM	SOLUTION
Without cleaners and degreasers: Contaminants, soils and oils on components cause performance failures in production and plant operations.	With cleaners and degreasers: Cleaner components increase production quality, help to decrease operating costs, and maximise performance of LOCTITE Adhesives.

Clean parts, hands and mechanical equipment

LOCTITE cleaners and degreasers provide highly effective water- and solvent-based cleaning of components, worktops, floors, parts and hands. The major factors to consider are drying time, residue, odour and substrate compatibility.



BEST SELLER

LOCTITE SF 7063

General Purpose Parts Cleaner

LOCTITE SF 7063 is a general purpose parts cleaner for cleaning and degreasing any kind of surface or machinery component before proceeding with a bonding or sealing application. It is solvent-based and leaves no residue. LOCTITE SF 7063 removes most greases, oils, lubrication fluids and metal cuttings.

Benefits:

- Ideal for use prior to adhesive bonding and sealing applications
- Leaves no residue



How to choose the right cleaner.

DEGREASING / PARTS CLEANING

For removing dirt, resins, metal filings, lacquer, oils and greases from components.

HAND CLEANING

Available with and without abrasives for removing dirt, grease, grime, oil and adhesives from hands.



BEST SELLER

LOCTITE SF 7200

Parts Cleaner, Gasket Remover

LOCTITE SF 7200 is a solvent-based cleaner designed to remove cured chemical gaskets in 10 – 15 minutes, by softening the material on the metal flanges. Once applied, the product develops a foam-like layer on the gasket, preventing the agent from running off the desired location. It therefore keeps working for the required duration. It is particularly suitable for aluminium or other soft metal flanges, where scraping could lead to surface damage.

Benefits:

- Minimal scraping
- Usable on most types of surface

Find the right product for your application



Degreasers & Parts Cleaners

LOCTITE SF 7063
LOCTITE SF 7200
LOCTITE SF 7840

Hand Cleaners

LOCTITE SF 7850

PLEASE CONTACT YOUR
HENKEL REPRESENTATIVE
FOR MORE INFORMATION

on the full range
of cleaning products.

Degreasers & Parts Cleaners



LOCTITE
SF 7063
Parts Cleaner

General purpose, solvent-based parts cleaner and degreaser for use prior to bonding and sealing applications. Dries residue-free.



LOCTITE
SF 7200
Gasket Remover

General purpose, solvent-based parts cleaner designed to remove cured chemical gaskets on metal flanges with minimal scraping.



LOCTITE
SF 7840
Water-based

Concentrated, general purpose, biodegradable parts cleaner and degreaser. Solvent-free, non-toxic and non-flammable. Can be diluted with water.

Hand Cleaners



LOCTITE
SF 7850
No-Rinse

A general purpose, natural hand cleaner containing no petroleum solvents. It cleans with or without water and can remove ground-in dirt, grease, grime, inks, oils, paint and glues.

CLEANERS

Product	Pack Size	Application Area	Speciality	Odour
DEGREASERS				
LOCTITE SF 7063	400 ml, 10 l, 200 l	Parts cleaning prior to bond	Fast evaporation – residue-free	Solvent
LOCTITE SF 7840	750 ml, 5 l, 20 l, 200 l	General parts, machine and workshop cleaner	Biodegradable	Pleasantly fresh
PARTS CLEANER				
LOCTITE SF 7200	400 ml	Gasket remover	Strong foam-like layer to remove cured gaskets	Solvent
HAND CLEANER				
LOCTITE SF 7850	400 ml, 3 l, 10 l	Hand cleaner with natural abrasives	Contain premium skin conditioner like aloe vera, lanolin and jojoba	Fresh citrus



WEAR PREVENTION

Fight abrasion, erosion, corrosion, chemical attack and wear.

For longer, more efficient performance.



PROBLEM

Without wear resistant coatings:
Abrasion and corrosion can damage components.

SOLUTION

With wear resistant coatings:
Components are protected from direct process damage and equipment life is extended.

Protect. Repair. Rebuild.

Wear prevention solutions provide a sacrificial coating on new or worn surfaces, to provide wear and impact resistance and extend the life of parts. LOCTITE offers a range of wear prevention solutions for a range of applications.



BEST SELLER

LOCTITE PC 7218

General Purpose

LOCTITE PC 7218 is a 2K, grey, ceramic-filled, trowelable, epoxy-based surface coating designed to protect parts from coarse particle abrasion or erosion on metals (with or without chemical attack). It is designed for parts such as cyclones / separator bodies, dust collectors / exhausters, pump liners / impellers, fan blades and housings, chutes / hoppers and elbows and transition points.

Benefits:

- Suitable for chemical attack applications
- Applied by trowel
- Renews worn surfaces fast



How to choose the right wear prevention.



PARTICLE ABRASION

Trowelable, brushable and sprayable solutions for fighting abrasion from particles ranging from small to large.



FLUID EROSION

Coatings to combat the fine particles found in fluids on components such as a pump.



CHEMICAL ATTACK

Advanced epoxy products to protect equipment from extreme chemical attack and corrosion.

Surface Preparation

Correct surface preparation is crucial for the successful application of both, metal repair products and protective coatings and compounds. Good surface preparation will:

- Improve adhesion to parts
- Prevent corrosion between the surface and product used
- Extend maintenance intervals

The two main important factors for a successful application are **surface profile** and **surface cleanliness**.



BEST SELLER

LOCTITE PC 7226

Fine Particle

LOCTITE PC 7226 is a 2K, grey, carbide-filled, trowelable, non-sagging, epoxy-based surface coating designed to protect metal parts from fine particle abrasion or erosion (with or without chemical attack). It is suitable for overhead and vertical applications. Typical applications include dredge pump liners, flumes and troughs, pump impellers, vibrating feeders and chutes / hoppers.

Benefits:

- Prolongs equipment life



Find the right product for your application



Particle Abrasion

LOCTITE PC 7218
LOCTITE PC 7226

Fluid Erosion

LOCTITE PC 7227
LOCTITE PC 7255

High Temperature Resistance

LOCTITE PC 7234

Particle Abrasion



LOCTITE
PC 7218
Large Particles

Working life: 30 min.
Drying time: 7 h
Temperature (max): 120 °C
Colour: Thick grey paste



LOCTITE
PC 7226
Fine Particles

Working life: 30 min.
Drying time: 6 h
Temperature (max): 120 °C
Colour: Grey

Fluid Erosion



LOCTITE
PC 7227
Brushable

Working life: 34 – 48 min.
Drying time: 4 h
Temperature (max): 100 °C
Colour: Grey



LOCTITE
PC 7255
Sprayable

Working life: 40 – 70 min.
Drying time: 4 h
Temperature (max): 110 °C
Colour: Brilliant green or grey

High Temperature Resistance



LOCTITE
PC 7234
Brushable

Working life: 40 min.
Drying time: 2,5 h
Temperature (max): 200 °C
Colour: Red

PLEASE CONTACT YOUR
HENKEL REPRESENTATIVE
FOR MORE INFORMATION

on the full range
of wear prevention products.

WEAR PREVENTION

Product	Pack Size	Coverage	Colour	Maximum Operating Temp. (°C)	Compressive Strength (N/mm²)	Hardness Shore D	Working Time (min.)	Functional Cure (h) 25 °C	Mix Ratio by Volume	Mix Ratio by Weight
PARTICLE ABRASION										
LOCTITE PC 7218	1 kg, 10 kg	720 cm² @ 6 mm thick per 1 kg kit	Thick grey paste	120	110	90	30	7	2:1	2:1
LOCTITE PC 7226	1 kg	800 cm² @ 6 mm thick per 1 kg kit	Grey	120	103	85	30	6	4:1	4:1
FLUID EROSION										
LOCTITE PC 7227	1 kg	0,8 m² @ 1 mm thick per 1 kg	Grey	100	86	85	34 – 48	4	2,75:1	4,8:1
LOCTITE PC 7255	1,125 l	2,2 m² @ 0,5 mm thick per cartridge of 1,125 l	Brilliant green or grey	110	106	86	40 – 70	4	100:50	100:50
HIGH TEMPERATURE RESISTANCE										
LOCTITE PC 7234	1 kg	1,1 m² @ 0,5 mm per 1 kg	Red	200	102	88	40	8 h @ 20 °C + 3 h @ 150 °C	2,6:1	4,25:1

Equipment



LOCTITE EQ HD12
PNEUMATIC SPRAY
DISPENSER

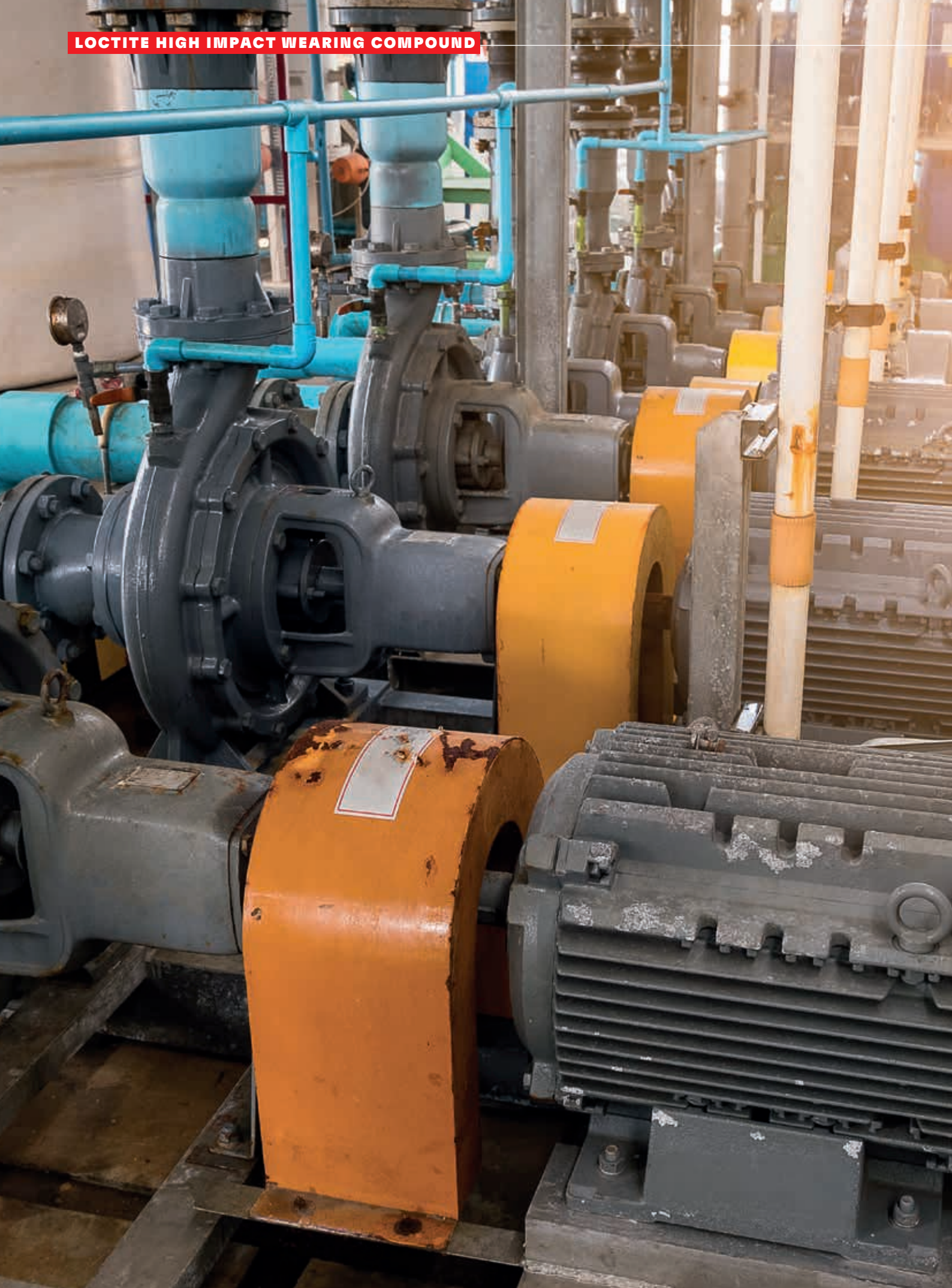
IDH 2251591

It is suitable for spraying LOCTITE PC 7255 and is designed for 2:1 mix ratio.
Corresponding spray nozzle: IDH 2447734

LOCTITE SERVICES

PROTECT COMPONENTS AND
EXTEND OPERATIONAL LIFE.





Coating against fluid erosion.

“Thanks to a LOCTITE Engineering Solutions Expert, reliability and performance has been improved.”



An industrial pump repair shop needed to improve reliability and performance for a customer's municipal wastewater pumps, which were failing prematurely due to erosion and abrasion. During an on-site consultation, a LOCTITE Technical Sales Engineer suggested **LOCTITE EA 3478 Superior Metal** and **LOCTITE PC 7255 Sprayable Ceramic** to repair damage and protect the wetted components against the harsh conditions.

The LOCTITE Technical Sales Engineer guided the team on how to properly prepare the surface, to ensure maximum adhesion and longevity. To fill large gaps in the pump caused by abrasion and erosion, **LOCTITE EA 3478 Superior Metal** was used to rebuild the pump geometry, followed by the application of **LOCTITE PC 7255 Sprayable Ceramic** to coat and protect all wetted components in the pump. Once back in service, the pump's mean time between failures was greatly increased, allowing for more reliable operation and maintenance schedules.

BENEFITS

LOCTITE EA 3478 Superior Metal and LOCTITE PC 7255 Sprayable Ceramic

- Fills large gaps caused by abrasion and erosion
- Coats and protects wetted components
- Increases mean time between failure
- Allows for more regular operation and maintenance schedules

REBUILDING

Repair shafts and other steel, aluminium or rubber components.

For longer life and better chemical resistance.



PROBLEM

Without rebuilding:
Damaged components reduce process efficiency, add excess stress to equipment, increase safety hazards and most importantly, add costs.



SOLUTION

With rebuilding:
Equipment is repaired quickly on-site, component integrity and seals are restored, process efficiencies are enhanced, and costs are minimised through part and component salvage.

Rebuilding damaged parts.

Rebuilding solutions can be used to repair rubber, steel, aluminium and other metal components. Metal rebuilding solutions offer high compressive strength and can be machined, drilled or tapped after cure. Rubber repair solutions offer excellent abrasion resistance and outstanding adhesion to metal and rubber.



BEST SELLER

LOCTITE EA 3478

High Performance

LOCTITE EA 3478 is a 2K, ferro-silicon filled epoxy resin system. It is extremely resistant to corrosion, chemical attack and abrasion. Helps to restore tolerances to worn shafts, repairing worn keyways and damaged housings, filling pitted surfaces in worn machinery and restoring fit to bearing housings.



Working time:
20 min.



Functional cure speed:
6 h



How to choose a rebuilding product.

Choose a rebuild product based on substrate type and form of solution desired. LOCTITE offers a range of rebuilding solutions from kneadable to flowable.



DAMAGED METAL PART

Trowelable or kneadable solutions for repairing, restoring or rebuilding damaged metal machinery, equipment and parts without the need for heat or welding.



DAMAGED RUBBER PART

Durable, tough and flexible repairs of conveyor belts and other damaged rubber equipment and parts, quickly and easily.



BEST SELLER

LOCTITE PC 7352

Rubber Repair

LOCTITE PC 7352 is a premium rubber repair compound designed for conveyors and other rubber parts. It offers excellent abrasion resistance and outstanding adhesion to metal and rubber.

Benefits:

- Trowelable paste, provides a flexible abrasion resistance
- Fills gaps between rubber liners, at corners or any other difficult-to-reach areas
- Works in vertical and overhead positions



Working time:
4 min.



Functional cure speed:
2 h

Find the right product for your application



Damaged Metal Parts

LOCTITE EA 3463
LOCTITE EA 3471
LOCTITE EA 3475
LOCTITE EA 3478

Damaged Rubber Parts

LOCTITE PC 7352

PLEASE CONTACT YOUR
HENKEL REPRESENTATIVE
FOR MORE INFORMATION

on the full range
of rebuilding products.

Damaged Metal Parts



LOCTITE
EA 3463
Fast Repair



LOCTITE
EA 3471
Steel Putty



Working time: 3 min.



Working time: 45 min.



Cure speed: 10 min.



Cure speed: 12 h

Substrate: Metal
Form: Kneadable putty

Substrate: Metal
Form: Trowelable



LOCTITE
EA 3475
Aluminium Putty



LOCTITE
EA 3478
High Performance



Working time: 45 min.



Working time: 20 min.



Cure speed: 12 h



Cure speed: 6 h

Substrate: Aluminium
Form: Trowelable

Substrate: Metal
Form: Trowelable

Damaged Rubber Parts



LOCTITE
PC 7352
Rubber Repair



Working time: 4 min.



Cure speed: 2 h

Substrate: Rubber
Form: Pasty

Equipment

DISPENSERS

Pneumatic



Manual



Please refer to page 128 for additional equipment / information.

LOCTITE EQ HD14
400 ml
Dual Cartridge
Pneumatic Dispenser
1:1 – 10:1
IDH 2693825

LOCTITE EQ HD14
400 ml
Dual Cartridge
Manual Dispenser
1:1 – 10:1
IDH 2693823

Suitable nozzle:
TEROSON ET QUAD STATMIX BIG10PC
IDH 780805

RUBBER & BELT REPAIR

Product	Pack Size	Coverage Per Kit	Colour	Tensile Strength (N/mm²)	Elongation (%)	Hardness Shore A	Working Time (min.)	Functional Cure (h), 25 °C
RUBBER REPAIR								
LOCTITE PC 7352	400 ml	650 cm² for 6 mm thickness	Mixed: Black	15	850	70	4	2

REBUILD EPOXIES

Product	Pack Size	Coverage Per Kit	Colour	Compressive Strength (N/mm²)	Tensile Strength (N/mm²)	Hardness Shore D	Working Time (min.)	Functional Cure, 25 °C
STICK								
LOCTITE EA 3463	114 g	45 cm² for 6 mm thickness	Metallic black	50	18	≥70	3	10 min.
TROWELABLE								
LOCTITE EA 3471	500 g	470 cm² for 5 mm thickness	Grey putty	70	50	82	45	12 h
LOCTITE EA 3475	500 g	450 cm² for 6 mm thickness	Grey putty	70	50	85	45	12 h
LOCTITE EA 3478	453 g	232 cm² for 6 mm thickness	Grey putty	125	38	86	20	6 h

LOCTITE SERVICES

RESTORE COMPONENT INTEGRITY.



Restoring Worn Metal to its Near-Original Dimensions.



“We went from replacing 2 impellers a year to almost never replacing impellers, thanks to LOCTITE.”

A water treatment plant with 25 mixer impellers was searching for a way to avoid the high cost of OEM replacement parts. The plant was replacing at least 2 impellers each year at a cost of \$6,000 per unit, plus the cost of renting a crane to remove the impellers. They had tried competitive wear resistant coatings previously, but they failed after only a few months of use. **LOCTITE EA 3478** and **LOCTITE PC 7227** were an ideal solution for restoring the impellers. The impellers were removed from service and grit blasted to leave a bare metal surface.

A LOCTITE Engineering Solutions Expert showed the team how to first clean with **LOCTITE SF 7063** to remove any oil or grease residues and apply **LOCTITE EA 3478** to restore eroded surfaces to a near-original surface dimension, grinding the cured product as needed to optimise impeller efficiency. Finally, a primary coat of **LOCTITE PC 7227** was applied. The result: the plant has eliminated almost all impeller replacement costs while reducing downtime expenses substantially.

BENEFITS

LOCTITE EA 3478 Superior Metal:

- Restores impeller original dimensions to improve pumping efficiency.

LOCTITE PC 7227 Brushable Ceramic:

- Protects metal from abrasion to prolong impeller service life.

LUBRICANTS

Long-lasting lubrication.

**For longer component life
and performance.**



PROBLEM

Without lubricants:
Moving parts can corrode and seize.



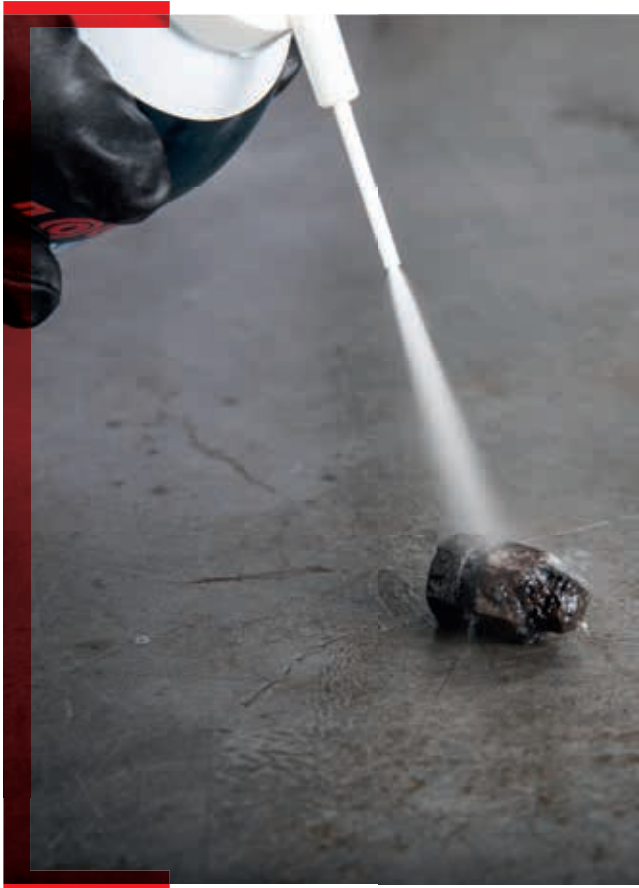
SOLUTION

With lubricants:
Assemblies maintain performance longer.

Keep moving
parts moving.

LOCTITE offers lubricants that can address and protect against friction and wear. Lubricants are also used to protect against corrosion by displacing moisture and leaving a continuous coating on the part.

PLEASE CONTACT YOUR
HENKEL REPRESENTATIVE
FOR MORE INFORMATION
on the full range of lubricants.



BEST SELLER

LOCTITE LB 8040

Seized, Rusted Parts

LOCTITE LB 8040 is the solution for releasing seized or corroded parts. Instantly freezes seized and rusted parts (bolts, nuts, studs) down to -43 °C. The shock-freeze causes microscopic cracks in the layer of rust, allowing the lubricating ingredient to wick directly into the rust. Dismantles parts in 1 – 2 minutes.

Benefits:

- Wicks directly into the rust by capillary action
- Released parts remain lubricated and protected from corrosion



Temperature resistance:
N/A



Base oil:
Mineral oils, silicone-free



BEST SELLER

LOCTITE LB 8201

Multi-Purpose, 5-Way Spray

LOCTITE LB 8201 is a penetrating oil which frees, lubricates, cleans, dries and prevents corrosion on machinery. It is used to free seized or corroded parts such as threaded fasteners, hinges and cylindrical joints. It provides light lubrication and displaces moisture from damp electrical devices to leave a protective anti-corrosive film.

Benefits:

- Five-way spray: Frees assemblies, lubricates metal, cleans parts, displaces moisture, prevents corrosion



Temperature resistance:
-20 to +120 °C



Base oil:
Mineral oils, silicone-free

What considerations
are important when
choosing a lubricant?

When choosing a lubricant, it is important to consider the intended application as well as the environmental conditions to which the assembly will be exposed. Environmental conditions are critical to the successful selection of the right lubricant product. Factors including high temperature, harsh chemicals and contaminants may have an adverse effect on the expected lubricant performance.



ANTI-SEIZE PRODUCTS

Prevent seizing.
**Even in extreme
environments.**



PROBLEM

Without anti-seize lubricants:
Parts seize at extreme temperatures or in
corrosive environments.

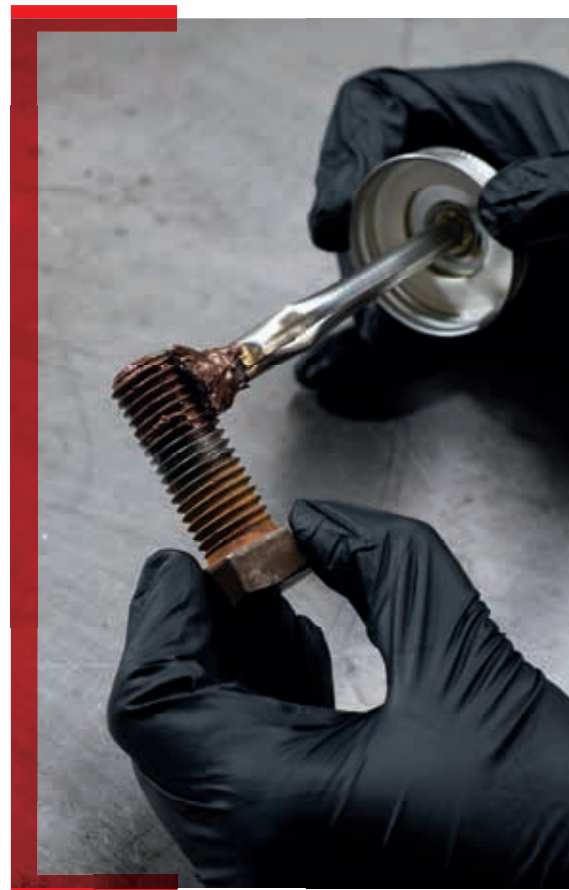


SOLUTION

With anti-seize lubricants:
Assemblies maintain operation in all types
of extreme conditions with more reliable
removal and on-torque performance.

Keep assemblies from seizing.

Anti-seize lubricants are used in harsh environments to keep assemblies from seizing. They also protect against rust, corrosion and galling even in extreme temperature conditions. Temperature is a key consideration when choosing a LOCTITE anti-seize lubricant, along with substrate material and contamination restrictions.



BEST SELLER

LOCTITE LB 8008

Copper-based

LOCTITE LB 8008 is an anti-seize lubricant with an exclusive formula that suspends copper and graphite in a high quality grease. It protects metal parts from rust, corrosion, galling and seizing at temperatures to 980 °C.

Benefits:

- Unique brush top
- NLGI grade of 0
- Protects from rust, corrosion, galling and seizing



Temperature resistance:
980 °C



Metal free:
No



How to choose the right anti-seize product.



TEMPERATURE

LOCTITE anti-seize lubricants are designed to protect your equipment from a wide range of temperatures, which allows for a wide range of applications. To choose the right anti-seize lubricant, choose the conditions in which your equipment operates, up to 1.315 °C.



METAL FREE

LOCTITE metal-free formulations – a growing concern for all types of industries is the dispersal of “heavy” metals like lead, nickel, zinc and others, into the environment. Metal-free formulations offer the same performance as traditional products without heavy metals.



BEST SELLER

LOCTITE LB 8023

Water Wash-out Resistance

LOCTITE LB 8023 is a black, metal-free anti-seize lubricant. ABS* approved, it protects assemblies from fresh and salt water. It works especially well in high humidity conditions. It has excellent lubricity, superior water wash-out resistance and prevents galvanic corrosion.

Benefits:

- Temperature resistant up to +1.315 °C
- Fresh & salt water / high humidity resistance



Temperature resistance:
1.315 °C



Metal free:
Yes

*American Bureau of Shipping

Find the right product for your application



General Purpose

LOCTITE LB 8150
LOCTITE LB 8008

High Performance

LOCTITE LB 8009
LOCTITE LB 8023

PLEASE CONTACT YOUR
HENKEL REPRESENTATIVE
FOR MORE INFORMATION

on the full range
of anti-seize products.

General Purpose

**LOCTITE
LB 8150**
Silver Grade

 **Temperature resistance:**
Up to 900 °C

 **Metal free:** No

Colour: Silver
Solid lubricating agent: Aluminium, graphite, extreme pressure (EP) additives

**LOCTITE
LB 8008**
Copper

 **Temperature resistance:**
Up to 980 °C

 **Metal free:** No

Colour: Copper
Solid lubricating agent: Copper / graphite

High Performance

**LOCTITE
LB 8009**
Heavy Duty

 **Temperature resistance:**
Up to 1.315 °C

 **Metal free:** Yes

Colour: Grey
Solid lubricating agent: Graphite / calcium fluoride

**LOCTITE
LB 8023**
Water Wash-out Resistance

 **Temperature resistance:**
Up to 1.315 °C

 **Metal free:** Yes

Colour: Black
Solid lubricating agent: Graphite, calcium sulfonate, rust inhibitors

ANTI-SEIZE PRODUCTS

Product	Pack Size	Temperature Resistance (°C)	Colour	Specialty	Metal-Free (Yes / No)
GENERAL PURPOSE					
LOCTITE LB 8150	500 g	900	Silver	Extreme pressure (EP) additive	No
LOCTITE LB 8008	453 g	980	Copper	C5-A Anti-Seize	No
HIGH PERFORMANCE					
LOCTITE LB 8009	453 g	1.315	Grey	Heavy duty	Yes
LOCTITE LB 8023	453 g	1.315	Black	Marine Anti-Seize	Yes



SPECIALTY MAINTENANCE

Solutions for any situation.

Even unexpected ones.

For a wide range of specialised maintenance and repair scenarios.

With deep expertise in industrial maintenance and repair, LOCTITE has been able to develop a wide range of technologies suitable for solving nearly all situations.



LOCTITE SF 7900

Welding Protection

LOCTITE SF 7900 is a unique, silicone-free ceramic protective coating that prevents metal spatter from adhering to welding equipment. The coating forms a dry film that repels spatter and ensures uninterrupted welding for up to 8 hours without the need for re-application. It is suitable for manual MIG / MAG welding, laser and plasma cutting, or for protecting jigs, fixtures and fittings.

Benefits:

- Excellent surface adhesion
- Eliminates cleaning processes



PIPE REPAIR

Easy-to-use urethane-impregnated fibre-glass tape for temporary / medium-term repair of leaking pipes.

GROUTING & CONCRETE REPAIR

Self-levelling, non-shrinking grouting that is stronger than concrete, and chemical and corrosion resistant.

RUST PREVENTION & CONVERSION

Stabilises existing rust, guards against corrosion, prevents electrochemical corrosion and provides protection against flash rust.

WELDING PROTECTION

Protects welding equipment against metal spatter for 8 hours without reapplication.

INSULATING & SEALING

Self-fusing silicone wrap for electrical insulation and sealing applications even for pipes under pressure.

SPECIALTY REPAIR

To meet tough, on-the-job requirements, these specialty repair products get the job done.

Find the right product for your application



Pipe Repair

LOCTITE PC 5070

Concrete Repair

LOCTITE PC 9410 MAGNA CRETE

Insulating & Sealing

LOCTITE SI 5075

Welding Protection

LOCTITE SF 7900

Anti Slip Coatings

LOCTITE PC 6261

LOCTITE PC 6315

Rust Prevention & Conversion

LOCTITE SF 7515

LOCTITE SF 7505

TEROSON VR 625

Specialty Repair

LOCTITE SF 7100

TEROSON VR 5080

LOCTITE O-RING KIT

Pipe Repair



LOCTITE
PC 5070
Emergency Repair Kit

An emergency repair product for sealing pipe leaks. Includes LOCTITE EA 3463 and urethane-impregnated fibreglass tape (activated by water) for the temporary repair of weak areas on metal, plastic and composite pipes. Cures in 30 minutes.

Welding Protection



LOCTITE
SF 7900
Ceramishield

Innovative ceramic coating that protects welding equipment against metal spatter for 8 hours without re-application. Minimises downtime, reducing cost and enhancing productivity.

Concrete Repair



LOCTITE PC
9410 MAGNA
CRETE
Magna-Crete Concrete Repair

Grey, 2-part, rapid setting, liquid magnesium phosphate-based concrete repair and grouting system that outperforms conventional concrete repairs. This product is typically used wherever concrete is used in the construction and roads industries like runways, floors and bridges. Operating range of -50°C to 1100°C.

Anti Slip Coatings



LOCTITE
PC 6261

Non-slip, single-component epoxy floor and deck coating designed for application in areas of heavy pedestrian traffic or light rolling traffic. It is a room temperature-cure product with typical dry service temperatures of -29 °C to +60 °C. It is used for concrete and steel ramps, walkways, locker rooms, loading docks, marine applications, machine rooms, assembly areas and stairs.

Rust Prevention & Conversion



LOCTITE
SF 7515
Rust Prevention

Amber, water-based, liquid surface treatment that delivers 48-hour protection against flash rust on large surfaces. Straightforward spray and wipe application.



LOCTITE
SF 7505
Rust Converter

Converts existing rust (rust required) into a stable, black base that forms a protective coating on exposed iron and steel surfaces. Cured product acts as a primer, ready for painting with oil or solvent-based paint. Suitable for metal pipes, fittings, storage tanks, railings, conveyors, and construction and agricultural equipment.



TEROSON
VR 625
Rust Converter

Slightly brownish, clear, solvent-based, synthetic resin-based liquid rust converter aerosol used to treat various forms of rust. Organic agents convert the rust into a stable complex compound causing color changes into a brown-black color. It forms a paint-like, protective, adhesive film with excellent adhesion which remains on the metal and may be used as a primer.

Specialty Repair



LOCTITE
SF 7100
Leak Detection

A leak detection product for emergency repairs on pressurised gas and compressed air systems. Applied by aerosol, this colourless product produces bubbles at leakage points. Non-flammable and non-toxic, it is suitable for iron, copper and plastic pipes with a service temperature range of +10 to +50 °C.



TEROSON
VR 5080
Tape

A multi-purpose, high strength adhesive tape for emergency repairs. Ideal for temporarily repairing, reinforcing, fixing, sealing or protecting parts. It adheres to any dry, oil- and dust-free surface and is water resistant. It is suitable for indoor and outdoor applications with temperature resistance up to +70 °C.



LOCTITE
O-RING KIT

LOCTITE O-Ring Kit - contains rubber cords and tools to create customized O-rings. LOCTITE 406 adhesive is sold separately due to refrigerated storage requirement. O-RING Kit is an emergency repair kit for making replacement O-rings on the spot. It is easy to handle and ready for use in just a few seconds. LOCTITE 406 creates a strong bond line as strong as the rubber itself. The kit contains five different sizes of nitrile rubber cord, a splicing jig and a safety knife. Add 20 g of LOCTITE 406 and you have all you need!

EQUIPMENT

From standard manual dispensing and curing equipment up to advanced application robots.

High Quality Equipment System Solution

LOCTITE = 360° total solution provider

PRESSURE / TIME VALVES

Product Name	Product Image	Description	Application	Benefits
LOCTITE 97130 Ergoloc Valve (IDH 444643)		It is a pneumatically operated handheld dispense valve.	Anaerobic and instant adhesives with viscosities up to 10.000 mPa·s	• Forward closing avoids air entrapment and potential premature curing of cyanoacrylates • Dispenses repeatable drop sizes down to 0,005 g • Stroke adjustment for fine-tuning dispense characteristics • Slim ergonomic design greatly reduces hand fatigue
LOCTITE 97135 / 97136 Diaphragm Dispense Valve (IDH 215846 / 215848)		They are pneumatically actuated dispense valves.	Anaerobic adhesives with viscosities up to 2.500 mPa·s (higher for 97136)	• Fail-safe spring assists closing of valve upon loss of air pressure • Internal components are PTFE to prevent premature curing • Modular design and floating diaphragm allow for easy cleaning
LOCTITE 98013 CA Diaphragm Dispense Valve (IDH 318654)		It is a normally closed diaphragm valve that provides high-resolution stroke adjustment and results in consistent flow control.	Instant adhesives, retaining compounds and threadlockers up to 2.500 mPa·s	• Bubble-free, no-drip dispensing • Precision adjustment of stroke to control flow • Can be used in static position, manually or mounted directly to a robot
LOCTITE 98009 Light Cure Diaphragm Dispense Valve (IDH 218280)		It is a normally closed diaphragm valve that provides high-resolution stroke adjustment and results in consistent flow control.	Light cure adhesives, retaining compounds and threadlockers up to 2.500 mPa·s	• Bubble-free, no-drip dispensing • Precision adjustment of stroke to control flow • Can be used in static position, manually or mounted directly to a robot
LOCTITE 97113 / 97114 Stationary Applicator Valve (IDH 88644 / 88645)		This Dispense Applicator Valve with 1/4" feed line (3/8" feed line with 97114) has a modular design and comprises of a product shut-off valve and valve actuator which provides quick on-line serviceability.	Anaerobic and light cure adhesives with viscosities up to 10.000 mPa·s (higher for 97114)	• Slim, lightweight, seal-less design • Adjustable suck-back feature eliminates stringing and dripping • Can be used in static position, manually or mounted directly to a robot

PRESSURE / TIME CONTROLLERS

Product Name	Product Image	Description	Application	Benefits
LOCTITE 97006 Digital Syringe Dispenser (IDH 88633)		It accurately dispenses adhesives or other fluids directly from syringes.	Adhesives and sealants in 10 ml, 30 ml, 55 ml syringes and 300 ml cartridges with viscosities from 5 mPa·s to paste	• High precision syringe dispenser for maximum dispense accuracy and control • Digital precision regulator for accurate flow control • Vacuum suck back to ensure no drips or run-on • Useful for all kinds of applications such as drops, beads and potting
LOCTITE EQ RC50 Integrated Dispenser (IDH 2814024)		The LOCTITE Pulse RC50 Integrated Dispenser, I4.0, is an enhanced version of the RC40 Integrated Dispenser and offers a digital touch screen for operation, as well as a precision regulator for low-viscosity dispensing. The dispenser is industry 4.0 compatible, providing enhanced communication / connectivity via ethernet or Wi-Fi. The reservoir can accommodate most standard LOCTITE adhesive bottles.	Anaerobic, instant and light cure adhesives in 250 ml and 500 g bottles viscosities >1.500 mPa·s	• Integrated reservoir and controller solution in one system. • Two independent digital timing channels. • Easy-to-use, full-colour touch screen. • The dispenser is industry 4.0 compatible, providing enhanced communication / connectivity via ethernet or Wi-Fi.
LOCTITE EQ RC40 Integrated Semi-Automatic Dispenser (IDH 2814025)		The LOCTITE RC40 Integrated Semi-Automatic Dispenser combines a dual-channel dispense controller and a reservoir into a single unit. The controller provides two independent digital timing channels that provide control of two pneumatic outputs. These outputs can be used to control dispense valves or any other pneumatic device. The reservoir can accommodate most standard LOCTITE adhesive bottles	Anaerobic, instant and light cure adhesives in 250 ml and 500 g bottles viscosities <1,500 mPa·s	• Integrated reservoir and controller solution in one system. • Two independent digital timing channels. • Easy-to-use keypad with LCD display screen for entering values. • Simple menu-driven commands.
LOCTITE 97152 Dual Channel Controller (IDH 1275665)		It is a versatile multi-functional controller for actuating 1 – 2 dispensing valves and accessories. Settings can be made via the membrane keypad and the rotary selector switch. Reservoir pressure is controlled via a precision regulator and monitored electronically.	Depends on the supplementary equipment. E.g. rotorspray, advancing slide, flow monitoring	• 1 – 2 independent dispensing channels • Integrated solenoid valve module • High precision pressure regulator • PLC interface • Online flow monitor signal evaluation

VOLUMETRIC VALVES & PUMPS				
Product Name	Product Image	Description	Application	Benefits
LOCTITE EQ VA20 Volumetric Dispense Valve (IDH 2084141)		It is a positive displacement metering valve that dispenses a precise drop of adhesive with each cycle.	Light cure adhesives with volumes from 1,5 to 12 µL	• High speed automation up to 180 cycles per minute • Easily fed from any LOCTITE reservoir • Estimated lifetime >1 million cycles • Low maintenance requirement • Ideal for needle bonding applications
LOCTITE 97611 Compact Rotor Pump 4.0 (IDH 1196160)		It is a precision volumetric dispenser for accurate dispensing applications. The dispenser uses a rotating displacement method consisting of a rotor and a stator.	Anaerobic, light cure and acrylic adhesives with flow rates from 500 to 6.000 µL/min	• High repeatability • High accuracy +/-1 % valid up to 10.000 mPa·s • Reversible direction of flow (suck-back) allows for an exact stop of the product flow • Useful for all kinds of applications such as drops, beads and potting
LOCTITE Eccentric Rotor Pump (RD-EC Dispenser) (Multiple IDH's)		Self-priming, rotating displacement pump for relatively small capacities. The pump is ideally suited for dosing and pumping liquids with various viscosities up to pasty consistency. Operation direction is reversible with capacity proportional to speed.	Volumetric dispensing of high viscous and especially moisture sensitive adhesives such as SI's or SMP's	The volumetric dosing or conveying of silicones, adhesives, solder pastes, etc. provides benefits like: • Pulsation-free conveying • Self-priming • Easy to clean • No dripping • Multiple different sizes
LOCTITE EQ MM25 Dual Rotor Pump (IDH 1774437)		It consists of two compact rotor-pumps connected by a manifold where the two adhesive components are brought together. The individual rotor pump speeds can be controlled to provide adhesive mix ratios from 1:1 to 10:1.	2K methyl methacrylate (MMAs), epoxy, silicone and hybrid products in 400 ml cartridges (or individual reservoirs)	• Reversible direction of flow (suck-back) allows for an exact stop of the product flow • Designed for use in many applications from stationary work cells to integration with LOCTITE Benchtop Robots
LOCTITE EQ VA40 CA Volumetric valve (IDH 2333708)		It is a positive displacement metering valve designed for dispensing precise volumetric drops of CA's with each cycle.	CA adhesives with volumes from 1,5 to 6 µL	• High speed automation up to 120 cycles per minute • Easily fed from any LOCTITE reservoir • Long life seal design: > 1 million cycles • Designed for simple, no-mess priming • For CA's and flash cure CA's • Viscosities up to 10,000mPa·s • Field repairable • Ideal for precision dot dispensing

VOLUMETRIC CONTROLLERS				
Product Name	Product Image	Description	Application	Benefits
LOCTITE EQ PU20 Digital Peristaltic Dispenser (IDH 2265279)		It is a reliable and effective volumetric dispenser for 1K, low viscosity adhesives. It is great for precise dosing or applications that require a specific flow rate. This dispenser is electro-mechanically operated and does not require the use of air.	Anaerobic, instant and light cure adhesives in 10 ml, 20 g and 30 ml packs as well as solvent-free activators and oils up to a viscosity of approx. 5.000 mPa·s	• Air-free dispensing reduces premature curing and clogging of product • Instant reverse for vacuum suck-back, shuts off the flow of liquid and prevents dripping • Simple and convenient load mechanism for tubing replacement • Digital timer and motor speed adjustment • Multiple operating modes
LOCTITE EQ RC15 Compact Rotor Pump Controller (IDH 1880232)		It provides all control required to operate the 97611 Compact Rotor Pumps. This controls all the dispensing parameters, such as pump speed, volume dispense, reservoir pressure and rotorspray control (if applicable).	Depends on the supplementary equipment	• Easy menu navigation allowing users to select either the amount of product dispensed (in µL) or the dispense rate (in µL/min) • Designed to interface seamlessly with a compact rotor pump • Touch screen display for ease of use • Connects directly to standard LOCTITE reservoirs • Useful for all kinds of applications such as drops, beads and potting
LOCTITE EQ RC24 Pump Control System (IDH 2636370)		It is used for precise control of volumetric eccentric rotor pumps. The RC24 consists of a touch panel control as well as a brushless servomotor with integrated digital controller.	Volumetric dispensing of high viscosity and especially moisture sensitive adhesives such as SI's or SMP's	• Start/stop mode (bead dispensing) • Quantity mode (dot dispensing) • Lightweight servo drive is ideally suited to mounting to the Z axis of Benchtop Robots

FEED SYSTEMS

Product Name	Product Image	Description	Application	Benefits
LOCTITE EQ RC34 Automatic Reservoir (IDH 2830690)		The LOCTITE RC34 Automatic Reservoirs are suitable for the application of LOCTITE adhesives in semi- or fully-automated assembly processes where a LOCTITE controller is already in use. They allow for pressure adjustment and/or management directly from the LOCTITE controller, and include a low-level sensor. The reservoirs can accommodate most standard LOCTITE adhesive bottles.	Adhesive bottle sizes 250 ml, 500 g, 1 l and 2 kg	• Cost-effective dispensing reservoir for a variety of LOCTITE adhesives • Includes dual-point, low-level sensor • Integrates directly with high-functioning LOCTITE controllers • Allows for reservoir pressure to be managed by external controller
LOCTITE 97631 300 ml Cartridge Pusher (IDH 854181)		It is used to dispense LOCTITE products in 300 ml cartridges such as gel-CA, anaerobics, epoxies and silicones.	Adhesives and sealants in 300 ml syringes / cartridges from low to high viscosity (5 mPa·s to paste)	• The Cartridge Dispenser 97631 is used to dispense bubble minimised LOCTITE products in 300 ml cartridges such as gel-CA, anaerobics, epoxies and silicones • In connection with a dispensing valve or eccentric rotor pump it can be used in transfer lines, manual or automatic workplaces
LOCTITE EQ MM30 400 ml Dual Cartridge Pusher (IDH 1529531)		It is used as a supply unit for volumetric 2K dispensers, such as the EQ MM25 Dual Rotor Pump. Two independent piston rods are mechanically driven and include path measurement to increase the process reliability.	2K methyl methacrylate (MMAs), epoxy, silicone and hybrid products in 400 ml cartridges	• Mixing ratio and dispensed volume can be monitored via path measurement and mechanical pointers • Low level sensing • Independent pressure control

BENCHTOP ROBOTS

Product Name	Range of Operation
LOCTITE EQ RB40 200D (IDH 2104801)	200 x 200 x 50 mm
LOCTITE EQ RB40 300D (IDH 2104799)	300 x 300 x 100 mm
LOCTITE EQ RB40 400D (IDH 2104795)	400 x 400 x 100 mm
LOCTITE EQ RB40 500D (IDH 2103369)	500 x 500 x 100 mm

LOCTITE Benchtop Robots have features and accessories custom tailored for adhesive dispensing. These units are fully compliant with RIA (Robotic Industry Association) safety guidelines. Programming accessories, dispensing equipment, integration cables and mounting hardware are sold separately.

BENEFITS:

- Independent dispense on / off purge control button on front panel allows adhesive to be purged from a dispense valve to prevent curing or for aiding initial set-up
- No special programming required
- Teach Pendant (IDH 2268727) program storage capabilities allow dispense program to be easily transferred from robot to robot
- 100 programs, 4.000 points memory per program
- Auto-switching power supply 95-132 VAC or 180-250 VAC



LIGHT CURE SYSTEMS

Product Name	Product Image	Description	Application	Benefits
LOCTITE EQ CL32 LED Spot 365 nm / 405 nm Cure Pen (IDH 2182210 / 2182207)		It is a UV / visible light emitting light source. This system offers a high powered, portable light source capable of consistently curing light cure products that respond to UV / visible light. Due to its unique LED technology, it can provide instant on / off performance and consistent light output. It can be run on its rechargeable batteries or while plugged to the included wall plug adapter.	UVA and UVV curing products	• Combines handheld and stationary unit in one device • Can be set to timed or continuous operating mode • Ergonomic finger switch • Rechargeable using mini-USB adapter • Long focus length to allow for variable handheld application
Light-Curing Systems LOCTITE EQ CL40 (Multiple IDH's)		The LOCTITE CL40 LED Spot-Cure System offers a cost-effective, high-output solution for all your light-curing needs. Its compact size and multi-channel design offer a high level of flexibility for integrating into most manufacturing processes. The system provides all the benefits of LED technology while maintaining one of the highest intensity outputs available. • CL40 LED Spot Quad Controller (IDH 2804936) • CL40 LED Spot Light Source 365 nm (IDH 2804938) • CL40 LED Spot Light Source 405 nm (IDH 2804937)	UVA and UVV curing products	• LED spot-curing system offering long-life, energy-efficient, instant on/off performance. • Operates up to four LED heads. • Compact LED head design. • Intensity adjustment for each channel. • Resistive colour touch screen for ease of operation.

LIGHT CURE SYSTEMS

Product Name	Product Image	Description	Application	Benefits
LED Flood-Curing System LOCTITE EQ CL42 (multiple IDH's)		The LOCTITE CL42 System is a high intensity LED flood system specifically designed to cure LOCTITE light-cure adhesives. The large area flood allows for easy curing of large part assemblies and the LED heads can be stacked side-by-side, further expanding the curing area if needed. The system can be easily integrated into either benchtop or fully-automated processes. • LED Flood Array Light Source, 365 nm (IDH 2804955) • LED Flood Array Light Source, 405 nm (IDH 2804956) • CL42 Dual LED Controller (IDH 2804957) • CL42 LED Flood Chamber (IDH 2804959)	UVA and UVV curing products	• LED flood-curing system offering long-life, energy-efficient, instant on/off performance. • Connect up to two LED flood heads. • Intensity adjustment for each channel. • Large cure area (100 mm x 100 mm). • LED heads side-by-side stackable.
LOCTITE 97055 UVALOC 1000 (IDH 805741)		It is the optimum UV curing chamber that is designed for manual loading and unloading of components to be cured. The emission spectrum of the lamp and radiant power capacity have been designed specifically to meet the requirements of UV curable LOCTITE adhesives.	UVA, UVC and UVV curing products	• Standard unit supplied with a 1,000 W medium pressure mercury arc lamp to provide good tack-free and depth cure • Optional visible light bulb for plastic bonding • Optional iron-doped bulb for maximum depth of cure • Complete shielding of operator from exposure to UV light • High process safety due to the integrated UV monitoring system
LOCTITE EQ PM20 Radiometer UV VIS / UV AB (IDH 2436352 / 2436353)		It is an industry first for measurement of LED light curing devices. The flat response curve makes it uniquely qualified to measure narrow band wavelengths of LED light curing devices. It can also be used with curing chambers, conveyors and flood lamps. This unit combines the all-in-one exposure, intensity measurement and profile memory capability into one device. Comes in UV VIS and UV AB variants.	UV AB / VIS radiometers	• Measuring UVA / UVB and visible light

MANUAL / PNEUMATIC DISPENSERS

Product Name	Product Image	Description	Application	Benefits
300 ml Manual Cartridge Dispenser (IDH 142240)		It is a manually operated dispenser for adhesives and sealants.	Manual dispenser for plastic and aluminium 290 ml, 300 ml and 310 ml cartridges	• Rapid-loading system to make cartridge changes clean and easy • Ergonomically designed • Simple and clean dispensing
LOCTITE 97002 300 ml Pneumatic Cartridge Dispenser (IDH 88632)		It is a manually controlled, pneumatically operated unit. The amount and rate are controlled by the operator.	Pneumatic dispenser for 300 ml / 310 ml plastic and aluminium cartridges and LOCTITE 250 ml tubes	• Accurate flow controlled by integral pressure regulator • Quick exhaust to minimise run-on • Ergonomically designed • Simple and clean dispensing
LOCTITE 96001 50 ml Dual Cartridge Manual Dispenser (IDH 267452)		It is a manually operated dispenser to apply 1:1, 2:1 and 10:1 mix ratio products from 50 ml packs.	2K epoxy, polyurethane and hybrid products in 50 ml cartridges	• Convenient, cost-effective method of application • Good ergonomic features to minimise operator fatigue
LOCTITE 97042 50 ml Dual Cartridge Pneumatic Dispenser (IDH 476898)		It is a pneumatic dispenser to apply 1:1 mix ratio products from 50 ml packs.	2K epoxy, polyurethane and hybrid products in 50 ml dual cartridges	• Lightweight and ergonomic design for easy use • Integrated air pressure regulator • Convenient 8-position thumb wheel pressure adjustment to control the dispense rate
50 ml 10:1 Dual Cartridge Manual Dispenser (IDH 1034026)		It is a manually operated dispenser to apply 10:1 ratio products from S Type 50 ml packs.	2K acrylic products in 10:1 ratio S Type 50 ml packs	• Convenient, cost-effective method of application • Good ergonomic features to minimise operator fatigue
50 ml 10:1 Dual Cartridge Pneumatic Dispenser (IDH 1493310)		It is a pneumatic dispenser to apply 10:1 mix ratio products from 50 ml S Type packs.	2K acrylic products in 10:1 ratio S Type 50 ml packs	• Lightweight and ergonomic design for easy use • Integrated air pressure regulator

MANUAL / PNEUMATIC DISPENSERS

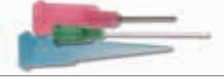
Product Name	Product Image	Description	Application	Benefits
LOCTITE EQ HD14 200 ml Dual Cartridge Manual / Pneumatic Dispenser (IDH 2693822 / 2693824)		They are hand-held, manually operated meter-mix dispensers. These dispensers provide a convenient, cost-effective method to apply product with minimal waste. The dispensers are compatible with 1:1, 2:1, 4:1 and 10:1 mix ratio products and are available in manual or pneumatic versions.	Designed for mixing and applying 2K adhesives of various chemistries in 200 ml cartridges	• Highly precise dosing results thanks to the quick air exhaust • Dispenser immediately achieves its maximum pressure – no power lag • Fatigue free handling thanks to improved tool balance and up to 35 % less weight than comparable dispensers • Ease of operation – new designed trigger and return button are easily accessible with one hand • Conversion kits allow 1:1, 2:1, 4:1 and 10:1 cartridges to be used in the same dispenser
LOCTITE EQ HD14 400 ml Dual Cartridge Manual / Pneumatic Dispenser (IDH 2693823 / 2693825)		They are hand-held, manually operated meter-mix dispensers. These dispensers provide a convenient, cost-effective method to apply product with minimal waste. The dispensers are compatible with 1:1, 2:1, 4:1 and 10:1 mix ratio products and are available in manual or pneumatic versions.	Designed for mixing and applying 2K adhesives of various chemistries in 400 ml cartridges	• Highly precise dosing results thanks to the quick air exhaust • Dispenser immediately achieves its maximum pressure – no power lag • Fatigue free handling thanks to improved tool balance and up to 35 % less weight than comparable dispensers • Ease of operation – new designed trigger and return button are easily accessible with one hand • High specification components used to ensure strength and stiffness, even in the harshest environments • Conversion kits allow 1:1, 2:1, 4:1 and 10:1 cartridges to be used in the same dispenser
LOCTITE EQ HD12 Pneumatic Spray Dispenser (IDH 2251591)		It includes heavy duty dual cartridge handgun 1.125 ml dual cartridge with spray adapter, pressure regulator, gauge, on / off-valve and air hose.	Suitable for spraying LOCTITE 7255 packaged in 900 ml Dual Cartridges. It is designed for 2:1 mix ratio	• Control pressure separately adjustable for advancing cylinder and atomising air • A hand lever valve is provided for turning the atomising air supply to the spray nozzle ON and OFF

Henkel offers suitable stationary accessories (such as nozzles, mixers etc.) for all pieces of equipment. In order to find the optimal nozzle or mixer, please contact your Henkel representative or visit www.equipment.loctite.com

DISPENSING TIPS

Illustration / Example	Item No.	Order No.	Pack Size, pcs	Colour	Gauge	Inner Ø, mm
FLEXIBLE DISPENSING TIPS: DISPENSING NEEDLE, POLYPROPYLENE (PPF), HELICALTHREAD						
	97229	142640	50	Amber	15	1,37
	97230	142641	50	Green	18	0,84
	97231	142642	50	Pink	20	0,61
	97232	142643	50	Red	25	0,25
TAPERED DISPENSING TIPS: DISPENSING NEEDLE, POLYETHYLENE – CONICAL (PPC), LUER-LOCK						
	97221	88660	50	Grey	16	1,19
	97222	88661	50	Green	18	0,84
	97223	88662	50	Pink	20	0,61
	97224	88663	50	Blue	22	0,41
HIGH PRECISION DISPENSING TIPS: DISPENSING NEEDLE, STAINLESS STEEL STANDARD (SSS), LUER-LOCK						
	97225	88664	50	Amber	15	1,37
	97226	88665	50	Green	18	0,84
	97227	88666	50	Pink	20	0,61
	97228	88667	50	Red	25	0,25

ADDITIONAL DISPENSING TIPS AND MIXER NOZZLES

Illustration	Item No.	Order No.	Pack Size, pcs	Description
	98741	1146079	50	Dispensing needle, stainless steel – PTFE-lined (SSTL), 25 gauge
	97262	218288	2 each	Needle selection pack: 2 each of a variety of dispensing needles
	K1003100	88805	50	Formable dispensing tip, 21 gauge / 0,5 mm
	97248	218275	50	Luer-Lock® tip caps
	97233	88672	20 + 5	Luer-Lock® adapter kit: 20 Luer-Locks® and 5 adapters
	97207	88656	40	10 ml clear syringe barrel kit

ADDITIONAL DISPENSING TIPS AND MIXER NOZZLES

Illustration	Item No.	Order No.	Pack Size, pcs	Description
	97283	529462	40	10 ml amber syringe barrel kit, for UV products
	97263	218287	40	10 ml black syringe barrel kit, for UV and light cure adhesives
	97208	88657	2	10 ml syringe airline adapter
	97244	88677	20	30 ml clear syringe barrel kit
	97264	218286	20	30 ml black syringe barrel kit, for UV and light cure adhesives
	97245	88678	2	30 ml syringe airline adapter
	97290	397462	50	All plastic precision dispensing tip, 20 gauge
	984569	2900614	10	Static mixer for epoxy and PU in 50 ml, SQ 5.3-24
	984570	1487439	10	Static mixer for epoxy in 200 / 400 ml, SQ 7.5-24
	1034575	1034575	10	Static mixer MBX 6.5-20-S 10:1 for LOCTITE AA 3038
	8953593	1248606	10	Spray mix nozzle for LOCTITE PC 7255
	8953186	1104046	10	Static mixer 4:1 / 10:1 for 400 / 490 ml, MCX 08-18
	5289010	545996	10	Static mixer 1:1 for acrylics in 50 ml, MA 6.3-7
	98457	720174	10	Static mixer 1:1 / 2:1 in 200 / 400 ml, MC 8-24
	863585	367545	10	Static mixer 1:1 for MS polymers in 410 ml, MC 13-18
	8953187	1104047	10	Static mixer 4:1 / 10:1 in 400 / 490 ml, MCX 08-24
	8955989	1453183	10	Static mixer for LOCTITE 3090 and LOCTITE 4070, MLX 2.5-16-5
	N/A	1826921	10	Static mixer 1:1 / 2:1 in 50 ml, MBH 3.2-16 S
	N/A	1573153	10	Static mixer 1:1 / 2:1 in 50 ml, MBQ 5.0-24 L
	N/A	1573135	10	Static mixer 1:1 / 2:1 in 400 ml, MFH 6.0-34 T

Product name	Pack sizes	Page
LOCTITE 222	10 ml, 50 ml, 250 ml	10, 13
LOCTITE 2400	50 ml, 250 ml	10, 13
LOCTITE 243	5 ml, 10 ml, 24 ml, 50 ml, 250 ml	9, 10, 13
LOCTITE 248	9 g, 19 g	10, 13
LOCTITE 270	10 ml, 50 ml, 250 ml	9, 11, 13
LOCTITE 2700	50 ml, 250 ml	11, 13
LOCTITE 2701	5 ml, 250 ml	11,13
LOCTITE 277	50 ml, 250 ml	11, 13
LOCTITE 290	50 ml, 250 ml	10, 13
LOCTITE 3090	11 g	49, 51
LOCTITE 401	20 g, 500 g	47, 48, 51
LOCTITE 402	20 g, 500 g	48, 51
LOCTITE 406	20 g, 500 g	48, 51
LOCTITE 435	20 g, 500 g	48, 51
LOCTITE 454	20 g	47, 49, 51
LOCTITE 460	20 g, 500 g	49, 51
LOCTITE 480	20 g, 500 g	48, 51
LOCTITE 495	20 g, 500 g	49, 51
LOCTITE 510	50 ml, 160 ml, 250 ml, 300 ml	28, 31
LOCTITE 518	25 ml, 50 ml, 300 ml	28, 31
LOCTITE 5188	50 ml, 300 ml	28, 31
LOCTITE 5400	50 ml, 250 ml	20, 21
LOCTITE 542	10 ml, 50 ml, 250 ml	19, 20, 21
LOCTITE 55	24 x 160 m, 48 x 160 m	20, 21
LOCTITE 574	50 ml, 250 ml	28, 31
LOCTITE 577	50 ml, 250 ml	19, 20, 21
LOCTITE 5800	50 ml, 300 ml	28, 31
LOCTITE 603	50 ml, 250 ml	38, 41
LOCTITE 620	10 ml, 50 ml, 250 ml	39, 41
LOCTITE 6300	50 ml, 250 ml	39, 41

Product name	Pack sizes	Page
LOCTITE 638	50 ml, 250 ml	37, 39, 41
LOCTITE 641	50 ml, 250 ml	38, 41
LOCTITE 648	50 ml, 250 ml	38, 41
LOCTITE 660	50 ml	37, 39, 41
LOCTITE AA 326	50 ml	65, 66, 70
LOCTITE AA 330	50 ml kit	66, 70
LOCTITE AA 3504	250 ml	86, 89
LOCTITE AA 352	250 ml, 1 l	86, 89
LOCTITE AA 3922	25 ml, 1 l	87, 89
LOCTITE AA 3951	25 ml, 1 l	86, 89
LOCTITE AA 3953	25 ml, 1 l	86, 89
LOCTITE EA 3421	50 ml	66, 70
LOCTITE EA 3423	50 ml, 200 ml	66, 70
LOCTITE EA 3430	24 ml, 50 ml	65, 67, 70
LOCTITE EA 3450	25 ml	67, 70
LOCTITE EA 3463	114 g	108, 109
LOCTITE EA 3471	500 g	108, 109
LOCTITE EA 3475	500 g	108, 109
LOCTITE EA 3478	453 g	107, 108, 109
LOCTITE EA 9450	50 ml	67, 70
LOCTITE EA 9461	50 ml	67, 70
LOCTITE EA 9466	50 ml, 400 ml	68, 70
LOCTITE EA 9483	50 ml, 400 ml	67, 70
LOCTITE EA 9492	50 ml, 400 ml	68, 70
LOCTITE EA 9497	50 ml	67, 70
LOCTITE EA 9514	300 ml	67, 70
LOCTITE HY 4070	11 g, 45 g	56, 57
LOCTITE HY 4080	50 g	58, 59
LOCTITE HY 4090 / HY 4090 GY	50 ml, 400 ml	58, 59
LOCTITE LB 8008	453 g	119, 120, 121

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LOCTITE LB 8023	453 g	119, 120, 121
LOCTITE LB 8040	400 ml	115
LOCTITE LB 8150	500 g	120, 121
LOCTITE LB 8201	400 ml	115
LOCTITE O-Ring Kit	N/A	127
LOCTITE PC 5070	1,8 m	126
LOCTITE PC 6261	3,634 l	127
LOCTITE PC 6315	2,676 l	127
LOCTITE PC 7218	1 kg, 10 kg	99, 100, 101
LOCTITE PC 7222	1,36 kg	100, 101
LOCTITE PC 7226	1 kg	99, 100, 101
LOCTITE PC 7227	1 kg	100, 101
LOCTITE PC 7234	1 kg	100, 101
LOCTITE PC 7255	1,125 l	100, 101
LOCTITE PC 7352	400 ml	107, 108, 109
LOCTITE PC 9410	25,7 kg	127
LOCTITE SF 7063	400 ml, 10 l, 200 l	12, 21, 30, 40, 50, 93, 94, 95
LOCTITE SF 7100	400 ml	127
LOCTITE SF 7200	400 ml	30, 93, 94, 95
LOCTITE SF 7455	18 ml, 150 ml, 500 ml, 20 l	50
LOCTITE SF 7505	90 ml, 250 ml, 1 l	127
LOCTITE SF 7515	5 l, 20 l	127
LOCTITE SF 7649	150 ml, 500 ml	12, 21, 30, 40
LOCTITE SF 770	10 g, 300 g	50
LOCTITE SF 7840	750 ml, 5 l, 20 l, 200 l	94, 95
LOCTITE SF 7850	400 ml, 3 l, 10 l	94, 95
LOCTITE SF 7900	400 ml	125, 126
LOCTITE SI 5075	4,27 m	127
LOCTITE SI 5300	310 ml	29, 31

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LOCTITE SI 5367	310 ml	29, 31
LOCTITE SI 5368	310 ml	79
LOCTITE SI 5699	80 ml, 300 ml	29, 31
LOCTITE SI 5900	300 ml	29, 31
LOCTITE SI 5910	300 ml	27, 29, 31
LOCTITE SI 596	80 ml, 310 ml	29, 31
LOCTITE SI 5970	300 ml	29, 31
LOCTITE SI 5980	100 ml	29, 31
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TEROSON MS 930	310 ml	77, 79
TEROSON MS 9360	310 ml, 570 ml	79
TEROSON MS 939	290 ml	77, 78, 79
TEROSON MS 9399	400 ml	78, 79
TEROSON PU 6700	50 ml, 310 ml, 400 ml	68, 71
TEROSON PU 6700 ME	50 ml, 400 ml	68, 71
TEROSON PU 9225 SF	50 ml	68, 71
TEROSON PU 9225 SF ME	50 ml	68, 71
TEROSON VR 5080	25,5 m	127
TEROSON VR 625	400 ml	127

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LOCTITE 97135 / 97136 Diaphragm Dispense Valve	215846 / 215848	130
LOCTITE 98013 CA Diaphragm Dispense Valve	318654	130
LOCTITE 98009 Light Cure Diaphragm Dispense Valve	218280	130
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