



Threadlocking

Locking of Threaded Fasteners

- Prevents loosening from shock and vibration
- Single component – clean and easy to apply
- Can be used on various sizes of fasteners – reduces inventory costs
- Seals threads
- Stops rust and corrosion



ARE THE PARTS ALREADY ASSEMBLED?

Helpful Hints:

- Clean parts with Loctite® ODC-Free Cleaner & Degreaser before applying the adhesive
- If the threadlocker will be applied below 40°F, pre-treat with Loctite® 7649™ Primer N™ or Loctite® QuickStix™ 7088™ Primer
- If the parts were in contact with aqueous washing solutions or cutting fluids which leave a protective layer on the surface, wash with hot water before use

Solution

Yes		No						
Wicking Grade		What strength do you require?						
What strength do you require?		Low – Purple	Medium – Blue			High – Red		
		Liquid Product	Liquid Product	Semi-Solid Product	Gel Product	Liquid Product	Semi-Solid Product	
Loctite® 220™ Threadlocker	Loctite® 290™ Threadlocker	Loctite® 222MS™ Threadlocker	Loctite® 2440™ Threadlocker	Loctite® QuickStix™ 248™ Threadlocker	Loctite® 2033™ Gel Threadlocker	Loctite® 2760™ Threadlocker	Loctite® QuickStix™ 268™ Threadlocker High Strength	
Fastener Size	#2 to 1/2"	Up to 1/4"	1/4" to 3/4"	1/4" to 3/4"	1/4" to 1"	Up to 1"	Up to 1"	
Strength	Medium	Low	Medium	Medium	Medium	High	High	
Cure Time (Fixture/Full Strength)*	6 min./24 hr.	10 min./24 hr.	3 min./24 hr.	10 min./24 hr.	20 min./24 hr.	4 min./24 hr.	20 min./24 hr.	
Breakaway/Prevail Torque (lb./in.)	20/250	53/30	215/53	110/43	204/133	325/320	220/4	
Temperature Resistance for Continuous Service	300°F (150°C)	300°F (150°C)	300°F (150°C)	300°F (150°C)	298°F (148°C)	300°F (150°C)	300°F (150°C)	
Common Sizes / Part Number	10 ml bottle – 37388 50 ml bottle – 39186 250 ml bottle – 22041	10 ml bottle – 29021 50 ml bottle – 29031 250 ml bottle – 29041	10 ml bottle – 22221 50 ml bottle – 22231 250 ml bottle – 22241	10 ml bottle – 33946 50 ml bottle – 33947 250 ml bottle – 33948	9 g stick – 37684 19 g stick – 37087	1.18 fl. oz. (35 ml) bottle – 1029050	10 ml bottle – 32526 50 ml bottle – 32525 250 ml bottle – 32527	9 g stick – 37685 19 g stick – 37686

* Typical value @ 70°F (22°C)

Additional Loctite® brand Threadlockers

Name	Strength	Breakaway/Prevail Torque (lb./in.)	Features	Part #	Package Size
242®	Medium	110/43	Fasteners 1/4" to 1/2"	24231	50 ml bottle
243™	Medium	180/62	Oil Tolerance	24078	50 ml bottle
262™	High	189/275	Fasteners up to 3/4"	26231	50 ml bottle
272™	High	200/220	High Temp up to 1 1/2"	27240	50 ml bottle
277™	High	275/275	Fasteners up to 1 1/2"	27731	50 ml bottle
425™ Assure™	Low	4/2	Plastic Fasteners	42540	20 g bottle
Loctite® Bottle Hand Pump – Fits Loctite® 50 or 250 ml bottles				97001 98414	250 ml bottle 50 ml bottle

Use Loctite® 7649™ Primer N™ or Loctite® QuickStix™ 7088™ Primer:

1. Activate inactive surfaces.
2. Speed cure times for faster return to service.
3. Speed curing through larger gaps and deep threads.
4. Substantially speed cure times on cold parts.

Primer is optional with: Active surfaces: Brass, copper, bronze, iron, soft steel, nickel.

Primer is required with: Inactive surfaces: Aluminum, stainless steel, magnesium, zinc, black oxide, cadmium, titanium, others.



Loctite® 220™ Threadlocker – Medium Strength/Wicking/Blue

A low viscosity threadlocking adhesive that allows the product to wick along the threads of preassembled fasteners. Perfect for fasteners up to 1/4" diameter (6 mm).



Loctite® 290™ Threadlocker – High Strength/Wicking/Green

Recommended for locking pre-assembled fasteners, i.e. instrumentation screws, electrical connectors, and set screws. Also seals porosities in welds and metal parts. Mil Spec (S-46163A) Type III, Grade R. NSF/ANSI 61.



Loctite® 222MS™ Threadlocker – Low Strength

Recommended for low-strength threadlocking of adjustment screws, countersunk head screws, and set screws; on collars, pulleys, tool holders, and controllers. Also for low strength metals such as aluminum or brass. Mil-Spec (S-46163A) Type II, Grade M.



Loctite® 2440™ Threadlocker – Primerless/Medium Strength

Particularly fast curing, reducing or eliminating the need for primers. Effective on all types of metal threaded fasteners. Prevents loosening on vibrating parts such as pumps, motor mounting bolts, gear boxes, or presses. Removable with hand tools.



Loctite® QuickStix™ 248™ Threadlocker – Medium Strength

Semi-solid stick form is convenient, portable, and great for hard-to-reach applications. Loctite® QuickStix™ 248™ Threadlocker is the ideal general-purpose threadlocker for all nut and bolt applications, especially fasteners between 1/4" and 3/4". Removable.



Loctite® 2033™ Gel Threadlocker – Medium Strength

New package allows gel threadlocker to be dispensed with pinpoint accuracy, or in a wide band. Gel consistency is ideal for overhead or pre-applied applications. For standard or large thread applications.



Loctite® 2760™ Threadlocker – Primerless/High Strength

Particularly fast curing, reducing or eliminating the need for primers. Recommended for permanently locking studs on engine blocks and pump housings. CFIA Approved.



Loctite® QuickStix™ 268™ Threadlocker – High Strength

This convenient semi-solid stick form is portable and less messy. Its high strength prevents loosening of threaded fasteners. Well suited for heavy-duty applications.