



# LOCTITE®
























## Maintenance Solutions





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# 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			
Medium – Blue	Medium/High – Green		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	
<b>Fastener Size</b>	#2 to 1/2"	#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"	
<b>Strength</b>	Medium	High	Low	Medium	Medium	Medium	High	High	
<b>Cure Time (Fixture/Full Strength)*</b>	6 min./24 hr.	20 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.	
<b>Breakaway/Prevail Torque (lb./in.)</b>	20/250	90/260	53/30	215/53	110/43	204/133	325/320	220/4	
<b>Temperature Resistance for Continuous Service</b>	300°F (150°C)	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)	
<b>Common Sizes / Part Number</b>	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 3/4"	24231	50 ml bottle
243™	Medium	180/62	Oil Tolerance	24078	50 ml bottle
262™	High	189/275	Fasteners up to 3/2"	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 1/4"	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.

**Package Size:** 7649™ Primer N™ – 1.75 fl. oz. bottle – 38402

**Part Number:** 7649™ Primer N™ – 4.5 oz. aerosol – 21348

QuickStix™ 7088™ – 17 g solventless semi-solid stick – 1069256



#### 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.



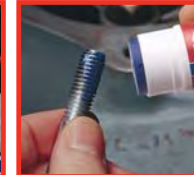
#### Loctite® 222MS™ Threadlocker – Low Strength

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. NSF P1.



#### 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 with hand tools. NSF/ANSI 61.



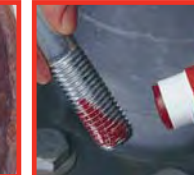
#### Loctite® 2033™ Gel Threadlocker – Medium Strength

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. For use on all metal fasteners where regular removal for maintenance is not required. 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.



# Thread Sealing

- Replaces tapes and pastes
- Liquids ensure complete contact between threads for a 100% seal
- Liquids will not creep, shrink, shred, or block systems (including filters)
- Disassembly can be achieved easily with basic hand tools



## ARE THE PARTS METAL OR PLASTIC?

### Helpful Hints:

- If the sealant (Loctite® 545™ Thread Sealant, Loctite® 565™ PST® Thread Sealant, Loctite® 567™ PST® Thread Sealant, or Loctite® QuickStix™ 561™ PST® Pipe Sealant) will be applied below 40°F, pre-treat with Loctite® 7649™ Primer N™ or Loctite® QuickStix™ 7088™ Primer
- All parts must be clean and dry before sealing – use Loctite® ODC-Free Cleaner & Degreaser

### Solution



Description	Cord	White Paste	Purple Liquid	White Paste	White Paste	White Stick
Maximum Thread Size	4"	3"	Up to 2"	Up to 2"	3"	3"
Temperature Resistance	300°F (150°C)	400°F (204°C)	300°F (150°C)	300°F (150°C)	400°F (204°C)	300°F (150°C)
Maximum Pressure Resistance (psi)/Cure Time	10,000 psi/Instant	5,000 psi/N.A.	10,000 psi/24 hr.	10,000 psi/72 hr.	10,000 psi/72 hr.	10,000 psi/72 hr.
Substrate to be Sealed	Metal, Plastic or Both	Plastic	Metal	Metal	Stainless Steel*, Aluminum	Metal
Instant Low Pressure Seal	Yes	Yes	No	Yes	Yes	Yes
Common Sizes / Part Number	1,968 inches – 39036 5,700 inches – 35082	2 fl. oz. tube – 80725 7 fl. oz. tube – 80724 1 pint brush can – 80726	10 ml bottle – 32429 50 ml bottle – 54531 250 ml bottle – 54541	6 ml tube – 56507 50 ml tube – 56531 250 ml tube – 56541 300 ml cartridge – 56571	6 ml tube – 56707 50 ml tube – 56747 250 ml tube – 56765 350 ml brush can – 33241	19 g stick – 37127

Additional Loctite® brand Thread Sealants			
Name	Type	Part #	Pkg. Size
Loctite® 564™ Thread Sealant	Instant seal, low strength	28754	50 ml tube
Loctite® 554™ Thread Sealant	Refrigerant sealant	25882	10 ml bottle
Loctite® H.V.A.C. Blue Pipe Joint Compound	Seals oil, refrigerants, butane, propane, and more	82481	1 pt. can
Loctite® Pipe Joint Compound	High temperature, non-hardening	30557	1 pt. can
Loctite® Thread Sealant with PTFE	Non-hardening	30561	1 pt. can



### 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.

**Package Size/** 7649™ Primer N™ – 1.75 fl. oz. bottle – **38402**

**Part Number:** 7649™ Primer N™ – 4.5 oz. aerosol – **21348**

QuickStix™ 7088™ – 17 g solventless semi-solid stick – **1069258**



### Loctite® 55™ Pipe Sealing Cord

Can be safely applied on metal and plastic threaded fittings. Potable water: NSF/ANSI Standard 61. UL Listed and Certified to CSA® International.

### Loctite® No More Leaks™

Recommended for use on threaded plastic fittings carrying hot or cold water, i.e. industrial and agricultural plastic water pipe systems, or drainage systems. NSF/ANSI Std. 61.

### Loctite® 545™ Thread Sealant

Recommended for fine threaded fittings as used in hydraulic and pneumatic installations and small fittings in general. ABS Approved. CFIA Approved.

### Loctite® 565™ PST® Thread Sealant

A general-purpose instant sealer for tapered and straight/tapered fittings. Controlled strength for ease of disassembly. CSA® 3319-81 and 3319-01. UL MH007(N). NSF/ANSI 61. ULC-Canada Approved. CFIA Approved.

### Loctite® 567™ PST® Thread Sealant with PTFE

Withstands temperatures to 400°F with excellent solvent resistance. Locks and seals tapered pipe threads and fittings, including high pressure applications. Disassembles with hand tools. \*Use Loctite® 7649™ Primer N™ with stainless steel. ABS Approved.

### Loctite® QuickStix™ 561™ PST® Pipe Sealant with PTFE

Semi-solid stick form is convenient, portable, and less messy. Formulated for fast, reliable curing on metal, tapered pipe threads and fittings. Provides high pressure sealing and withstands continuous operating temperatures of -65°F to 300°F (-54°C to 150°C). NSF/ANSI 61.



# Gasketing

## Sealing and Flanges

- No shimming effect – controlled tolerances, no need for re-torquing
- Fill all voids – reduce the need for a fine surface finish of flanges
- Parts can be disassembled easily even after extended service
- Resists high pressure when fully cured

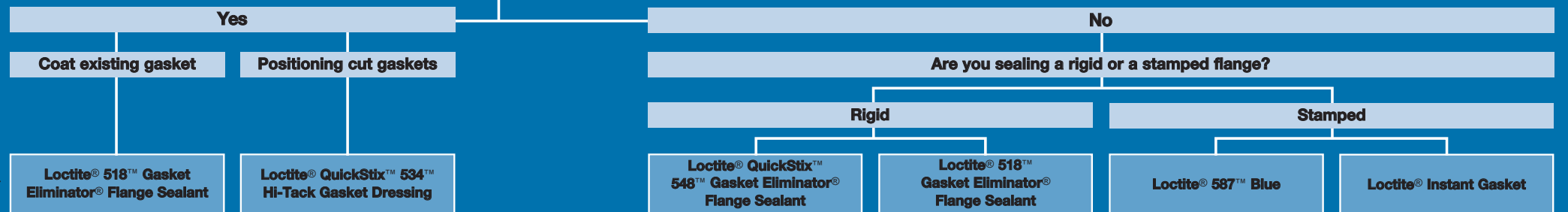


### DOES THE EXISTING GASKET NEED TO BE USED AS A SHIM?

#### Helpful Hints:

- If there are traces of old gasket left on the parts to be sealed, clean with Loctite® Chisel® Gasket Remover
- All parts must be clean and dry before sealing – use Loctite® ODC-Free Cleaner & Degreaser
- Anaerobic products cure between metal surfaces with the absence of air

#### Solution



	Yes		No			
	Coat existing gasket	Positioning cut gaskets	Are you sealing a rigid or a stamped flange?			
			Rigid		Stamped	
	Loctite® 518™ Gasket Eliminator® Flange Sealant	Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant	Loctite® 518™ Gasket Eliminator® Flange Sealant	Loctite® 587™ Blue	Loctite® Instant Gasket
<b>Gasket Type</b>	Formed-in-place	Use with cut gasket	Formed-in-place	Formed-in-place	Formed-in-place	Formed-in-place
<b>Gap Fill</b>	0.010" (0.25 mm)	N.A.	0.010" (0.25 mm)	0.010" (0.25 mm)	0.250" (6.35 mm)	0.250" (6.35 mm)
<b>Gap Fill with Primer</b>	0.050" (1.27 mm)	N.A.	0.020" (0.508 mm)	0.050" (1.27 mm)	N.A.	N.A.
<b>Cure Method</b>	Anaerobic	Anaerobic	Anaerobic	Anaerobic	Moisture (RTV)	Moisture (RTV)
<b>Cure Time</b>	N.A.	N.A.	24 hrs.	24 hrs.	50 min.	5 min.
<b>Temperature Resistance (Continuous / Intermittent)</b>	300°F (150°C)/N.A.	300°F (150°C)/N.A.	300°F (150°C)/N.A.	300°F (150°C)/N.A.	400°F (204°C) 500°F (260°C)	450°F (232°C) 540°F (282°C)
<b>Instant Seal</b>	Excellent	Excellent	Yes	Excellent	Excellent	Excellent
<b>Oil Resistance</b>	Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
<b>Water / Glycol Resistance</b>	Excellent	N.A.	Good	Excellent	Excellent	Excellent
<b>Common Sizes / Part Number</b>	6 ml tube – 51817 50 ml tube – 51831	9 g stick – 39155 19 g stick – 39156 38 g stick – 39157	9 g stick – 39151 18 g stick – 39152 37 g stick – 39153	6 ml tube – 51817 50 ml tube – 51831	70 ml tube – 58730 300 ml cartridge – 58775 190 ml can – 40462	90 ml can – 40478 190 ml can – 40479

Additional Loctite® brand Gasketing Products			
Name	Color	Part #	Pkg. Size
Loctite® Gasket Sealant 1	Brown	30511	3 oz. tube
Loctite® Gasket Sealant 2	Black	30514	3 oz. tube
Loctite® Aviation Gasket Sealant	Brown	30516	1 pt. can
Loctite® High Performance Silicones (Loctite® 598™ Black, 5920™ Copper, and 5699™ Grey)	Black Copper Grey	59875 82046 18581	300 ml cartridge
Loctite® Superflex® RTV, Silicone Adhesive Sealants (Black, Clear, White, Blue, Red Hi-Temp)	Black Clear White Blue Red	59375 59575 59475 30533 59675	300 ml cartridge
Loctite® Copper Gasket Adhesive	Copper	30535	9 oz. aerosol
Loctite® 574™ Flange Sealant – Fast Cure	Orange	24018	50 ml tube
Loctite® 515™ Gasket Eliminator® Flange Sealant	Purple	51531	50 ml tube
Loctite® Hi-Tack Gasket Sealant	Red	30525	1 pt. can
Loctite® 510™ Gasket Eliminator® Flange Sealant	Pink	51031	50 ml tube



**Loctite® 518™ Gasket Eliminator® Flange Sealant**  
Recommended for coating and re-using gaskets to improve sealing. Spray Loctite® 7649™ Primer N™ on both flange surfaces and both sides of the gasket. NSF/ANSI 61 Certified. CFIA Approved.



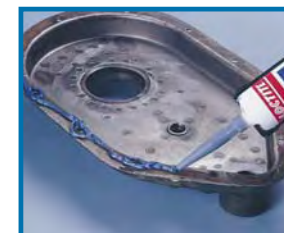
**Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing**  
No mess, semi-solid formula offers added control and ease of use. Patented package is portable and won't leak or spill. Seals and holds the heaviest gaskets in place during assembly. Solvent-free and low odor. Suitable to 300°F (149°C).



**Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant**  
Patented, semi-solid formula is ideal for on-the-spot repairs, or when a conventional gasket is out of stock. Can be applied quickly and neatly on a variety of metal surfaces, including aluminum, to form a flexible, solvent resistant seal. Seals to 300°F (149°C) and fills gaps to 0.010".



**Loctite® 518™ Gasket Eliminator® Flange Sealant**  
Recommended for use on rigid iron, steel, and aluminum flanges. Spray Loctite® 7649™ Primer N™ on only one surface. NSF/ANSI 61 Certified. CFIA Approved.



**Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker**  
Recommended for sealing all types of flanges including stamped sheet metal. Designed for superior bonding properties to oil contaminated metals. ABS Approved. NSF/ANSI P1.



**Loctite® Instant Gasket**  
Makes high-performance, leakproof gaskets in one minute. Equipment can be returned to service immediately. Blowout resistant. Outperforms pre-cut gaskets.



# Retaining

## Securing Cylindrical Assemblies

- Bond non-threaded cylindrical metal assemblies
- High and moderate strength products – can carry high loads and eliminate fretting
- Fill all voids – prevent corrosion
- Reduce the need for close tolerances
- 100% contact – load and stress are distributed evenly over the joint

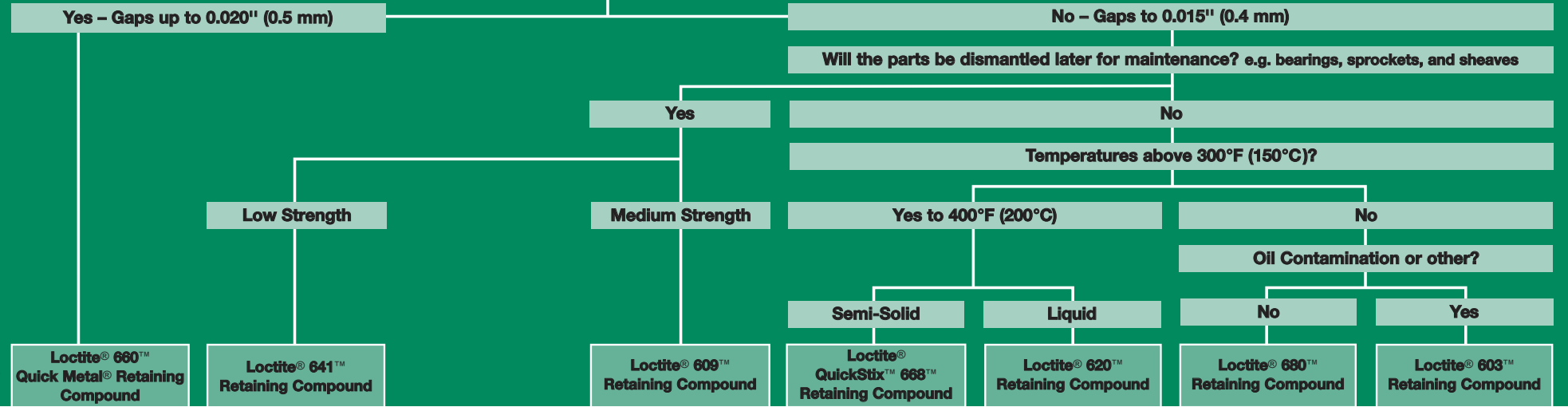


### IS THE ASSEMBLY BADLY WORN?

#### Helpful Hints:

- If the retaining compound will be applied below 40°F (5°C), pre-treat with Loctite® 7649™ Primer N™ or Loctite® QuickStix™ 7088™ Primer
- All parts must be clean and dry before sealing – use Loctite® ODC-Free Cleaner & Degreaser
- If the parts have been in contact with washing or cutting fluids containing nitrates, wash with hot water

#### Solution



Strength Required	High	Low	Medium	Medium	High	High	High
Shear Strength	3,335 psi	1,700 psi	2,300 psi	1,870 psi	3,800 psi	2,800 psi minimum	3,770 psi
Diametrical Clearance	Up to 0.020" (0.5 mm)	Up to 0.006" (0.15 mm)	Up to 0.005" (0.1 mm)	Up to 0.005" (0.1 mm)	Up to 0.015" (0.4 mm)	Up to 0.015" (0.4 mm)	Up to 0.005" (0.1 mm)
Temperature Resistance	300°F (150°C)	300°F (150°C)	300°F (150°C)	400°F (204°C)	450°F (232°C)*	300°F (150°C)	300°F (150°C)
Cure Time (Setup / Full Strength)	20 min./24 hr.	20 min./24 hr.	10 min./24 hr.	30 min./24 hr.	30 min./24 hr.	10 min./24 hr.	10 min./24 hr.
Common Sizes / Part Number	6 ml tube – 66010 50 ml tube – 66040	10 ml bottle – 28802 50 ml bottle – 21458	10 ml bottle – 60921 50 ml bottle – 60931 250 ml bottle – 60941	9 g stick – 39147 19 g stick – 39148 38 g stick – 39149	10 ml bottle – 62015 50 ml bottle – 62040 250 ml bottle – 62070	10 ml bottle – 68015 50 ml bottle – 68035 250 ml bottle – 68060	10 ml bottle – 21440 50 ml bottle – 21441 250 ml bottle – 21442

\* Requires heat cure to achieve temperature resistance

#### 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.

**Package Size/ Part Number:** 7649™ Primer N™ – 1.75 fl. oz. bottle – **38402**  
7649™ Primer N™ – 4.5 oz. aerosol – **21348**

QuickStix™ 7088™ – 17 g solventless semi-solid stick – **1069258**



#### Loctite® 660™ Quick Metal® Retaining Compound

Used for repairing worn coaxial parts without remachining; enables re-use of worn bearing seats, keys, splines, tapers, or for retaining shims. CFIA Approved.



#### Loctite® 641™ Retaining Compound

A controlled strength retaining compound that is ideal for cylindrical parts that require disassembly. CFIA Approved.



#### Loctite® 609™ Retaining Compound – Press Fit/ General Purpose

Recommended for parts that will need subsequent dismantling, i.e. retention of bearings onto shafts and into housings. Mil-Spec (R-46082B) Type I.



#### Loctite® QuickStix™ 668™ Retaining Compound

A high temperature retaining compound in a revolutionary semi-solid formula. Patented, no-mess package offers added convenience and portability. Ideal for gaps up to 0.005" on the diameter. Withstands temperatures to 400°F (204°C).



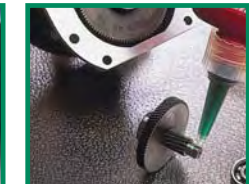
#### Loctite® 620™ Retaining Compound – Slip Fit/High Temperature

Recommended for high temperature retaining of parts with a clearance or interference fit, i.e. retaining bushes, bearings, seals, fans, and liners. Requires heat cure to achieve temperature resistance. ABS Approved.



#### Loctite® 680™ Retaining Compound – Slip Fit/High Strength

Gives best resistance to dynamic, axial and radial loads. Recommended for retaining shafts, gears, pulleys, and similar cylindrical parts. NSF/ANSI 61 Approved. ABS Approved.



#### Loctite® 603™ Retaining Compound – Press Fit/Oil Tolerant

For retaining close-fitting cylindrical parts, up to 0.005" (0.1 mm) gap, and for use on cylindrical fitting parts where thorough degreasing is not possible. Applications include retaining roller bearings or oil impregnated bushings into housings.

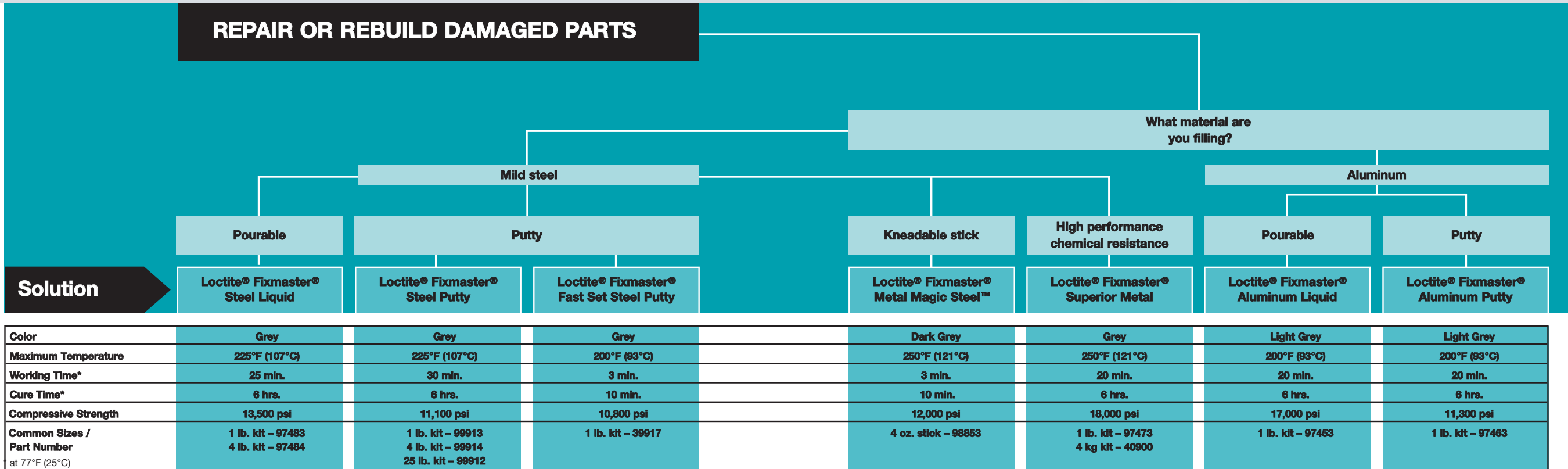


# Metal Rebuilding and Shaft Repair

- High compressive strength
- Choice of mild steel aluminum or non-metallic fillers
- Can be machined, drilled, or tapped after cure
- Excellent resistance to aggressive chemicals



## REPAIR OR REBUILD DAMAGED PARTS



Additional Products		
Name	Part #	Pkg. Size
Loctite® Fixmaster® Stainless Steel Putty	97443	1 lb. kit
Loctite® Fixmaster® Fast Set Steel Epoxy	96604	50 ml cart.
Loctite® Fixmaster® Wet Surface Repair Putty	96583	1 lb. kit
Loctite® Fixmaster® Underwater Repair Epoxy	82093	4 oz. stick



**Loctite® Fixmaster® Steel Liquid**  
High steel content. Pourable liquid filler used for making fixtures and molding. ABS Approved.



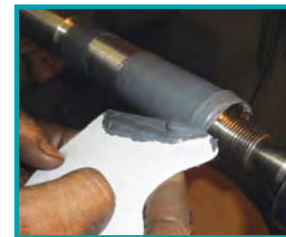
**Loctite® Fixmaster® Steel Putty**  
High steel content putty. Recommended for repairing and rebuilding worn steel components, such as bearing and fan housings. ABS Approved.



**Loctite® Fixmaster® Fast Set Steel Putty**  
A fast curing version of steel putty. Recommended for repairing pipes and other emergency repairs. ABS Approved.



**Loctite® Fixmaster® Metal Magic Steel™**  
Kneadable, two-part paste. Working time is 3 minutes – sets in 10 minutes. Adheres to damp surfaces. Can be drilled, filed, and painted. Ideal for emergency sealing of leaking tanks and pipes. Smooths welds, repairs small cracks in castings, and fills oversized bolt holes.



**Loctite® Fixmaster® Superior Metal**  
Formulated with fine alloy particles for high compressive strength and chemical resistance. Recommended for use on all metals. Outstanding compressive strength, chemical resistance, non-rusting.



**Loctite® Fixmaster® Aluminum Liquid**  
Fluid, self-leveling aluminum liquid. Can be poured into molds and cavities. Recommended for casting aluminum replacement parts and for making molds. ABS Approved.



**Loctite® Fixmaster® Aluminum Putty**  
General purpose, aluminum putty for repair of all aluminum alloy components. ABS Approved.





# Wear Prevention and Rebuilding

- Restores worn surfaces
- Provides wear and impact resistant coatings
- Use on new parts to extend life
- Available in both trowelable and brushable forms



## ARE YOU EXPERIENCING CORROSION OR WEAR?

### Helpful Hints:

- Clean surfaces with Loctite® ODC-Free Cleaner & Degreaser
- Use expanded metal to fill large voids
- Roughen surfaces to ensure adhesion

**Corrosion**  
(e.g. chemical, rust, etc.)

**Wear**

**Impact or sliding abrasion resistance?**

**Sliding**

**Impact**

**Are you filling deep or shallow wear?**

**Deep**

**Shallow**

### Solution

**Loctite® Nordbak®  
Chemical Resistant  
Coating**

**Loctite® Nordbak®  
Wearing Compound**

**Loctite® Nordbak®  
High Impact  
Wearing Compound**

**Loctite® Nordbak®  
Pneu-Wear**

**Loctite® Nordbak®  
Brushable Ceramic**

**Loctite® Nordbak®  
Wear Resistant Putty**

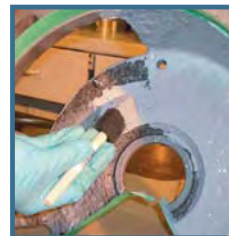
**Loctite® Fixmaster®  
Flex 80™ Putty**

<b>Color</b>	Grey	Grey	Grey	Grey	Grey or White	Grey	Black
<b>Maximum Temperature</b>	150°F (66°C)	250°F (121°C)	250°F (121°C)	250°F (121°C)	200°F (93°C)	225°F (107°C)	180°F (82°C)
<b>Working Time*</b>	20 min.	30 min.	30 min.	30 min.	Grey 30 min. White 15 min.	30 min.	10 min.
<b>Cure Time*</b>	16 hr.	7 hr.	6 hr.	6 hr.	Grey 6 hr. White 5 hr.	6 hr.	8 hr.
<b>Common Sizes / Part Number</b>	12 lb. kit – 96092	5 lb. kit – 99813 25 lb. kit – 99812	25 lb. kit – 39918	3 lb. kit – 98383 25 lb. kit – 98382	2 lb. kit grey – 98733 6 lb. kit grey – 98732 2 lb. kit white – 96443	1 lb. kit – 98742 3 lb. kit – 98743	1 lb. kit – 97423 6 lb. kit – 97422

\* At 77°F (25°C)

### Additional Products

Name	Type	Part #	Pkg. Size
Loctite® Nordbak® High Temp. Wearing Compound	450°F (232°C)	99112	25 lb. kit
Loctite® Nordbak® High Temperature Pneu-Wear	450°F (232°C)	98372	25 lb. kit
Loctite® Nordbak® Ultra High Temp. Wearing Compound	550°F (288°C)	96392	25 lb. kit
Loctite® Nordbak® Ultra High Temperature Pneu-Wear	550°F (288°C)	96332	25 lb. kit
Loctite® Nordbak® Fast Cure Wearing Compound	3 hr. cure	96373	6 lb. kit
Loctite® Nordbak® Fast Cure Pneu-Wear	3 hr. cure	96363	6 lb. kit
Loctite® Nordbak® High Temperature Brushable Ceramic	550°F (288°C)	96433	2 lb. kit
Loctite® Nordbak® Castable Wearing Compound	Mold wear resistant parts	98992	25 lb. kit
Loctite® Nordbak® Ceramic Tile Adhesive	200°F (93°C)	97762	20 lb. kit
Loctite® Fixmaster® Flex™ Metal Primer	Promotes the adhesion of Loctite® Flex™ Urethanes to metal	98471	3.3 fl. oz.
Loctite® Nordbak® Combo Bead Wearing Compound	250°F (121°C)	96303	6 lb. kit
Loctite® Nordbak® Brushable Ceramic – Thin Mil	Grey Blue Black	40592 40591 40590	2 lb. kit 2 lb. kit 2 lb. kit
Loctite® Nordbak® Low Odor Wearing Compound	Grey	41343	25 lb. kit



#### Loctite® Nordbak® Chemical Resistant Coating

Smooth, glossy, low friction finish protects against turbulence, abrasion, and cavitation. This advanced epoxy protects equipment from extreme chemical attack and corrosion. Low viscosity epoxy can be applied by brush.



#### Loctite® Nordbak® Wearing Compound

Trowelable compound that protects against sliding abrasion. Use to rebuild and protect chutes, pump housings, elbows, cyclones, and material handling equipment.



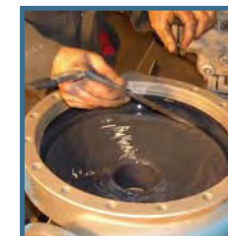
#### Loctite® Nordbak® High Impact Wearing Compound

Rubber modified compound absorbs impact. Recommended where both sliding abrasion and impact are present.



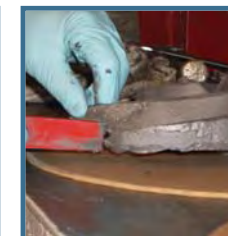
#### Loctite® Nordbak® Pneu-Wear

Resists fine particle abrasion caused in pipe elbows of pneumatic conveyor systems. ABS Approved.



#### Loctite® Nordbak® Brushable Ceramic

Smooth, wear resistant, low friction coating to combat turbulence and cavitation on components such as pump housings and impellers. Grey version is approved for use in potable water systems, NSF/ANSI 61 Approved. ABS Approved.



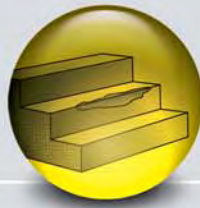
#### Loctite® Nordbak® Wear Resistant Putty

Ceramic fibers give this trowelable putty excellent wear and abrasion resistance with a smooth, low friction finish. Can be used over other wearing compounds to fill voids.



#### Loctite® Fixmaster® Flex 80™ Putty

A trowelable, two-part urethane for rebuilding and repairing rubber parts and linings, providing impact, abrasion, and corrosion resistant protection. Use Flex™ accessory products to properly etch, clean, and prime surfaces. ABS Approved.



# Floor and Concrete Repair

- Chemical and corrosion resistance
- High impact resistance
- Bond to concrete, wood, metals, brick, and other common building materials

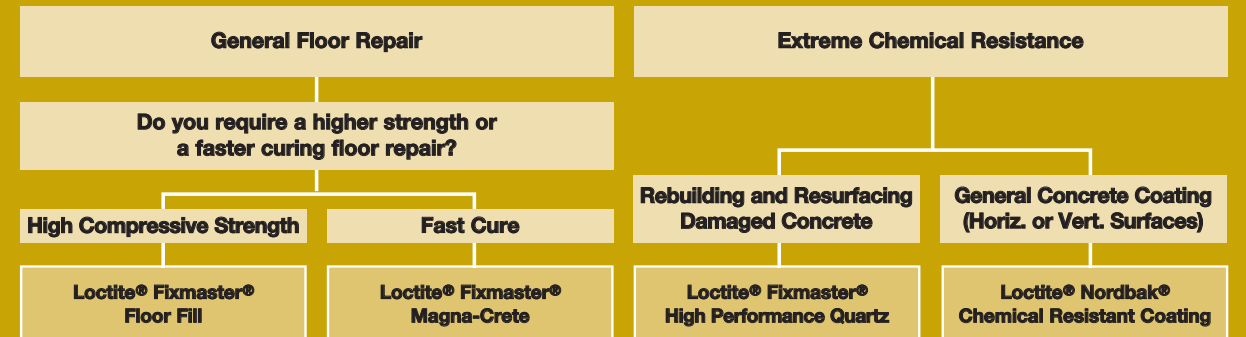
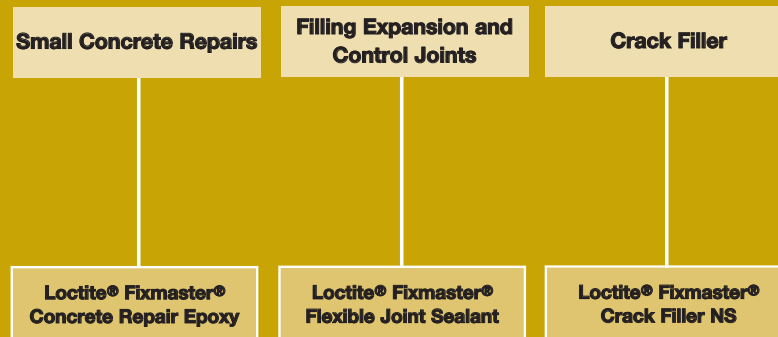


## FLOOR REPAIRS

### Helpful Hints:

- Vary consistency of Loctite® Fixmaster® Magna-Crete for vertical applications
- Use Loctite® Fixmaster® Magna-Crete for cold storage applications
- No concrete bonding agents are required
- Use a backer rod when filling deep expansion joints

### Solution



	Loctite® Fixmaster® Concrete Repair Epoxy	Loctite® Fixmaster® Flexible Joint Sealant	Loctite® Fixmaster® Crack Filler NS	Loctite® Fixmaster® Floor Fill	Loctite® Fixmaster® Magna-Crete	Loctite® Fixmaster® High Performance Quartz	Loctite® Nordbak® Chemical Resistant Coating
<b>Color</b>	Grey	Grey	Grey	Grey	Grey	Grey	Grey
<b>Maximum Temperature</b>	250°F (121°C)	180°F (82°C)	110°F (43°C)	225°F (107°C)	2,000°F (1,093°C)	150°F (66°C)	150°F (66°C)
<b>Compressive Strength</b>	12,000 psi	N.A.	9,800 psi	15,000 psi	13,000 psi	12,000 psi	10,000 psi
<b>Working Time</b>	4-7 min.	30 min.	8 min.	40-60 min.	15 min.	45 min.	20 min.
<b>Functional Cure</b>	1 hr.	24 hr.	2 hr.	24 hr.	1 hr.	24 hr.	16 hr.
<b>Chemical Resistance</b>	Good	High	Good	Good	Fair	Excellent	Excellent
<b>Common Sizes / Part Number</b>	4 oz. stick – 39366	1 gallon kit – 40347	8.6 fl. oz. coaxial cartridge – 1108886	10 lb. kit – 99361 40 lb. kit – 99365	1 lb. kit – 1012500 1 gallon kit – 95551 5 gallon kit – 95555	42 lb. kit – 96495	12 lb. kit – 96092

### Additional Products

Name	Features	Part #	Pkg. Size
Loctite® Urethane Sealant	Grey	39916	10.2 oz. cart.
	Black	36132	10.2 oz. cart.
Loctite® Fixmaster® Crack Filler (trowelable)	White/Tan	40346	1 gal. kit
Loctite® Fixmaster® Magna-Crete Activator	Extra Activator	36334	10 lb. bottle
Loctite® Fixmaster® Flex 80™ Liquid	Black	97413	1 lb. kit
Loctite® Fixmaster® Magna-Crete Winter Additive	Speeds cure time by 10 min. when winter temp. is below 45°F	40270	1 lb. bottle
Loctite® Fixmaster® Magna-Crete Summer Additive	Slows cure time by 10 min. when summer temp. is above 85°F	40271	1 lb. bottle
Loctite® Fixmaster® Magna-Crete	For large applications	42066	55 gal. activator
		40898	2,475 lb. aggregate



**Loctite® Fixmaster® Concrete Repair Epoxy**

Enables permanent repairs to concrete and masonry. Convenient stick contains pre-measured portions of activator and base. Once cured, it can be tamped, drilled, screwed, sawed, filed or painted, and will have an appearance and texture similar to concrete.



**Loctite® Fixmaster® Flexible Joint Sealant**

A two-component, urethane-based sealant. Excellent adhesion, high chemical resistance, and excellent tensile strength, flexibility and elongation.



**Loctite® Fixmaster® Crack Filler NS**

Non-drip, non-sag formula will repair holes, spalls and cracks in concrete, brick, block and masonry on horizontal or vertical surfaces. This two-part, rapid curing, high strength epoxy will not soften over time and can be used indoors or outdoors.



**Loctite® Fixmaster® Floor Fill**

A three-component, self-leveling, non-shrinking epoxy floor repair system. 100% solid, epoxy-based system for repairing holes in floors, spalled areas, ramps, stairs, cracks in floors, and for use in grouting applications. Stronger than concrete, it bonds to almost any clean substrate and provides corrosion and chemical resistance.



**Loctite® Fixmaster® Magna-Crete**

This two-component magnesium phosphate cement sets rapidly and has a very high early strength. Ideal for road and aircraft runway repairs, which can typically be driven over after 45 minutes. It bonds to new and old concrete as well as most construction materials including wood, glass, and steel. No water additive, so it can be applied at temperatures as low as -15°F.



**Loctite® Fixmaster® High Performance Quartz**

A highly-filled, quartz epoxy system designed to protect old or new concrete from chemical attack. Provides a surface resistant to concentrated acids, alkalis, and solvents. Areas damaged by chemical attack may be resurfaced with HPQ. Easily applied, trowelable system that should be applied at a minimum 1/4" build to provide maximum chemical resistance.



**Loctite® Nordbak® Chemical Resistant Coating**

Smooth, glossy, low friction finish protects against turbulence, abrasion, and cavitation. This advanced epoxy protects from extreme chemical attack and corrosion. Low viscosity epoxy can be applied by brush.



# Grouting

- Chemical and corrosion resistance
- Self-leveling and non-shrinking
- Stronger than concrete
- Bond to concrete, wood, metals, brick, and other common building materials

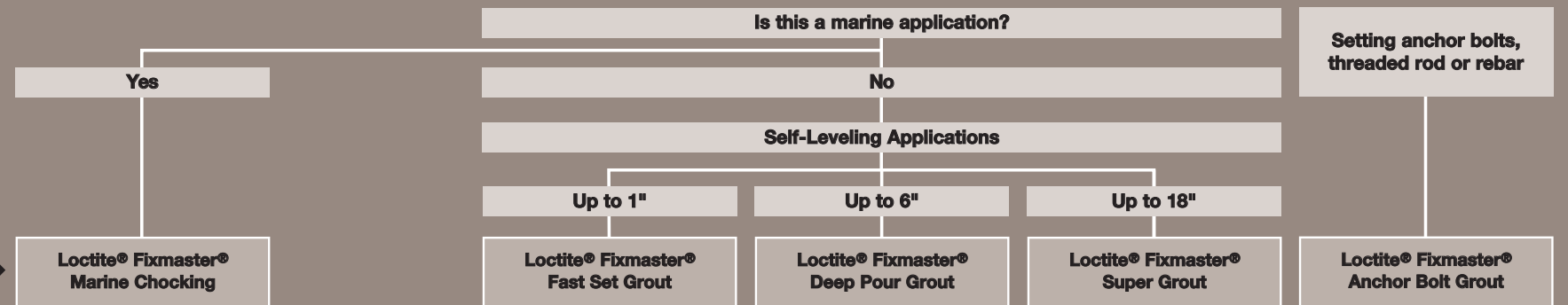


## GROUTING

### Helpful Hints:

- Replace traditional steel chocks with Loctite® Fixmaster® Marine Checking for mounting equipment in the marine industry

### Solution



	Loctite® Fixmaster® Marine Checking	Loctite® Fixmaster® Fast Set Grout	Loctite® Fixmaster® Deep Pour Grout	Loctite® Fixmaster® Super Grout	Loctite® Fixmaster® Anchor Bolt Grout
<b>Color</b>	Green or Orange	Red	Black	Red	Grey
<b>Maximum Temperature</b>	250°F (121°C)	200°F (93°C)	225°F (107°C)	225°F (107°C)	110°F (43°C)
<b>Compressive Strength / Tension Load</b>	22,000 psi/NA	14,500 psi/NA	14,500 psi/NA	12,900 psi/NA	NA/14,146 lbs.*
<b>Working Time*</b>	10-15 min.	10 min.	30 min.	285 min.	20 min.
<b>Functional Cure</b>	24 hrs.	12 hrs.	24 hrs.	24 hrs.	2 hrs.
<b>Common Sizes / Part Number</b>	1 gallon kit orange – 37316 2 gallon kit orange – 96102 2 gallon kit green – 97572	2 gallon kit – 39637	5 gallon kit – 99545	5 gallon kit – 33510	20.7 fl. oz. dual cartridge – 1108885

\* Typical value @ 77°F (25°C)

† 9D is the embedment depth of the anchor (9 X 1/2"); in this example, a 1/2" threaded rod embedded 4-1/2" in 3,000 psi concrete

### Additional Products

Name	Features	Part #	Pkg. Size
Loctite® Fixmaster® Anchor Bolt Grout	A high performance product with greater tension load capacity	1108757	8.6 fl. oz. coaxial cartridge
		1108758	20.7 fl. oz. dual cartridge



#### Loctite® Fixmaster® Marine Checking

Self-leveling, fast-curing, non-shrinking grout. Outstanding chemical and vibration resistance and compressive strength to withstand maximum loads. ABS Approved.



#### Loctite® Fixmaster® Fast Set Grout

Self-leveling, non-shrinking grout for installing machinery and setting anchor bolts. Cures quickly. Can be poured up to 1" thick. Compression strength and chemical resistance are superior to concrete. Forms strong bonds to old concrete and to itself.



#### Loctite® Fixmaster® Deep Pour Grout

Aggregate-filled, epoxy system for pours up to 6" deep, including self-leveling applications under rails and sole plates. High strength material bonds to steel, concrete, and itself. Withstands high torque load.



#### Loctite® Fixmaster® Super Grout

Designed for grouting up to 18" deep, including self-leveling applications under rails and sole plates. A 100% solids epoxy system that is non-shrinking, chemical and corrosion resistant, stronger than concrete, and withstands high torque loading.



#### Loctite® Fixmaster® Anchor Bolt Grout

This two-part structural epoxy is solvent free, odorless, high strength, and non-sag. It is formulated to anchor threaded rods, bolts, rebar dowels, and smooth dowels into concrete, grout-filled block, and masonry. Also available in a high strength formula.



# Floor Coatings

- Repair, resurface and protect industrial floors
- Smooth anti-slip finish
- High gloss provides higher visibility and improved safety

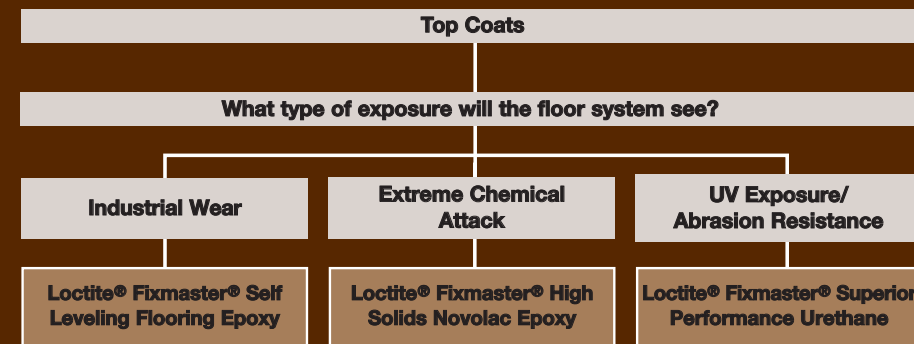
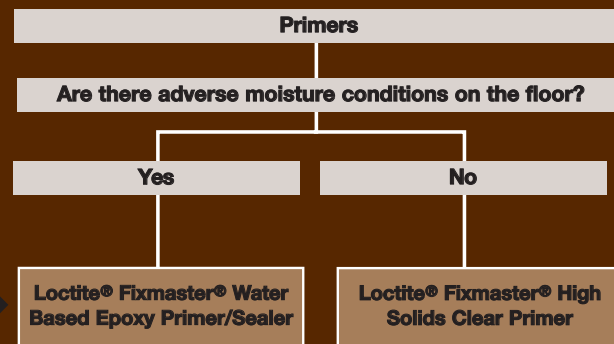


## FLOOR COATINGS

### Helpful Hints:

- Surface preparation before coating is critical. Make sure to follow instructions as to how to properly prepare the substrate to be coated
- Moisture detection prior to coating is very important. Detection techniques include:
  - Checking under mats in walking areas or under equipment to see if moisture exists
  - Tape the edges of a 4 mil, 2' X2' plastic sheet, leave several hours or overnight, and then check for condensation
  - Use a moisture meter or calcium chloride test to check for moisture

### Solution



	Loctite® Fixmaster® Water Based Epoxy Primer/Sealer	Loctite® Fixmaster® High Solids Clear Primer	Loctite® Fixmaster® Self Leveling Flooring Epoxy	Loctite® Fixmaster® High Solids Novolac Epoxy	Loctite® Fixmaster® Superior Performance Urethane
<b>Color</b>	Clear	Clear	Deck Grey*	Grey	Deck Grey*
<b>Work Life</b>	90 min.	40 min.	30 min.	30 min.	4 hr.
<b>Recoat Time (hours)</b>	6-48 hr.	8-36 hr.	8-72 hr.	8-72 hr.	6-24 hr.
<b>Cure Time (full service)</b>	N.A.	N.A.	72 hr.	7 days	72 hr.
<b>Coverage (sq. ft./gal)</b>	250 sq. ft. @ 5-7 mils	200 sq. ft. @ 7-9 mils	105 sq. ft. @ 15 mils	100 sq. ft. @ 14-16 mils	250 sq. ft. @ 5-7 mils
<b>Common Sizes / Part Number</b>	2 gallon kit - 40348††	1 gallon kit - 40319	1 gallon kit - 40332†	3.5 gallon resin - 40344 1.5 gallon hardener - 40345	1 gallon kit - 40311†

\* Also available in clear, haze grey, sandstone, and red  
 † 5 gallon kits also available  
 †† 10 gallon kits also available

Additional Products			
Name	Features	Part #	Pkg. Size
Loctite® Fixmaster® Self Leveling Flooring Epoxy	High Build Additive for floors requiring films of 30 mil or greater	40343	25 lb. (add to a 5 gallon kit)
Loctite® Fixmaster® Self Leveling Epoxy	Fast Set Hardener for increased cure speed	40341	5 gallon pail
Loctite® Fixmaster® Superior Performance Urethane	Anti-slip Additive	40314	10 oz. can
		40315	2 oz. bottle
Loctite® Fixmaster® Epoxy Floor Resurfacer	Trowel applied surfacing and leveling system	Requires both Resin and Aggregate	
		40326	Resin for 20 sq. ft.
		40325	40 lb bag of cement color aggregate**

\*\* Also available in deck grey, haze grey, and tile red



### Loctite® Fixmaster® Water Based Epoxy Primer/Sealer

Loctite® Fixmaster® Water Based Epoxy Primer/Sealer is a thin film, two-component, clear, water-based primer designed for use with most high performance floor coatings. It has a low viscosity for maximum penetration and can be brushed, rolled, or sprayed on. Use over new or old concrete, masonry, wood, and previously coated surfaces.



### Loctite® Fixmaster® High Solids Clear Primer

Loctite® Fixmaster® High Solids Primer is a clear, high solids, high build primer designed for use with clear finish coats or any of the Loctite® Fixmaster® Self Leveling Flooring Epoxy systems. It is fast curing, low odor, and low viscosity. Reduces bubbling and pinholes that occur when coating porous substrates. High build for use over mechanically prepared substrates.



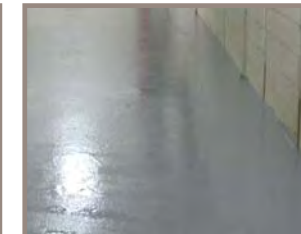
### Loctite® Fixmaster® Self Leveling Flooring Epoxy

Loctite® Fixmaster® Self Leveling Flooring Epoxy is a two-component, 100% solids, high performance self-leveling floor coating. Provides a high gloss, seamless, hygienic surface that is extremely hard wearing and durable. This epoxy has zero VOCs, is extremely low odor, and offers high chemical resistance.



### Loctite® Fixmaster® High Solids Novolac Epoxy

Loctite® Fixmaster® High Solids Novolac Epoxy is a two-component, high-build, high solids, novolac epoxy coating for surface protection against severe chemical attack. Provides a high gloss, seamless, hygienic surface that is extremely hard wearing and durable. Low odor and low VOC. Can be brushed, rolled or sprayed on to a thickness of 11 to 14 mils.



### Loctite® Fixmaster® Superior Performance Urethane

Loctite® Fixmaster® Superior Performance Urethane is an interior or exterior high solids, polyester aliphatic floor coating. This coating offers high chemical resistance and can be brushed, rolled or sprayed on to a thickness of 3 to 4 mils. Also available for use as line striping to mark particular areas of your plant in safety yellow or white.



# Anti-Slip Floor Coatings

- Chemical resistance
- Designed to increase the Coefficient of Friction (COF)
- Exceeds OSHA COF recommendations
- Reduce slips and falls in the workplace

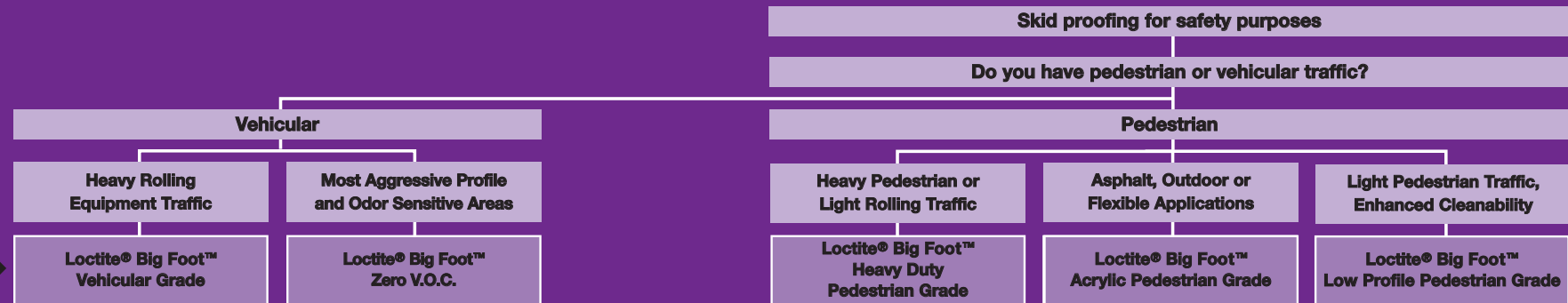


## ANTI-SLIP COATINGS

### Helpful Hints:

- Most formulas can be rolled, sprayed, or troweled
- Finished flooring is easily cleaned with a biodegradable cleaner/degreaser
- Remove any oil, grease, dirt or water prior to application
- Test for the presence of water to determine if floor can be coated
- It is always recommended that a primer be used. Primers increase adhesion to the substrate and also seal porosity when applying on concrete

### Solution



	Black or Grey	Grey or Black	Black, Grey or Safety Yellow	Grey	Safety Yellow
<b>Color</b>	Black or Grey	Grey or Black	Black, Grey or Safety Yellow	Grey	Safety Yellow
<b>Coefficient of Friction (Dry/Wet)</b>	1.05/1.05	1.10/1.00	1.17/1.00	1.30/0.90	0.78/0.86
<b>Coverage per Gallon (ft.<sup>2</sup>/meter<sup>2</sup>)</b>	40 ft. <sup>2</sup> (3.7 m <sup>2</sup> )	35 ft. <sup>2</sup> (3.3 m <sup>2</sup> )	50 ft. <sup>2</sup> (4.7 m <sup>2</sup> )	70 ft. <sup>2</sup> (6.5 m <sup>2</sup> )	90 ft. <sup>2</sup> (8.3 m <sup>2</sup> )
<b>Working Time</b>	4 hr.	1 hr.	N.A.	N.A.	1 hr.
<b>Drying Time (Light Pedestrian Traffic/Heavy Pedestrian Traffic)</b>	12/72 hr.	24/72 hr.	12/72 hr.	4/24 hr.	24/72 hr.
<b>Common Sizes / Part Number</b>	1 gallon kit black – 96221 1 gallon kit grey – 96251 5 gallon kit grey – 96255	1 gallon kit grey – 39915 1 gallon kit black – 96231	1 gallon kit black – 96211 1 gallon kit grey – 96261 5 gallon kit grey – 96285 1 gallon kit safety yellow – 40302 5 gallon kit safety yellow – 40303	1 gallon kit – 95591	1 gallon kit – 40352

### Additional Products

Name	Used on or with	Part #	Pkg. Size
Loctite® Big Foot™ Metal Primer	Metal	96132	1 gallon kit
Loctite® Big Foot™ Acrylic Primer	Loctite® Big Foot™ Acrylic Pedestrian Grade	95581	1 gallon kit
Loctite® Big Foot™ Water-Based Primer/Sealer	Porous Surfaces (ex. Concrete, wood, tile)	94142	1 gallon kit
Loctite® Mixer Blades	To mix all 1 gallon kits of Loctite® Big Foot™ flooring compounds	96131	1 blade
Loctite® Phenolic Rollers	Loctite® Big Foot™ Low Profile, Heavy Duty, Vehicular and Zero V.O.C. grade products	96121	1 roller
Loctite® Bristle Rollers	Loctite® Big Foot™ Acrylic Pedestrian, Acrylic Primer, Metal Primer and Water Based Primer Sealer	96153	1 roller



#### Loctite® Big Foot™ Vehicular Grade

Withstands even the heaviest rolling equipment traffic. Resists liquids as harsh as jet fuels and hydraulic fluids. Superior adhesion forms a solid bond to metal, concrete, and wood.



#### Loctite® Big Foot™ Zero V.O.C.

This 100% reactive, solvent-free epoxy has the most aggressive profile in the Big Foot™ line. Use in odor-sensitive areas such as wineries, food processing plants, hospitals, or confined spaces.



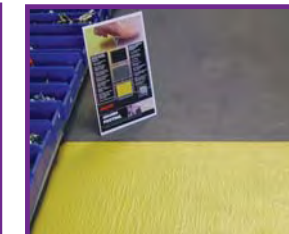
#### Loctite® Big Foot™ Heavy Duty Pedestrian Grade

For areas with heavy pedestrian or light rolling traffic. Ideal for ramps, walkways, locker rooms, stairs, and assembly areas.



#### Loctite® Big Foot™ Acrylic Pedestrian Grade

A single-component, elastomeric, anti-slip floor and deck coating for optimum adhesion to asphalt and flexible applications. Best for outdoor applications.



#### Loctite® Big Foot™ Low Profile Pedestrian Grade

A single-component, epoxy non-slip floor and deck coating for optimum adhesion to asphalt and flexible applications. Best for outdoor applications.



# Belt Repair

- Repair gouges, cuts and worn edges on rubber belting
- Non-shrinking and unaffected by oil, grease, and water
- Excellent flexibility and elongation

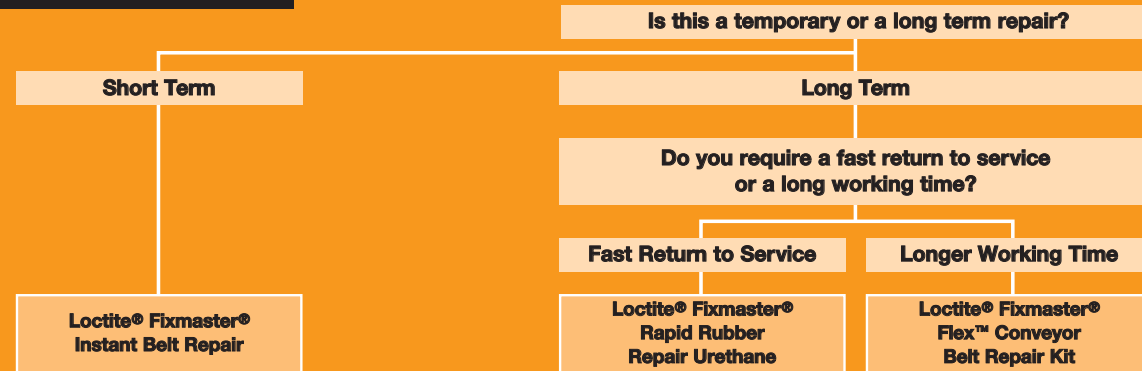


## CONVEYOR BELT REPAIR

### Helpful Hints:

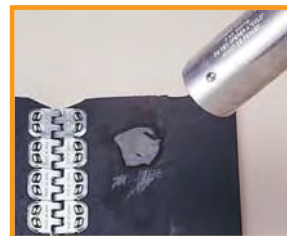
- Loctite® Fixmaster® Rapid Rubber Repair 400 ml cartridges and kit require Loctite® Rapid Rubber Repair Dispenser, Part Number 39635
- Loctite® Fixmaster® Instant Belt Repair requires heat
- Loctite® Fixmaster® Instant Belt Repair can be applied at any temperature
- Use the recommended accessory products to ensure maximum adhesion and product reliability

### Solution



	Loctite® Fixmaster® Instant Belt Repair	Loctite® Fixmaster® Rapid Rubber Repair Urethane	Loctite® Fixmaster® Flex™ Conveyor Belt Repair Kit
<b>Color</b>	Amber	Black	Black
<b>Working Time</b>	N.A.	1 min.	10 min.
<b>Tensile Strength</b>	400 psi	1,300 psi	1,500 psi
<b>Functional Cure</b>	30 min.	2 hrs.	8 hrs.
<b>Common Sizes / Part Number</b>	1 lb. kit – 37719	400 ml kit – 96677 400 ml cartridge – 96675 150 ml coaxial cart. – 96676	1 lb. kit – 96693

Additional Products			
Name	Features	Part #	Pkg. Size
Loctite® Fixmaster® Etching Agent	Enhances bonds to natural, SBR, and butadiene rubber	99626	3 fl. oz. bottle
Loctite® Fixmaster® Flex™ Cleaner	Cleans rubber, urethane or metal	39636	4 fl. oz. can
Loctite® Fixmaster® Rapid Rubber Repair Static Mixers	Mixing nozzles for 400 ml cartridge of Loctite® Fixmaster® Rapid Rubber Repair Urethane	39633	Bag of 6 nozzles
Loctite® Fixmaster® Flex™ Metal Primer	Promotes adhesion to metal parts	98471	3.3 fl. oz. can



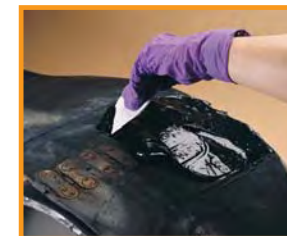
### Loctite® Fixmaster® Instant Belt Repair

A single-component, heat-curing material for fast, temporary belt repairs. Requires no priming. Equipment can be operated in 30 minutes.



### Loctite® Fixmaster® Rapid Rubber Repair Urethane

Our premium quality, belt repair product is designed to repair conveyor belts and other damaged rubber equipment quickly and easily. Repairs will have the same durability and flexibility as the belt. The 400 ml cartridge requires the use of a Loctite® Fixmaster® Rapid Rubber Repair Dispenser. Also available in a kit with etching agent and cleaner.



### Loctite® Fixmaster® Flex™ Conveyor Belt Repair Kit

Makes long-lasting belt repairs. Recommended for applications where speed of application is not critical. Cures in 8-12 hours.

### Loctite® Fixmaster® Rapid Rubber Repair Dispenser

Easy-to-use applicator for the Loctite® Fixmaster® Rapid Rubber Repair Kit.

**Part Number:** 39635





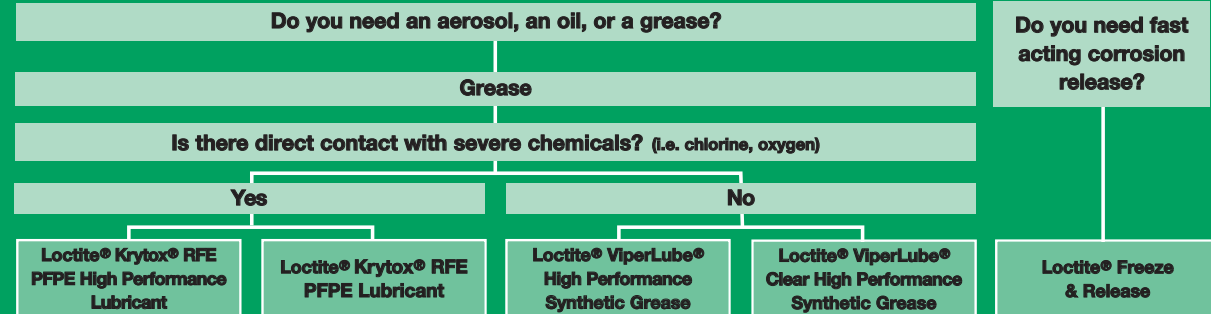
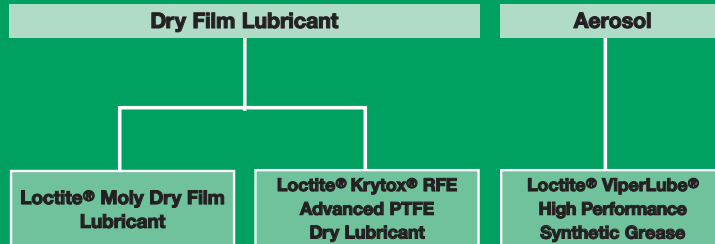
# Lubricants

- Temperature resistance
- Thermal stability
- Penetrate and free corroded assemblies



## HIGH PERFORMANCE LUBRICATION

### Solution



Base Oil	Molybdenum disulfide	PTFE†	PAO†	PFPE†	PFPE†	PAO†	PAO†	Mineral Oils, Silicone Free
Viscosity	•	•	•	240 CST <sup>1</sup>	240 CST <sup>1</sup>	240 CST <sup>1</sup>	103 CST <sup>1</sup>	1 cP
Temperature Range	-20°F to 750°F (-29°C to 398°C)	-15°F to 500°F (-26°C to 260°C)	-40°F to 500°F* (-40°C to 260°C)	-15°F to 500°F (-26°C to 260°C)	-15°F to 500°F (-26°C to 260°C)	-40°F to 500°F* (-40°C to 260°C)	-45°F to 520°F‡ (-20°C to 271°C)	-4°F to 113°F (-20°C to 45°C)
Four Ball Wear Test (mm)	•	•	•	0.30 mm <sup>2</sup>	0.30 mm <sup>2</sup>	0.42 mm <sup>2</sup>	0.60 mm <sup>2</sup>	NA
Food Grade	•	•	NSF H1	NSF H2	NSF H2	NSF H1	NSF H1	•
Common Sizes / Part Number	12 oz. aerosol – 39895 1.3 lb. can – 39896 10 lb. can – 39897	8 oz. aerosol – 30138	10.1 oz. aerosol – 36786	2 oz. tube – 29711 16 oz. cartridge – 29709	2 oz. tube – 29710 16 oz. aerosol – 31361 16 lb. pail – 31360	3 oz. tube – 36781 14 oz. cart. – 36782 400 g can – 36783 30 lb. pail – 37061 120 lb. drum – 37710	3 oz. tube – 39341 400 g cart. – 39342 30 lb. pail – 39364	13.52 fl. oz. (400 ml) aerosol – 996456

† PTFE = PolyTetraFluoroEthylene PFPE = PerFluoroPolyEther  
PAO = PolyAlphaOlefin  
\* 400°F (204°C) – Continuous, 500°F (260°C) – Intermittent  
‡ 420°F (216°C) – Continuous, 520°F (271°C) – Intermittent  
<sup>1</sup> CST @ 40°C  
<sup>2</sup> Four Ball Wear, ASTM D-2266    <sup>3</sup> Four Ball Wear, ASTM D-4172

### Additional Products

Name	Feature	Part #	Pkg. Size
Loctite® Extreme Pressure Grease	NLGI 1	51242	14.5 oz. aerosol
Loctite® Gear, Chain and Cable Lubricant	Repels dirt, sand, and dust	81251	12 oz. aerosol
Loctite® Silicone Lubricant	Food processing	51360	150 g tube
Loctite® Dielectric Grease	Electrical Equipment	37535	3 oz. tube
Loctite® White Lithium Grease	Metal to metal, metal to plastic	30530	1.5 oz. tube
Loctite® Food Grade Grease	Food processing	51252	14.5 oz. aerosol
Loctite® Maintain® Lubricant Penetrant	Close-fitting parts	81204	16 oz. aerosol
Loctite® Hydraulic Jack Oil	Hydraulic units	30522	1 qt. can
Loctite® Penetrating Oil	Displaces moisture	51221	12 oz. aerosol
Loctite® Solvo-Rust® Super Penetrating Oil	Close-fitting parts	81252	12.25 oz. aerosol



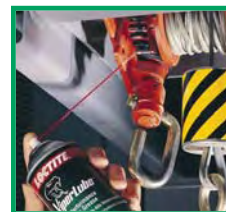
#### Loctite® Moly Dry Film Lubricant

Solid film lubricant for sliding surfaces and slow-moving parts. Temperature resistant up to 750°F (399°C) as a dry film lubricant, 2400°F (1315°C) as an anti-seize. Won't squeeze out, burn off, or pick up dirt.



#### Loctite® Krytox® RFE Advanced PTFE Dry Lubricant

High performance, synthetic lubricant designed to provide long-lasting lubrication for parts that require a dry, thin lubricating film. Krytox® RFE Advanced PTFE Dry Lubricant provides excellent lubrication properties over a broad temperature range.



#### Loctite® ViperLube® High Performance Synthetic Grease

NLGI Grade 2/Severe Duty GC-LB Grease provides protection against equipment exposed to a wide range of temperatures. Use as a lubricant and protective anti-rust film on bearings and machine parts, or as a release agent on gaskets and seals. NSF H1 rated for incidental food contact.



#### Loctite® Krytox® RFE PFPE High Performance Lubricant

Synthetic grease provides long-lasting lubrication for all types of moving and/or sliding parts. Compatible with all plastics, elastomers, and metals. Non-flammable, chemically resistant, and oxygen compatible.



#### Loctite® Krytox® RFE PFPE Lubricant

High performance synthetic grease formulated specifically for severe environments. Great for lubricating o-rings. Excellent lubrication properties over a broad temperature range and in chlorine processing. NLGI Grade 2.



#### Loctite® ViperLube® High Performance Synthetic Grease

NLGI Grade 2/Severe Duty GC-LB Grease provides protection against equipment exposed to a wide range of temperatures. Use as a lubricant and machine parts, or as a release agent on gaskets and seals. NSF H1 rated for incidental food contact.



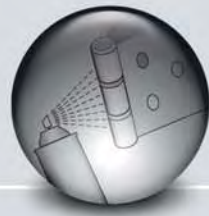
#### Loctite® ViperLube® Clear High Performance Synthetic Grease

Lasts four times longer than petroleum-based lubricants. Withstands temperatures up to 420°F (520°F intermittent). Contains PTFE for added protection against friction and wear. Non-flammable. Contains no ODCs. Clear in color. NLGI 2 grade grease. NSF H1 rated for incidental food contact.



#### Loctite® Freeze & Release, Fast Acting Corrosion Release

The solution for releasing seized or corroded parts. Instantly freezes seized and rusted parts (bolts, nuts, studs) down to -45°F (-43°C). The shock-freeze causes microscopic cracks in the layer of rust, allowing the lubricating ingredient to wick directly into the rust. Dismantle parts in 1-2 minutes.

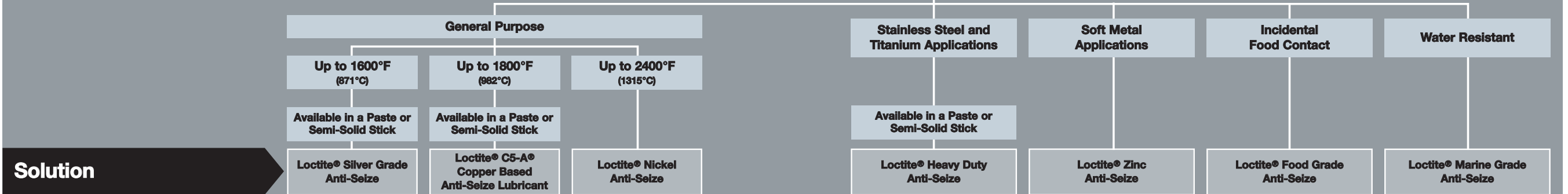


# Anti-Seize Lubricants

- Protect against rust, corrosion, seizing, and galling
- Provide lubrication in extreme environments



## WHAT TYPE OF ANTI-SEIZE DO YOU REQUIRE?

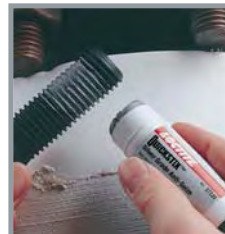


Solution	General Purpose Up to 1600°F (871°C) Available in a Paste or Semi-Solid Stick Loctite® Silver Grade Anti-Seize	General Purpose Up to 1800°F (982°C) Available in a Paste or Semi-Solid Stick Loctite® C5-A® Copper Based Anti-Seize Lubricant	General Purpose Up to 2400°F (1315°C) Available in a Paste or Semi-Solid Stick Loctite® Nickel Anti-Seize	Stainless Steel and Titanium Applications Available in a Paste or Semi-Solid Stick Loctite® Heavy Duty Anti-Seize	Soft Metal Applications Loctite® Zinc Anti-Seize	Incidental Food Contact Loctite® Food Grade Anti-Seize	Water Resistant Loctite® Marine Grade Anti-Seize
<b>Color</b>	Silver	Copper	Silver	Black	Grey	White	Black
<b>Solid Lubricating Agent</b>	Graphite/Aluminum	Copper/Graphite	Nickel/Graphite	Graphite/Calcium Fluoride	Zinc	White Lubricating Solids	Calcium Sulfonate
<b>Torque Coefficient*</b>	0.18	0.16	0.13	0.16	0.15	0.13	0.18
<b>Temperature Range</b>	-20°F to 1600°F (-29°C to 870°C)	-20°F to 1800°F (-29°C to 982°C)	-20°F to 2400°F (-29°C to 1315°C)	-20°F to 2400°F (-29°C to 1315°C)	-20°F to 750°F (-29°C to 399°C)	-20°F to 750°F (-29°C to 399°C)	-20°F to 2400°F (-29°C to 1315°C)
<b>Metal-Free</b>	No	No	No	Yes	No	Yes	Yes
<b>Common Sizes / Part Number</b>	8 oz. brush top – 76732 1 lb. brush top – 76764 20 g stick – 37230 12 oz. aerosol – 76759	8 oz. brush top – 51147 1 lb. brush top – 51007 20 g stick – 37229 12 oz. aerosol – 51003	8 oz. brush top – 77124 1 lb. brush top – 77164 12 oz. aerosol – 51286	9 oz. brush top – 51605 1.2 lb. brush top – 51606 20 g stick – 41205	1 lb. can – 39901	8 oz. brush top – 51168 2 lb. can – 51170	8 oz. brush top – 34395 1 lb. brush top – 34026

\* K value on steel nuts and bolts

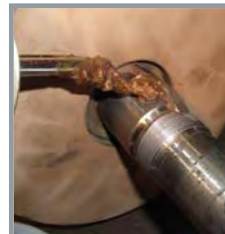
### Additional Loctite® brand Anti-Seizes

Name	Feature	Max Temp	Part #	Pkg. Size
Loctite® White Hi-Temp Anti-Seize	Non-metallic, high temp	2000°F (1093°C)	34517	8 oz. brush top can
Loctite® N-1000™ High Purity Anti-Seize	Power plant, copper based	1800°F (892°C)	51115	8 oz. brush top can
Loctite® N-5000™ High Purity Anti-Seize	Power plant, nickel based	2400°F (1315°C)	51243	8 oz. brush top can
Loctite® High Performance N-5000™ High Purity Anti-Seize	Power plant, nickel based, high lubricity	2400°F (1315°C)	51572	1 lb. brush top can
Loctite® N-7000™ High Purity Anti-Seize	Power plant, metal-free	2400°F (1315°C)	51272	8 oz. brush top can
Loctite® Moly-50™ Anti-Seize	Thread lubricant	750°F (399°C)	51094	1 lb. can
Loctite® Graphite-50™ Anti-Seize	Electrically conductive nonmetallic	900°F (482°C)	51084	1 lb. can
Loctite® Moly Paste	Withstands extreme pressure, heavy loads	750°F (399°C)	51048	8 oz. brush top can



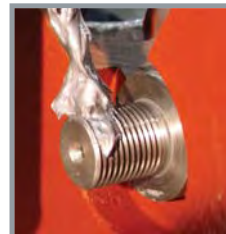
#### Loctite® Silver Grade Anti-Seize

Heavy duty, temperature resistant, petroleum-based lubricant compound fortified with graphite and metallic flake. Inert and will not evaporate or harden in extreme cold or heat. For use in assemblies up to 1600°F (871°C). ABS Approved. Tested to MIL-PRF-907E. CFIA Approved.



#### Loctite® C5-A® Copper Based Anti-Seize Lubricant

Exclusive formula suspends copper and graphite in a high quality grease. Protects metal parts from rust, corrosion, galling, and seizing at temperatures to 1800°F (982°C). Tested to MIL-PRF-907E. CFIA Approved.



#### Loctite® Nickel Anti-Seize

Copper-free. Recommended for stainless steel and other metal fittings. For preventing corrosion, seizing, and galling in harsh, chemical environments, and temperatures to 2400°F (1315°C). ABS Approved.



#### Loctite® Heavy Duty Anti-Seize

Metal-free. Excellent lubricity. Provides outstanding lubrication to all metals including stainless steel, aluminum, and soft metals up to 2400°F (1315°C).



#### Loctite® Zinc Anti-Seize

Protects aluminum and ferrous surfaces from seizure and corrosion up to 750°F (399°C).



#### Loctite® Food Grade Anti-Seize

Prevents seizure, galling, and friction in stainless steel and other metal parts up to 750°F (399°C). NSF H1 rated for incidental food contact.



#### Loctite® Marine Grade Anti-Seize

Formulated to protect assemblies exposed directly or indirectly to fresh and salt water, this anti-seize works especially well in high humidity conditions. It has excellent lubricity, superior water wash-out spray resistance, and prevents galvanic corrosion. ABS Approved.





# Surface Protection and Rust Prevention

- Stabilize existing rust
- Guard against corrosion
- Prevent electro-chemical corrosion
- Increase belt friction



## SURFACE PROTECTION AND RUST PREVENTION

Solution	Belt Dressing	Rust Treatment	Corrosion Protection			
			General Purpose			
			Cathodic Protection	Undercoating	Non-Drying	Color Coding
	Loctite® Belt Dressing & Conditioner	Loctite® Extend® Rust Treatment	Loctite® Cold Galvanizing Compound	Loctite® Heavy-Duty Rubberized Undercoating	Loctite® Maxi-Coat™	Loctite® Color Guard®
<b>Description</b>	Liquid Spray	Rust Converter	Zinc Spray	Rubberized Spray	Waxy Film	Rubber Coating
<b>Color</b>	Colorless	Matte black	Grey	Black	Brown	Red, Yellow, Blue, Black
<b>Temperature Range</b>	Up to 200°F (93°C)	Up to 250°F (121°C)	Up to 400°F (204°C)	Up to 200°F (93°C)	Up to 200°F (93°C)	Up to 200°F (93°C)
<b>Dry Time</b>	N.A.	30 min.	15 min.	20 min.	N.A.	4 hrs.
<b>Common Sizes / Part Number</b>	12 oz. aerosol – 30527	10.25 oz. aerosol – 30539 1 qt. bottle – 75430 1 gallon bottle – 75448 5 gallon pail – 75465	15 oz. aerosol – 82039	16 oz. aerosol – 30538	12 oz. aerosol – 51211 1 gallon can – 51213	11 oz. aerosol* 14.5 fl. oz. can* 1 gallon can*

\* Available in Black, Blue, Red and Yellow. See index for Part Numbers.

Additional Products		
Name	Part #	Pkg. Size
Loctite® Primer for Color Guard®	34994	1 gallon pail
Loctite® Thinner for Color Guard®	34995	1 gallon pail
Loctite® Nordbak® Chemical Resistant Coating	96092	12 lb. kit



### Loctite® Belt Dressing & Conditioner

Recommended to prevent slipping and increase friction for all types of belts. Extends belt life. Penetrates the cord fibers of "V" belts to restore pliability and flexibility. Eliminates squeaking and glazing.



### Loctite® Extend® Rust Treatment

Converts existing rust into a stable base. Cured product acts as a primer ready for painting. Protects surfaces from corrosion. Use on metal pipes, valves, fittings, storage tanks, fences, guard rails, conveyors, construction and agricultural equipment. ABS Approved.



### Loctite® Cold Galvanizing Compound

Sprays on metal surfaces to prevent corrosion even when the surface is scratched. Ideal touch-up for welded seams. Highly resistant to salt corrosion and water. Not resistant to acid or alkaline solutions. Contains no ozone-depleting compounds.



### Loctite® Heavy-Duty Rubberized Undercoating

This heavy-duty undercoating seals, protects, and insulates. Rubberized for maximum durability.



### Loctite® Maxi-Coat™, Heavy Duty Rustproofing

Heavy-duty coating provides long-term protection for metal parts, equipment, and machinery. Forms a protective, waxy film which seals out moisture, air, acid, and other corrosive elements. Great for protecting parts in storage. Removable.



### Loctite® Color Guard®, Tough Rubber Coating

Inhibits rust and corrosion. Seals, insulates, and identifies almost any material in minutes. Creates a non-slip gripping surface. Rubber coating won't crack or chip. Acid and alkali resistant. Dip, spray, or brush to apply. Suggested applications: tools, metal, electrical connections, masonry, wood, conveyors, glass, rope, fabric. Now in a toluene-free formulation.

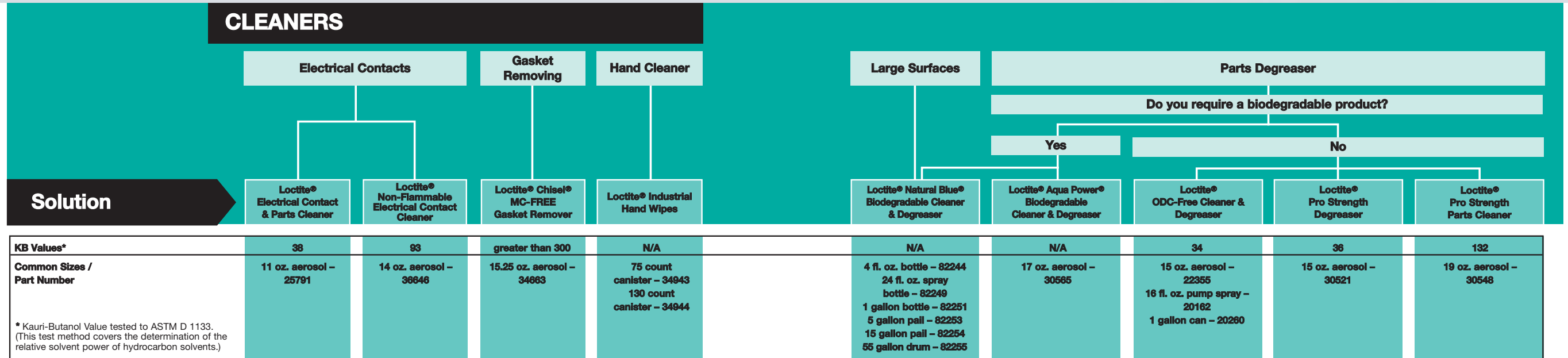


# Cleaning

- Clean and degrease work surfaces, parts, and hands



## CLEANERS



\* Kauri-Butanol Value tested to ASTM D 1133. (This test method covers the determination of the relative solvent power of hydrocarbon solvents.)

Additional Products		
Name	Part #	Pkg. Size
Loctite® Pro Strength Varnish Remover	30529	12 oz. aerosol
Loctite® Multi-Purpose Glass Cleaner	30546	18.75 oz. aerosol
Loctite® Non-Chlorinated Parts Cleaner	30545	14.75 oz. aerosol
Loctite® Chisel® Gasket Remover (Methylene Chloride)	79040	18 oz. aerosol
Loctite® Electrical Contact Cleaner	24379	15 oz. aerosol



**Loctite® Electrical Contact & Parts Cleaner**  
Fast-evaporating cleaner removes grease, oil, and other contaminants from electrical parts and mechanical equipment. Contains no CFCs or HCFCs and is safe on most plastics. Non-conductive and non-corrosive.



**Loctite® Non-Flammable Electrical Contact Cleaner**  
Removes grease, oil, and other contaminants from electrical parts to prevent contact failure. Dries residue-free in seconds. Contains no HCFCs or CFCs.



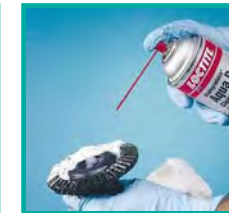
**Loctite® Chisel® MC-FREE Gasket Remover**  
Free of methylene chloride, Loctite® Chisel® MC-FREE has a foaming action that lifts off gaskets from any type of assembly in minutes. Performs better than methylene chloride formulations on silicone gaskets and removes most spray paints from steel panels in less than 30 seconds. Suitable for wood and plaster. Not for use on plastics, linoleum, or synthetic fibers.



**Loctite® Industrial Hand Wipes**  
Pre-moistened with a powerful citrus scented formula, each 9.5" x 12" wipe is abrasive enough to scrub off the toughest grease and grime without scratching hands. Quick and easy to use, no rinsing, no drying and no residue left behind. Perfect for industrial and commercial working hands in the painting, transportation, and construction industries.



**Loctite® Natural Blue® Biodegradable Cleaner & Degreaser**  
Biodegradable, all-purpose, industrial strength, concentrated cleaner and degreaser. Can be economically diluted with water. Formulated for wipe down, pressure spraying, and immersion cleaning processes at room temperature or heated. Non-flammable and non-toxic. Contains no ODCs. Available in pine scent or unscented formulas.



**Loctite® Aqua Power® Biodegradable Cleaner & Degreaser**  
Penetrates, dissolves and removes dirt and oil. Fast drying and residue-free. Environmentally friendly product is biodegradable, has low toxicity, no ODCs, and is non-corrosive/non-caustic.



**Loctite® ODC-Free Cleaner & Degreaser**  
A non-aqueous, hydrocarbon-based solvent designed for cleaning and degreasing surfaces to be bonded with adhesives, as well as for general purpose industrial cleaning. Safe on aluminum, rubber and most plastics, and will not cause flash rusting on water-sensitive parts. Dries residue-free. Contains no ozone-depleting compounds. (Formerly referenced as Loctite® 7070™.) NSF/ANSI K1.



**Loctite® Pro Strength Degreaser**  
Quickly dissolves and removes grease, oil and dirt from iron, steel, aluminum, magnesium, copper, rubber, plastic, and concrete. Rinses off with water.



**Loctite® Pro Strength Parts Cleaner**  
Aggressively penetrates, dissolves and removes oil and grease from parts. Dries quickly with no residue. Contains no ODCs.



# Machining and Lapping

- Loctite® Clover® compounds allow final finishing of metal surfaces not practical with mechanical methods alone
- Available in petroleum-based grease mix or Pat Gel® water-based carrier



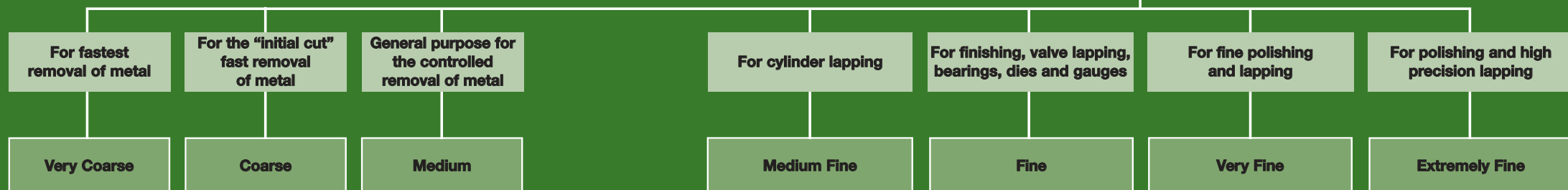
## MACHINING AND LAPPING METALS

### Helpful Hints:

- The more coarse the compound, the faster the metal removal
- The finer the compound, the smoother the finish will be

### Solution

What type of metal removal is needed?



Grade	J	G	F	E	NC	D	C	B	A	1A	2A	3A	4A	5A	6A	7A	
Grit	54	80	100	120	150	180	220	240	280	320	400	500	600	800	1,000	1,200	
Average Particle Size of Abrasive Grains	1/1000 inches	18.00	15.00	6.80	5.60	4.80	3.40	2.60	2.48	1.75	1.28	0.90	0.68	0.56	0.38	0.20	0.12
	Microns (0.001 mm)	463	267	173	142	122	86	66	63	44	33	23	17	14	9	5	3
Loctite® Clover® Silicon Carbide Grease Mix 1 lb. can Part Number*	39483	39473	39463	39452	39499	39439	39426	39413	39401	39510	39523	39536	39549	39561	39574	39587	
Loctite® Clover® Silicon Carbide Pat Gel® Water Mix 1 lb. jar Part Number	39488	39478†	39468	39457†	39504	39444	39431	39418	39406	39515	39528	39541†	39554	39566	39579	39592	

\* Also available in 25 lb. pails and 100 lb. drums.  
 † Also available in 25 lb. pails.

### Loctite® Clover® Silicon Carbide Grease Mix

The standard abrasive paste for fast metal removal. Produces a smooth, flat surface but not a polished one. Leaves a rust-preventing film on lapped surfaces.



### Loctite® Clover® Silicon Carbide Pat Gel® Water Mix

Paste formulation for fast metal removal. Biodegradable, recommended for applications where cleanup with water is required.



### Loctite® Clover® Duplex Package

Silicon carbide grease mix in two convenient grit sizes 120 and 280. Contains 2 ounces of each.

Part Number  
39598



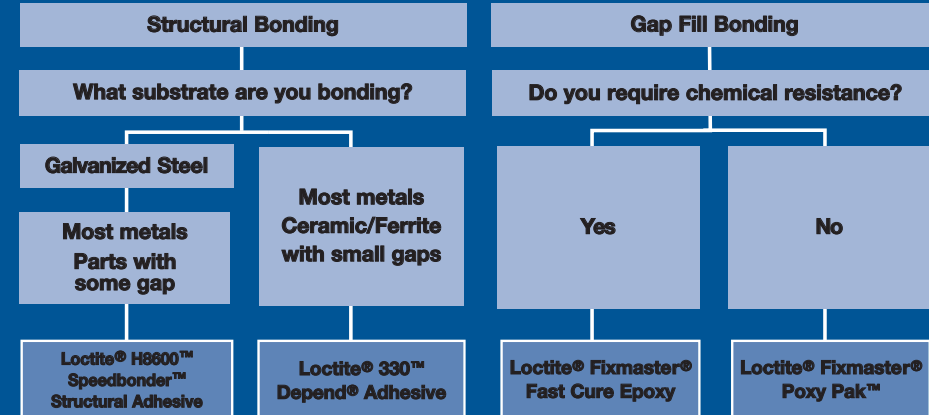
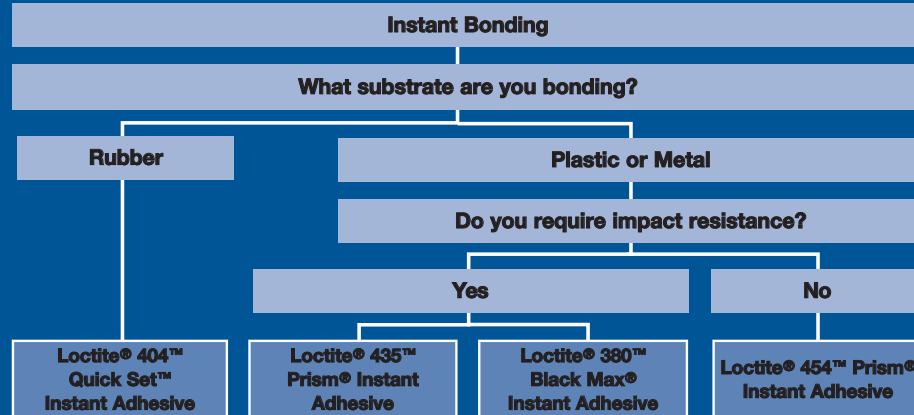


# Bonding

- Assemble parts quickly and easily
- Repair broken parts
- Bond dissimilar parts



## WHAT IS YOUR BONDING NEED?



### Solution

Color	Clear	Clear	Black	Clear
Fixture Time	20-40 seconds	30 seconds	20-120 seconds	20 seconds
Temperature Resistance	Up to 180°F (82°C)	Up to 240°F (115°C)	Up to 225°F (107°C)	Up to 180°F (82°C)
Common Sizes / Part Number	¼ oz. bottle – 46551 4 oz. bottle – 46548	3 g tube – 41005 20 g bottle – 40994	3 g tube – 38004 1 oz. bottle – 38050	3 g tube – 45404 20 g tube – 45440

Color	Blue	Amber	Grey	Clear
Fixture Time	45 min.	1-2 min.	10 min.	4-6 min.
Temperature Resistance	Up to 300°F (150°C)	Up to 250°F (121°C)	Up to 180°F (82°C)	Up to 300°F (149°C)
Common Sizes / Part Number	50 ml cartridge – 40875	25 ml syringe kit – 20251 250 ml tube kit – 20252 250 ml tube – 33058 300 ml cartridge – 33064	10 – 0.12 fl. oz. cups – 21425 10 – 1 oz. cups – 21426 4 pk – 0.12 fl. oz. cups – 39068	1 oz. syringe – 81120

### Additional Products

Name	Part #	Pkg. Size
Loctite® Black Contact Adhesive – Flexible, resists gasoline, waterproof	30540	5 fl. oz. tube
Loctite® Contact Adhesive – Flexible, withstands freezing temperatures	30537	5 fl. oz. tube
Loctite® All Purpose Spray Adhesive – Water resistant spray	30544	10.5 oz. aerosol
Loctite® Maximum Strength Headliner Adhesive – Resists extreme weather conditions	37312	16.75 oz. aerosol
Loctite® Fixmaster® 4 Minute Epoxy – Translucent, fast curing	97434	50 ml cartridge
Loctite® Fixmaster® General Purpose Epoxy, Mixing Cups – Single use, bonds porous and non-porous surfaces	21427	10-0.12 fl. oz. cups
Loctite® QuickTite® Instant Adhesive Gel	39202	0.14 oz. bottle
Loctite® Fixmaster® High Performance Epoxy – Fiberglass reinforced, shock resistant	99393 99394	1 oz. syr. 50 ml cart.



**Loctite® 404™ Quick Set™ Instant Adhesive**  
This general-purpose instant adhesive liquid is the one adhesive everyone needs in their toolbox for general maintenance and repair. It sets instantly. No clamping, no mixing, no waiting. Keep it handy to bond just about anything in an instant. Bonds rubber to rubber, i.e. making o-rings. ABS Approved.



**Loctite® 435™ Prism® Instant Adhesive**  
Loctite® 435™ Prism® Instant Adhesive has good impact resistance and a fast cure time on a wide variety of materials. This product has good chemical and humidity resistance. Excellent for rubber to metal, metal to metal and plastic to plastic bonds.



**Loctite® 380™ Black Max® Instant Adhesive**  
For parts that encounter shock, vibration or thermal cycling, Loctite® 380™ Black Max® Instant Adhesive is the instant adhesive choice. This black, toughened cyanoacrylate adhesive uses elastomers to withstand impact and challenging environmental conditions. Seals as well as bonds. Works especially well bonding rubber to metal.



**Loctite® 454™ Prism® Instant Adhesive**  
The ideal adhesive for porous substrates, Loctite® 454™ Prism® Instant Adhesive is a clear gel. As a surface insensitive cyanoacrylate, it is ideal for difficult-to-bond substrates, including rough, porous and acidic surfaces. Need to bond something on a vertical surface? This gel formulation won't run off before you put substrates together. ABS Approved.



**Loctite® H8600™ Speedbonder™ Structural Adhesive**  
Excellent for bonding galvanized steel as well as a combination of other metals and most plastics. Loctite® H8600™ Weld Eliminator™ seals against most fluids and gases and reduces the need for rivets and welding. Use to patch metal surfaces, sleeving metal conduit and ducts, and for metal fabrication.



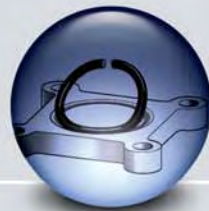
**Loctite® 330™ Depend® Adhesive**  
Loctite® 330™ Depend® Adhesive sets in just minutes to a tough acrylic adhesive with high peel and impact strength. Bonds almost all combinations of materials, including glass. No-mix kit includes activator and adhesive.



**Loctite® Fixmaster® Fast Cure Epoxy – Mixer Cups**  
Premeasured epoxy mixer cups. Bonds in 5-15 minutes. Excellent chemical resistance. Fills porosities and can be used to build up worn parts. Ideal for bonding glass, hard plastics, rubber, and metal.



**Loctite® Fixmaster® Poxy Pak™ – Fast Cure Epoxy**  
This fast-cure, high-strength, thick liquid reaches handling strength in 4-6 minutes. Bonds virtually any material to repair, fill and seal holes, cracks, and worn surfaces. ABS Approved.



# Specialty and Emergency Repair Kits



- Enable rapid repair of damaged or burst pipes
- Will seal leaks in tanks and other containment vessels in addition to repairing metal parts
- Include a kit for repairing or replacing damaged o-ring seals

## EMERGENCY REPAIR



Solution	Loctite® Quick Service Toolkit	Loctite® Toolbox	Loctite® Reliability Tacklebox	Loctite® O-Ring Making Kit	Loctite® Form-A-Thread® Stripped Thread Repair Kit	Loctite® Pipe Repair Kit
Part Number	00101	38956	39062	Standard – 00112 Metric – 40488	28654	2" x 6' tape – 96321 4" x 12' tape – 96322

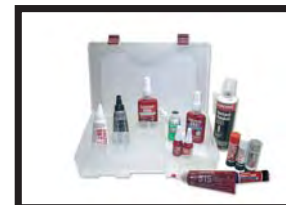
Additional Products	
Name	Part #
Loctite® Maintenance Tacklebox	33486
Loctite® Manufacturing Reliability Toolbox	31362



**Loctite® Quick Service Toolkit**  
This compact kit contains everything needed to solve the most common mechanical failures.  
Kit contains: Loctite® 242® Threadlocker – Medium Strength, 10 ml; Loctite® 262™ Threadlocker – High Strength, 10 ml; Loctite® 7649™ Primer N™, 4.5 oz.; Loctite® 454™ Prism® Instant Adhesive, 3 g; Loctite® 660™ Quick Metal® Retaining Compound, 6 ml; Loctite® 565™ Thread Sealant, 50 ml; Loctite® 587™ Blue – High Performance RTV Silicone Gasket Maker, 70 ml; Loctite® 518™ Gasket Eliminator® Flange Sealant, 50 ml.



**Loctite® Toolbox**  
A new product assortment containing more of our newer technologies and formulations.  
Box contains: Loctite® 220™ Threadlocker – Medium Strength/Wicking, 10 ml; Loctite® 222MS™ Threadlocker – Low Strength/Small Screw, 10 ml; Loctite® QuickStix™ 248™ Threadlocker – Medium Strength, 9 g; Loctite® QuickStix™ 268™ Threadlocker – High Strength, 9 g; Loctite® 2440™ Threadlocker – Primerless/Medium Strength, 10 ml; Loctite® 2760™ Threadlocker – Primerless/High Strength, 10 ml; Loctite® 518™ Gasket Eliminator® Flange Sealant, 50 ml; Loctite® 545™ Thread Sealant – Hydraulic/Pneumatic, 10 ml; Loctite® QuickStix™ 561™ PST® Pipe Sealant with PTFE, 19 g; Loctite® 565™ PST® Thread Sealant, 50 ml; Loctite® 587™ Blue – High Performance RTV Silicone, 70 ml; Loctite® 641™ Retaining Compound – Low Strength, 10 ml; Loctite® 660™ Quick Metal® Retaining Compound, 50 ml; Loctite® QuickStix™ C5-A® Copper Anti-Seize, 20 g; Loctite® 7649™ Primer N™, 1.75 oz. aerosol can.



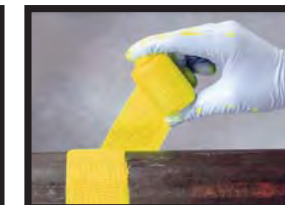
**Loctite® Reliability Tacklebox**  
Designed for the Manufacturing Reliability program.  
Box contains: Loctite® 220™ Threadlocker – Medium Strength/Wicking, 10 ml; Loctite® 222MS™ Threadlocker – Low Strength/Small Screw, 10 ml; Loctite® 243™ Threadlocker – Medium Strength/Oil Resistant, 50 ml; Loctite® QuickStix™ 248™ Threadlocker – Medium Strength, 19 g; Loctite® QuickStix™ 268™ Threadlocker – High Strength, 19 g; Loctite® 515™ Gasket Eliminator® Flange Sealant – High Temperature, 50 ml; Loctite® 567™ PST® Thread Sealant, 50 ml; Loctite® 609™ Retaining Compound, 50 ml; Loctite® 660™ Quick Metal® Retaining Compound, 50 ml; Loctite® 7649™ Primer N™, 1.75 oz. aerosol can; Loctite® Instant Gasket, 7 oz. can; Loctite® QuickStix™ Silver Grade Anti-Seize, 20 g.



**Loctite® O-Ring Making Kit**  
Eliminates the need for an inventory of different sized o-rings. Joints resist water and oil and are as strong as the rubber itself. Contains 3 ft. lengths of common diameters of Buna N cord, Loctite® 404™ Quick Set™ Instant Adhesive, o-ring fixture, blade, waterproofing solution, and cleanup solution.



**Loctite® Form-A-Thread® Stripped Thread Repair Kit**  
Permanently repairs stripped threads and fasteners in five minutes (up to SAE Grade 5 English and 8.8 metric). Allows up to 128 lb. in torque and 300°F. Resists most shop fluids.



**Loctite® Pipe Repair Kit**  
No tools required. Cures in 30 minutes. Easy-to-use repair kit. Use for temporary/medium term repair of leaking pipes, and reinforcement of weak areas. Kit contains protective gloves, Loctite® Metal Magic Steel™ Stick, and urethane-impregnated fiberglass tape.



# Accessories

- **Loctite® brand accessories are specially designed to make application and use of Loctite® brand products fast, precise, clean, and economical**



# Product Ordering Information



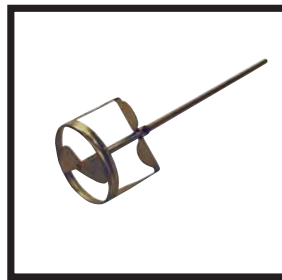
### Loctite® Bottle Hand Pump

This hand held applicator is a low-cost, precision bottle top applicator that mounts easily on the top of any Loctite® brand 50ml or 250 ml bottle.  
**Part # 97001**



### Loctite® Phenolic Roller and Loctite® Bristle Roller

These rollers are recommended for applying the Loctite® Big Foot™ range of flooring compounds. The Loctite® Phenolic Roller gives a rough surface and the Loctite® Bristle Roller is used for applying primers and sealers.  
**Phenolic Roller: 96121**  
**Bristle Roller: 96153**



### Loctite® Mixer Blades

For use with all 1 gallon kits of Loctite® Big Foot™ flooring compounds.  
**Part # 96131**



### Loctite® Manual Applicator

Two-component epoxies are dispensed through hand held, manually operated, meter mix dispensers. These dispensers provide a convenient, cost-effective method to apply product with minimal waste.  
**Part # 983531**



### Loctite® Fixmaster® Rapid Rubber Repair Dispenser

Easy-to-use applicator for the Loctite® Fixmaster® Rapid Rubber Repair Kit.  
**Part # 39635**



### Loctite® Fixmaster® Rapid Rubber Repair Static Mixers

These mixing nozzles are for use with Loctite® Fixmaster® Rapid Rubber Repair Urethane in the 400 ml cartridge. Packaged in bags of 6.  
**Part # 39633**



### Loctite® Industrial Manual Grease Dispenser

These grease guns have a 6" rigid extension, lever action, vinyl handle grip, vent valve for purging, two way filling (bulk or cartridge), variable stroke that yields variable pressure and volume with a precision fit and hardened coupler. Good for all grease type lubricants including Loctite® ViperLube® Synthetic Lubricants.  
**Part # 98431**



### Loctite® Caulking Gun Conversion Kit

Provides an inexpensive means of converting a household caulking gun into a hand held meter mix dispenser for 1:1 and 2:1 Loctite® 50 ml dual cartridge products. (shown here using Loctite® Foldable Caulking Gun, PN 98500). Includes cartridge sleeve, a 1:1 ratio plunger, a 2:1 ratio plunger, and two 50 ml mix nozzles.  
**Part # 98466**

### Loctite® Foldable Caulking Gun

A hand held, manually operated dispenser designed for all products packaged in a 300 ml cartridge. Innovative folding trigger assembly allows it to be stored in less space or carried more conveniently than conventional household models.  
**Part # 98500**

- **Search by Loctite® Part Number on these pages.**

Part Number	Product Name	Pkg.-Size	Page	Part Number	Product Name	Pkg.-Size	Page
00101	Loctite® Quick Service Toolkit	N/A	36	30511	Loctite® Gasket Sealant 1	3 oz.	6
00112	Loctite® O-Ring Making Kit – Standard	N/A	37	30512	Loctite® Gasket Sealant 1	7 fl. oz.	6
18581	Loctite® 5699™ RTV Grey, Silicone Gasket Maker	300 ml	6	30513	Loctite® Gasket Sealant 2	1.5 oz.	6
18718	Loctite® 5699™ RTV Grey, Silicone Gasket Maker	70 ml	6	30514	Loctite® Gasket Sealant 2	7 oz.	6
20162	Loctite® ODC-Free Cleaner & Degreaser	16 fl. oz.	2, 4, 6, 8, 12, 31	30515	Loctite® Gasket Sealant 2	3 fl. oz.	6
20251	Loctite® 330™ Depend® Adhesive	25 ml kit	35	30516	Loctite® Aviation Gasket Sealant	1 pt.	6
20252	Loctite® 330™ Depend® Adhesive	250 ml kit	35	30517	Loctite® Aviation Gasket Sealant	0.25 pt.	6
20260	Loctite® ODC-Free Cleaner & Degreaser	1 gal.	2, 4, 6, 8, 12, 31	30518	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	12 oz.	6
20279	Loctite® Natural Blue® Biodegradable Cleaner & Degreaser, Fragrance-Free	55 gal.	31	30521	Loctite® Pro Strength Degreaser	15 oz. aerosol	31
21347	Loctite® 7649™ Primer N™ (Acetone)	25 g	2, 4, 8	30522	Loctite® Hydraulic Jack Oil	1 qt.	24
21348	Loctite® 7649™ Primer N™ (Acetone)	4.5 oz.	2, 4, 8	30523	Loctite® Hydraulic Jack Oil	1 gal.	24
21425	Loctite® Fixmaster® Fast Cure Epoxy, Mixer Cups	10 - 0.12 fl. oz. cups	35	30524	Loctite® Hi-Tack Gasket Sealant	0.25 pt.	6
21426	Loctite® Fixmaster® Fast Cure Epoxy, Mixer Cups	10 - 1 oz. cups	35	30525	Loctite® Hi-Tack Gasket Sealant	1 pt.	6
21427	Loctite® Fixmaster® General Purpose Epoxy, Mixer Cups	10 - 0.12 fl. oz. cups	35	30526	Loctite® Hi-Tack Gasket Sealant	9 oz. aerosol	6
21434	Loctite® 277™ Threadlocker – High Strength/Large Threads	10 ml	2	30527	Loctite® Belt Dressing & Conditioner	12 oz. aerosol	28
21440	Loctite® 603™ Retaining Compound – Press Fit/Oil Tolerant	10 ml	9	30529	Loctite® Pro Strength Varnish Remover	12 oz. aerosol	30
21441	Loctite® 603™ Retaining Compound – Press Fit/Oil Tolerant	50 ml	9	30530	Loctite® White Lithium Grease	1.5 oz.	24
21442	Loctite® 603™ Retaining Compound – Press Fit/Oil Tolerant	250 ml	9	30533	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	300 ml	6
21458	Loctite® 641™ Retaining Compound	50 ml	8	30534	Loctite® Thread Sealant with PTFE	0.25 pt.	4
22041	Loctite® 220™ Threadlocker – Medium Strength/Wicking	250 ml	2	30535	Loctite® Copper Gasket Adhesive	9 oz.	6
22221	Loctite® 222MS™ Threadlocker – Low Strength/Small Screw	10 ml	3	30536	Loctite® Dielectric Grease	0.33 oz.	24
22231	Loctite® 222MS™ Threadlocker – Low Strength/Small Screw	50 ml	3	30537	Loctite® Contact Adhesive	5 fl. oz.	35
22241	Loctite® 222MS™ Threadlocker – Low Strength/Small Screw	250 ml	3	30538	Loctite® Heavy Duty Rubberized Undercoating	16 oz. aerosol	29
22355	Loctite® ODC-Free Cleaner & Degreaser	15 oz. aerosol	2, 4, 6, 8, 12, 31	30539	Loctite® Extend® Rust Treatment	10.5 oz. aerosol	28
23811	Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	1 gal.	31	30540	Loctite® Black Contact Adhesive	5 fl. oz.	35
24018	Loctite® 574™ Flange Sealant – Fast Cure	50 ml	6	30542	Loctite® 5920™ RTV Copper, Silicone Gasket Maker	70 ml	6
24077	Loctite® 243™ Threadlocker – Medium Strength/Oil Resistant	10 ml	2	30543	Loctite® White Lithium Grease	10.75 oz. aerosol	24
24078	Loctite® 243™ Threadlocker – Medium Strength/Oil Resistant	50 ml	2	30544	Loctite® All-Purpose Spray Adhesive	10.5 oz. aerosol	35
24079	Loctite® 243™ Threadlocker – Medium Strength/Oil Resistant	250 ml	2	30545	Loctite® Non-Chlorinated Parts Cleaner	14.75 oz. aerosol	30
24221	Loctite® 242® Threadlocker – Medium Strength/Removable	10 ml	2	30546	Loctite® Multi-Purpose Glass Cleaner	18.75 oz. aerosol	30
24231	Loctite® 242® Threadlocker – Medium Strength/Removable	50 ml	2	30548	Loctite® Pro Strength Parts Cleaner	19 oz. aerosol	31
24241	Loctite® 242® Threadlocker – Medium Strength/Removable	250 ml	2	30556	Loctite® Pipe Joint Compound	0.25 pt.	4
24379	Loctite® Electrical Contact Cleaner	15 oz. aerosol	30	30557	Loctite® Pipe Joint Compound	1 pt.	4
25791	Loctite® Electrical Contact & Parts Cleaner	11 oz. aerosol	30	30560	Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	80 ml	6
25882	Loctite® 554™ Thread Sealant	10 ml	4	30561	Loctite® Thread Sealant with PTFE	1 pt.	4
26221	Loctite® 262™ Threadlocker – High Strength/Permanent	10 ml	2	30565	Loctite® Aqua Power® Biodegradable Cleaner & Degreaser	17 oz. aerosol	31
26231	Loctite® 262™ Threadlocker – High Strength/Permanent	50 ml	2	31360	Krytox® RFE PFPE Lubricant	16 lb.	25
26241	Loctite® 262™ Threadlocker – High Strength/Permanent	250 ml	2	31361	Krytox® RFE PFPE Lubricant	16 oz.	25
26338	Loctite® 574™ Flange Sealant – Fast Cure	250 ml	6	31362	Loctite® Manufacturing Reliability Toolbox	N/A	36
27240	Loctite® 272™ Threadlocker – High Strength/High Temp	50 ml	2	32429	Loctite® 545™ Thread Sealant – Hydraulic/Pneumatic	10 ml	5
27270	Loctite® 272™ Threadlocker – High Strength/High Temp	250 ml	2	32525	Loctite® 2760™ Threadlocker – Primerless/High Strength	50 ml	3
27731	Loctite® 277™ Threadlocker – High Strength/Large Threads	50 ml	2	32526	Loctite® 2760™ Threadlocker – Primerless/High Strength	10 ml	3
27741	Loctite® 277™ Threadlocker – High Strength/Large Threads	250 ml	2	32527	Loctite® 2760™ Threadlocker – Primerless/High Strength	250 ml	3
28654	Loctite® Form-A-Thread® Stripped Thread Repair Kit	12.9 ml	37	33058	Loctite® 330™ Depend® Adhesive	250 ml	35
28753	Loctite® 564™ Thread Sealant – Low Strength	6 ml	4	33064	Loctite® 330™ Depend® Adhesive	300 ml	35
28754	Loctite® 564™ Thread Sealant – Low Strength	50 ml	4	33241	Loctite® 567™ PST® Thread Sealant with PTFE	16 oz.	5
28755	Loctite® 564™ Thread Sealant – Low Strength	250 ml	4	33486	Loctite® Maintenance Tackle Box	N/A	36
28802	Loctite® 641™ Retaining Compound	10 ml	8	33510	Loctite® Fixmaster® Super Grout	5 gal. kit	17
29021	Loctite® 290™ Threadlocker – Wicking Grade	10 ml	2	33946	Loctite® 2440™ Threadlocker – Primerless/Medium Strength	10 ml	3
29031	Loctite® 290™ Threadlocker – Wicking Grade	50 ml	2	33947	Loctite® 2440™ Threadlocker – Primerless/Medium Strength	50 ml	3
29041	Loctite® 290™ Threadlocker – Wicking Grade	250 ml	2	33948	Loctite® 2440™ Threadlocker – Primerless/Medium Strength	250 ml	3
29709	Krytox® RFE PFPE High Performance Lubricant	16 oz.	25	34018	Loctite® 598™ RTV Black, Silicone Gasket Maker	0.5 oz.	6
29710	Krytox® RFE PFPE Lubricant	2 oz.	25	34026	Loctite® Marine Grade Anti-Seize	1 lb.	27
29711	Krytox® RFE PFPE High Performance Lubricant	2 oz.	25	34395	Loctite® Marine Grade Anti-Seize	8 oz.	27
30138	Krytox® RFE Advanced PTFE Dry Lubricant	8 oz. aerosol	24	34517	Loctite® White High-Temp Anti-Seize	8 oz.	26
30287	Loctite® 660™ Quick Metal® Retaining Compound – Press Fit Repair	250 ml	8	34518	Loctite® White High-Temp Anti-Seize	1 lb.	26
30510	Loctite® Gasket Sealant 1	1.5 oz.	6				











# Product Ordering Information

Product Name	Part Number	Pkg.-Size	Page
Loctite® Nordbak® Wear Resistant Putty	98742	1 lb. kit	13
Loctite® Nordbak® Wear Resistant Putty	98743	2 lb. kit	13
Loctite® Fixmaster® Wet Surface Repair Putty	96583	1 lb. kit	10
Loctite® Foldable Caulking gun	98500	N/A	38
Loctite® Food Grade Anti-Seize	51168	8 oz.	27
Loctite® Food Grade Anti-Seize	51170	2 lb.	27
Loctite® Food Grade Anti-Seize	51171	40 lb.	27
Loctite® Food Grade Grease	51252	14.5 oz. aerosol	24
Loctite® Form-A-Thread® Stripped Thread Repair Kit	28654	12.9 ml	37
Loctite® Freeze & Release	996456	13.52 fl. oz. aerosol	25
Loctite® Gasket Sealant 1	30510	1.5 oz.	6
Loctite® Gasket Sealant 1	30511	3 oz.	6
Loctite® Gasket Sealant 1	30512	7 fl. oz.	6
Loctite® Gasket Sealant 2	30513	1.5 oz.	6
Loctite® Gasket Sealant 2	30514	3 oz.	6
Loctite® Gasket Sealant 2	30515	7 fl. oz.	6
Loctite® Gasket Sealant 2	80964	5 gal.	6
Loctite® Gear, Chain and Cable Lubricant	81251	12 oz. aerosol	24
Loctite® Graphite-50™ Anti-Seize	51084	1 lb.	26
Loctite® H.V.A.C. Blue Pipe Joint Compound	82480	0.25 pt.	4
Loctite® H.V.A.C. Blue Pipe Joint Compound	82481	1 pt.	4
Loctite® H8600™ Weld Eliminator™ Structural Adhesive	40875	50 ml	35
Loctite® Heavy Duty Anti-Seize	36354	8 lb.	27
Loctite® Heavy Duty Anti-Seize	51605	9 oz.	27
Loctite® Heavy Duty Anti-Seize	51606	1.2 lb.	27
Loctite® Heavy Duty Anti-Seize	51607	2.3 lb.	27
Loctite® Heavy Duty Anti-Seize	51608	45 lb.	27
Loctite® Heavy Duty Anti-Seize	51609	1 oz.	27
Loctite® Heavy Duty Rubberized Undercoating	30538	16 oz. aerosol	29
Loctite® High Performance N-5000™ High Purity Anti-Seize	51572	1 lb.	26
Loctite® Hi-Tack Gasket Sealant	30524	0.25 pt.	6
Loctite® Hi-Tack Gasket Sealant	30525	1 pt.	6
Loctite® Hi-Tack Gasket Sealant	30526	9 oz. aerosol	6
Loctite® Hydraulic Jack Oil	30522	1 qt.	24
Loctite® Hydraulic Jack Oil	30523	1 gal.	24
Loctite® Industrial Hand Wipes	34943	75 count	30
Loctite® Industrial Hand Wipes	34944	130 count	30
Loctite® Industrial Manual Grease Dispenser	98431	N/A	25, 38
Loctite® Industrial Strength Paint Stripper	81716	18 oz. aerosol	30
Loctite® Instant Gasket	40478	90 ml aerosol	7
Loctite® Instant Gasket	40479	190 ml aerosol	7
Loctite® Maintain® Lubricant Penetrant	81204	16 oz. aerosol	24
Loctite® Maintenance Tackle Box	33486	N/A	36
Loctite® Manual Applicator	983531	N/A	38
Loctite® Manufacturing Reliability Toolbox	31362	N/A	36
Loctite® Marine Grade Anti-Seize	34026	1 lb.	27
Loctite® Marine Grade Anti-Seize	34395	8 oz.	27
Loctite® Maxi-Coat™	51211	12 oz. aerosol	29
Loctite® Maxi-Coat™	51213	1 gal.	29
Loctite® Maximum Strength Headliner Adhesive	37312	16.75 oz.	35
Loctite® Mixer Blades	96131	1 pc.	20, 38
Loctite® Moly Dry Film Lubricant	39895	12 oz. aerosol	24
Loctite® Moly Dry Film Lubricant	39896	1.3 lb.	24
Loctite® Moly Dry Film Lubricant	39897	10 lb.	24
Loctite® Moly Paste	51048	8 oz.	26
Loctite® Moly Paste	51049	1 lb.	26
Loctite® Moly Paste	51050	12 oz. aerosol	26

Product Name	Part Number	Pkg.-Size	Page
Loctite® Moly Paste	51145	15 lb.	26
Loctite® Moly-50™ Anti-Seize	51094	1 lb.	26
Loctite® Multi-Purpose Glass Cleaner	30546	18.75 oz. aerosol	30
Loctite® N-1000™ High Purity Anti-Seize	51115	8 oz.	26
Loctite® N-1000™ High Purity Anti-Seize	51116	1 lb.	26
Loctite® N-1000™ High Purity Anti-Seize	51117	2 lb.	26
Loctite® N-5000™ High Purity Anti-Seize	51243	8 oz.	26
Loctite® N-5000™ High Purity Anti-Seize	51245	8 lb.	26
Loctite® N-5000™ High Purity Anti-Seize	51246	2 lb.	26
Loctite® N-5000™ High Purity Anti-Seize	51269	1 lb.	26
Loctite® N-5000™ High Purity Anti-Seize	51346	1 oz.	26
Loctite® N-7000™ High Purity Anti-Seize	51270	1 lb.	26
Loctite® N-7000™ High Purity Anti-Seize	51272	8 oz.	26
Loctite® N-7000™ High Purity Anti-Seize	51273	2 lb.	26
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	23811	1 gal.	31
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	82244	4 fl. oz.	31
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	82249	24 fl. oz.	31
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	82251	1 gal.	31
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	82253	5 gal.	31
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	82254	15 gal.	31
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser	82255	55 gal.	31
Loctite® Natural Blue® Biodegradable Cleaner & Degreaser, Fragrance-Free	20279	55 gal.	31
Loctite® Nickel Anti-Seize	51102	1 lb.	26
Loctite® Nickel Anti-Seize	51152	8 lb.	26
Loctite® Nickel Anti-Seize	51286	12 oz. aerosol	26
Loctite® Nickel Anti-Seize	77124	8 oz.	26
Loctite® Nickel Anti-Seize	77164	1 lb.	26
Loctite® Nickel Anti-Seize	77175	5 gal.	26
Loctite® No More Leaks™, White Threaded Plastic Pipe Sealant	80724	7 fl. oz.	4
Loctite® No More Leaks™, White Threaded Plastic Pipe Sealant	80725	2 fl. oz.	4
Loctite® No More Leaks™, White Threaded Plastic Pipe Sealant	80726	1 pt.	4
Loctite® Non-Chlorinated Parts Cleaner	30545	14.75 oz. aerosol	30
Loctite® Non-Flammable Electrical Contact Cleaner	36646	14 oz. aerosol	30
Loctite® Nordbak® Brushable Ceramic – Grey	98732	6 lb. kit	13
Loctite® Nordbak® Brushable Ceramic – Grey	98733	2 lb. kit	13
Loctite® Nordbak® Brushable Ceramic – Thin Mil – Black	40590	2 lb. kit	12
Loctite® Nordbak® Brushable Ceramic – Thin Mil – Blue	40591	2 lb. kit	12
Loctite® Nordbak® Brushable Ceramic – Thin Mil – Grey	40592	2 lb. kit	12
Loctite® Nordbak® Brushable Ceramic – White	96443	2 lb. kit	13
Loctite® Nordbak® Castable Wearing Compound	98992	25 lb. kit	12
Loctite® Nordbak® Ceramic Tile Adhesive	97762	20 lb. kit	12
Loctite® Nordbak® Chemical Resistant Coating	96092	12 lb. kit	12, 15, 28
Loctite® Nordbak® Combo Bead Wearing Compound	96303	6 lb. kit	12
Loctite® Nordbak® Fast Cure Pneu-Wear	96363	6 lb. kit	12
Loctite® Nordbak® Fast Cure Wearing Compound	96373	6 lb. kit	12
Loctite® Nordbak® High Impact Wearing Compound	39918	25 lb. kit	13
Loctite® Nordbak® High Temperature Brushable Ceramic	96433	2 lb. kit	12
Loctite® Nordbak® High Temperature Pneu-Wear	98372	25 lb. kit	12
Loctite® Nordbak® High Temperature Wearing Compound	99112	25 lb. kit	12
Loctite® Nordbak® Low Odor Wearing Compound	41343	25 lb. kit	12
Loctite® Nordbak® Pneu-Wear	98382	25 lb. kit	13
Loctite® Nordbak® Pneu-Wear	98383	3 lb. kit	13
Loctite® Nordbak® Ultra High Temperature Pneu-Wear	96332	25 lb. kit	12
Loctite® Nordbak® Ultra High Temperature Wearing Compound	96392	25 lb. kit	12
Loctite® Nordbak® Wearing Compound	99812	25 lb. kit	12
Loctite® Nordbak® Wearing Compound	99813	5 lb. kit	12
Loctite® ODC-Free Cleaner & Degreaser	20162	16 fl. oz.	2, 4, 6, 8, 12, 31

Product Name	Part Number	Pkg.-Size	Page
Loctite® ODC-Free Cleaner & Degreaser	20260	1 gal.	2, 4, 6, 8, 12, 31
Loctite® ODC-Free Cleaner & Degreaser	22355	15 oz. aerosol	2, 4, 6, 8, 12, 31
Loctite® O-Ring Making Kit – Metric	40488	N/A	37
Loctite® O-Ring Making Kit – Standard	00112	N/A	37
Loctite® Penetrating Oil	51221	12 oz. aerosol	24
Loctite® Penetrating Oil	80032	1 pt.	24
Loctite® Pipe Joint Compound	30556	0.25 pt.	4
Loctite® Pipe Joint Compound	30557	1 pt.	4
Loctite® Pipe Repair Kit	96321	2" x 6" tape	37
Loctite® Pipe Repair Kit	96322	4" x 12" tape	37
Loctite® Primer for Color Guard®	34994	1 gal.	28
Loctite® Pro Strength Degreaser	30521	15 oz. aerosol	31
Loctite® Pro Strength Parts Cleaner	30548	19 oz. aerosol	31
Loctite® Pro Strength Varnish Remover	30529	12 oz. aerosol	30
Loctite® Quick Service Toolkit	00101	N/A	36
Loctite® QuickStix™ 248™ Threadlocker – Medium Strength	37087	19 g	3
Loctite® QuickStix™ 248™ Threadlocker – Medium Strength	37684	9 g	3
Loctite® QuickStix™ 268™ Threadlocker – High Strength	37685	9 g	3
Loctite® QuickStix™ 268™ Threadlocker – High Strength	37686	19 g	3
Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	39155	9 g	6
Loctite® QuickStix™ 534™ Hi-Tack Gasket Dressing	39156	19 g	6
Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant	39157	38 g	6
Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant	39151	9 g	7
Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant	39152	18 g	7
Loctite® QuickStix™ 548™ Gasket Eliminator® Flange Sealant	39153	37 g	7
Loctite® QuickStix™ 561™ PST® Thread Sealant	37127	19 g	5
Loctite® QuickStix™ 668™ Retaining Compound	39147	9 g	9
Loctite® QuickStix™ 668™ Retaining Compound	39148	19 g	9
Loctite® QuickStix™ 668™ Retaining Compound	39149	38 g	9
Loctite® QuickStix™ 7088™ Primer	1069258	17 g stick	2, 4, 8
Loctite® QuickStix™ C5-A® Copper Anti-Seize	37229	20 g	26
Loctite® QuickStix™ Heavy Duty Anti-Seize	41205	20 g	27
Loctite® QuickStix™ Silver Grade Anti-Seize	37230	20 g	26
Loctite® QuickTite® Instant Adhesive Gel	39202	0.14 oz.	35
Loctite® Reliability Tacklebox	39062	N/A	36
Loctite® Silicone Lubricant	51360	5.3 oz.	24
Loctite® Silicone Lubricant	81246	13 oz. aerosol	24
Loctite® Silver Grade Anti-Seize	76732	8 oz.	26
Loctite® Silver Grade Anti-Seize	76759	12 oz. aerosol	26
Loctite® Silver Grade Anti-Seize	76764	1 lb.	26
Loctite® Silver Grade Anti-Seize	76775	5 gal.	26
Loctite® Silver Grade Anti-Seize	80206	1 gal.	26
Loctite® Silver Grade Anti-Seize	80209	4 oz.	26
Loctite® Solvo-Rust® Super Penetrating Oil	81252	12.25 oz. aerosol	24
Loctite® Superflex® Black RTV, Silicone Adhesive Sealant	40464	190 ml aerosol	6
Loctite® Superflex® Black RTV, Silicone Adhesive Sealant	59330	80 ml	6
Loctite® Superflex® Black RTV, Silicone Adhesive Sealant	59375	300 ml	6
Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	30518	12 oz.	6
Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	30533	300 ml	6
Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	30560	80 ml	6
Loctite® Superflex® Blue RTV, Silicone Adhesive Sealant	40482	190 ml aerosol	6
Loctite® Superflex® Clear RTV, Silicone Adhesive Sealant	40481	190 ml aerosol	6
Loctite® Superflex® Clear RTV, Silicone Adhesive Sealant	59530	80 ml	6
Loctite® Superflex® Clear RTV, Silicone Adhesive Sealant	59575	300 ml	6
Loctite® Superflex® Non-Corrosive RTV, Silicone Adhesive Sealant	51387	80 ml	6
Loctite® Superflex® Non-Corrosive RTV, Silicone Adhesive Sealant	51388	300 ml	6
Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant	40465	190 ml aerosol	6

Product Name	Part Number	Pkg.-Size	Page
Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant	59630	80 ml	6
Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant	59675	300 ml	6
Loctite® Superflex® Red High Temp RTV, Silicone Adhesive Sealant	82279	12 oz.	6
Loctite® Superflex® White RTV, Silicone Adhesive Sealant	40466	190 ml aerosol	6
Loctite® Superflex® White RTV, Silicone Adhesive Sealant	59430	80 ml	6
Loctite® Superflex® White RTV, Silicone Adhesive Sealant	59475	300 ml	6
Loctite® Thinner for Color Guard®	34995	1 gal.	28
Loctite® Thread Sealant with PTFE	30534	0.25 pt.	4
Loctite® Thread Sealant with PTFE	30561	1 pt.	4
Loctite® Toolbox	38956	N/A	36
Loctite® Urethane Sealant – Black	36132	10.2 oz.	14
Loctite® Urethane Sealant – Grey	39916	10.2 oz.	14
Loctite® ViperLube® Clear High Performance Synthetic Grease	39341	3 oz.	25
Loctite® ViperLube® Clear High Performance Synthetic Grease	39342	400 g	25
Loctite® ViperLube® Clear High Performance Synthetic Grease	39363	120 lb.	25
Loctite® ViperLube® Clear High Performance Synthetic Grease	39364	30 lb.	25
Loctite® ViperLube® Clear High Performance Synthetic Grease	36780	1 cc	25
Loctite® ViperLube® High Performance Synthetic Grease	36781	3 oz.	25
Loctite® ViperLube® High Performance Synthetic Grease	36782	14 oz.	25
Loctite® ViperLube® High Performance Synthetic Grease	36783	400 g	25
Loctite® ViperLube® High Performance Synthetic Grease	36784	0.42 oz.	25
Loctite® ViperLube® High Performance Synthetic Grease	36786	10.1 oz. aerosol	24
Loctite® ViperLube® High Performance Synthetic Grease	37061	30 lb.	25
Loctite® ViperLube® High Performance Synthetic Grease	37710	120 lb.	25
Loctite® White High-Temp Anti-Seize	34517	8 oz.	26
Loctite® White High-Temp Anti-Seize	34518	1 lb.	26
Loctite® White Lithium Grease	30530	1.5 oz.	24
Loctite® White Lithium Grease	30543	10.75 oz. aerosol	24
Loctite® Zinc Anti-Seize	39901	1 lb.	27







Name: \_\_\_\_\_

Area: \_\_\_\_\_

### Reliability Improvement Suggestion

1. Problem Equipment \_\_\_\_\_ Department or Area \_\_\_\_\_

Describe problem including failing components: \_\_\_\_\_

How often does this happen? \_\_\_\_\_ Times per month \_\_\_\_\_ Times per year

Describe negative impact: \_\_\_\_\_

Describe your intended actions including products to be used: \_\_\_\_\_

Necessary products issued?  Yes  No      Need Loctite rep help?  Yes  No

2. Problem Equipment \_\_\_\_\_ Department or Area \_\_\_\_\_

Describe problem including failing components: \_\_\_\_\_

How often does this happen? \_\_\_\_\_ Times per month \_\_\_\_\_ Times per year

Describe negative impact: \_\_\_\_\_

Describe your intended actions including products to be used: \_\_\_\_\_

Necessary products issued?  Yes  No      Need Loctite rep help?  Yes  No

### Additional Training Needed

**Topics (Check appropriate boxes)**

**Comments**

- Mechanical Basics & Failure Root Causes
- Rebuild/Resurface Shafts     Wear Prevention
- Machine Base Grouting
- Belt Jointing & Repair
- Floor Repair & Resurface
- Anti-Slip Safety Flooring
- Corrosion Protection (tanks, decking, etc.)

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

### Training Critique

**Check appropriate boxes**

**Great**

**O.K.**

**Poor**

- I learned useful information and proactive techniques for my job  Great  O.K.  Poor
- The instructor was well informed and his style made it easy to learn  Great  O.K.  Poor
- The examples helped me to understand where I can help increase reliability  Great  O.K.  Poor
- The demos and visual aids were used effectively and helped me learn  Great  O.K.  Poor
- The reference handouts are on target and will be helpful reminders  Great  O.K.  Poor
- Length of class       Too Long       Just Right       Too Short
- Pace of class       Too Fast       Just Right       Too Slow

Comments: \_\_\_\_\_

\_\_\_\_\_

**Henkel Corporation, Engineering Adhesives**

1001 Trout Brook Crossing, Rocky Hill, CT, 06067 • [www.henkelna.com/mro](http://www.henkelna.com/mro) • [www.loctite.com](http://www.loctite.com)

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# “Do it Right” User’s Guide

The “WHEN, WHERE & HOW” to use  
Loctite® Maintenance Products



The primary function of this User's Guide is to help you, the maintenance professional, with the proper selection and use of Loctite® products. A wide variety of preventative maintenance, as well as repair techniques, are explained in step-by-step detail. Consider this a supplemental service manual for every piece of equipment in your plant. Our goal is to make it easier for you to use our products, to your benefit, for faster repair times, reduced downtime, and extended equipment life. Additional information on these products, as well as others, is available by contacting your local Henkel adhesives and sealants representative at the telephone number listed on the back cover of this guide.

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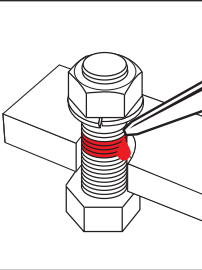
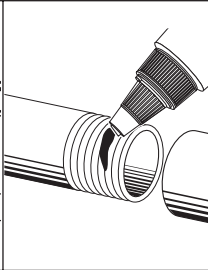
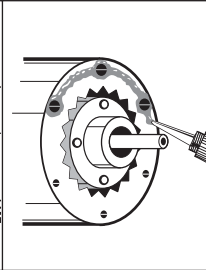
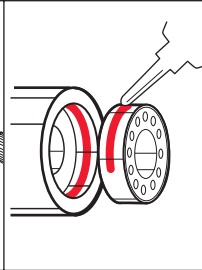
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# INTRODUCTION

## INTRODUCTION TO ANAEROBIC ADHESIVES AND SEALANTS

Anaerobic adhesives and sealants were developed by the founder of Loctite Corporation, now Henkel Corporation, in 1953 and, since then, they have significantly evolved to meet the highest requirements of equipment manufacturers, maintenance and overhaul.

Anaerobic adhesives and sealants are resins that convert from liquid to a tough structural solid in the absence of air and the presence of metal. The primary functions of anaerobic resins are:

Threadlocking	Thread Sealing	Gasketing	Retaining
			

Each one of these functions is based upon control of five major variables: strength, viscosity, adhesion, flexibility, and temperature resistance. These five parameters give anaerobics users considerable latitude in adjusting properties for optimum performance in specific application areas.

Another variable that should be considered is the substrate in which the adhesive will be applied. For certain substrates or other special requirements, the use of primer is recommended.

## WHY USE A PRIMER?

1. Primers activate inactive surfaces.
2. Primers speed cure times for faster return to service.
3. Primers speed curing through larger gaps and deep threads.
4. Primers substantially speed cure times on cold parts.
5. Primers act as cleaning agents.

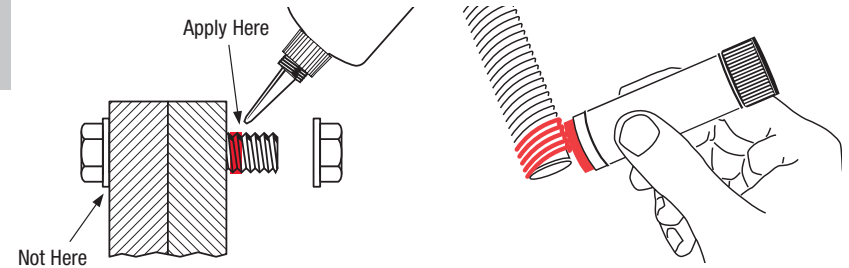
**Active surfaces (Primer optional):** Brass, copper, bronze, iron, soft steel, nickel.

**Inactive surfaces (Primer required):** Aluminum, stainless steel, magnesium, zinc, black oxide, cadmium, titanium, others.

# THREADLOCKING

## THRU HOLES (BOLTS AND NUTS)

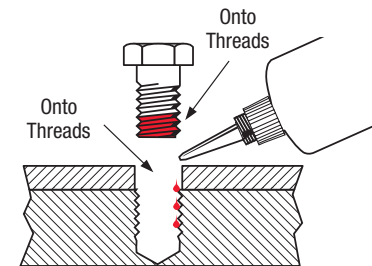
### LIQUID AND SEMI-SOLIDS



1. Clean all threads (bolt and nut) with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray all threads with Loctite® 7649™ Primer N™. Allow to dry.
3. Select the proper strength Loctite® threadlocker.
4. Insert bolt into thru hole assembly.
5. Apply several drops of liquid threadlocker onto bolt at targeted tightened nut engagement area or, when using the stick product, completely fill the root of the threads at the area of engagement.
6. Assemble and tighten nut as usual.

## BLIND HOLES (CAP SCREWS, ETC.)

### LIQUID ONLY



1. Clean all threads (bolt and hole) with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray (bolt and hole) with Loctite® 7649™ Primer N™. Allow 30 seconds to dry.
3. Select the proper strength Loctite® threadlocker.
4. Squirt several drops down the sides of the female threads.
5. Apply several drops to bolt.
6. Tighten as usual.

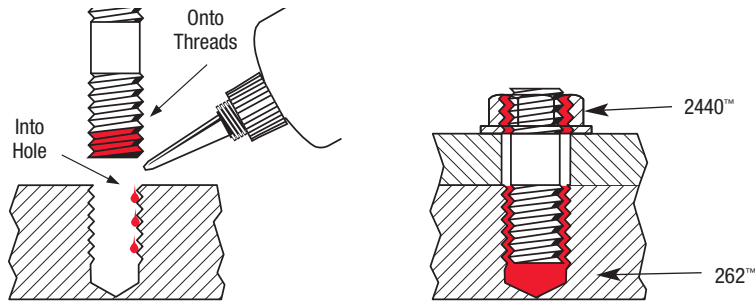
**Note:** Using Loctite® threadlockers will virtually eliminate stripped threads, in aluminum or magnesium housings, caused by galvanic corrosion.



# THREADLOCKING

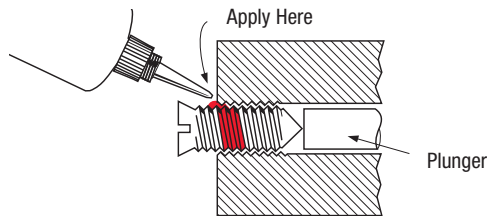
## BLIND HOLES (STUDS, ETC.)

### LIQUID ONLY



1. Clean all threads (bolt and hole) with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray all threads with Loctite® 7649™ Primer N™. Allow to dry.
3. Squirt several drops of Loctite® 2670™ Threadlocker down the sides of the female threads.  
**Note:** Use Loctite® 277™ Threadlocker if stud is over 1" diameter.
4. Apply several drops of Loctite® 2670™ Threadlocker onto stud threads.
5. Install studs.
6. Position cover, head, etc.
7. Apply drops of Loctite® 2440™ Threadlocker onto exposed threads.
8. Tighten nuts as required.

## ADJUSTMENT SCREWS

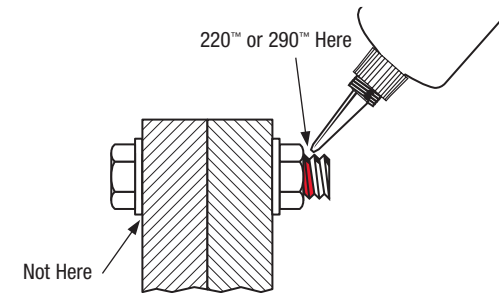


1. Adjust screw to proper setting.
2. Apply several drops of Loctite® 220™ or 290™ Threadlocker at screw and body juncture.
3. Avoid touching bottle tip to metal.  
**Note:**
  - If re-adjustment is difficult, apply heat to screw with soldering gun (450°F).
  - Loctite® 220™ Threadlocker is a weaker version of Loctite® 290™ Threadlocker.

# THREADLOCKING

## PRE-ASSEMBLED FASTENERS

### LIQUID ONLY



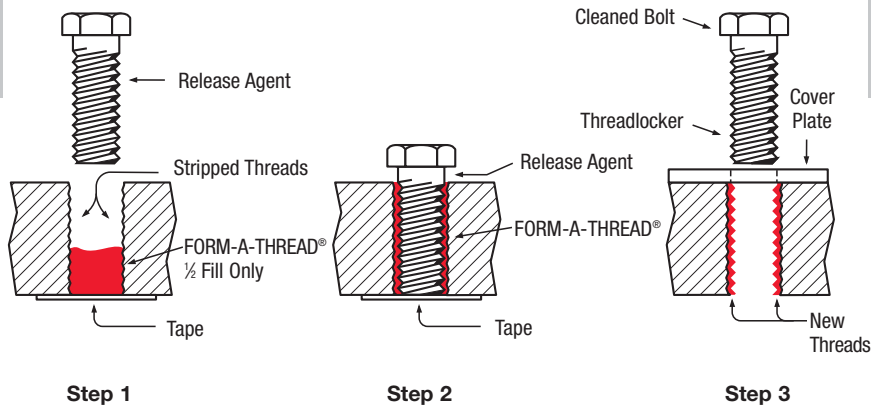
1. Clean bolts and nuts with Loctite® ODC-Free Cleaner & Degreaser.
2. Assemble components.
3. Tighten nuts.
4. Apply several drops of Loctite® 220™ or 290™ Threadlocker at the nut and bolt juncture.
5. Avoid touching bottle tip to metal.  
**Note:** For preventive maintenance on existing equipment: RETIGHTEN nuts and apply Loctite® 220™ or 290™ Threadlocker at the nut and bolt juncture.

## LOCTITE® BRAND THREADLOCKER QUICK SELECTOR

Use	Strength	Product	Color
Small Screws	Low	222MS™	Purple
Nuts & Bolts	Medium	2440™ / QuickStix™ 248™	Blue
Pre-Assembled	Medium	290™	Green
Pre-Assembled	Low	220™	Blue
Nuts & Bolts	High	2670™ / QuickStix™ 268™	Red
Studs (up to 1")	High	2760™	Red
Studs (over 1")	High	277™	Red

# THREAD REPAIR

## STRIPPED THREAD REPAIR



## STANDARD THREAD REPAIR

1. Follow instructions on Loctite® FORM-A-THREAD® package.
2. If cover plate is used for bolt alignment:
  - (a) Apply release agent to mating faces around repair area.
  - (b) Use “waxed” paper or similar film between faces.
3. A “jiggling/twisting” motion when initially inserting bolt improves thread conformation.

Note: NOT intended for engine stud repair.

## SMALL HOLE/FINE THREAD REPAIR

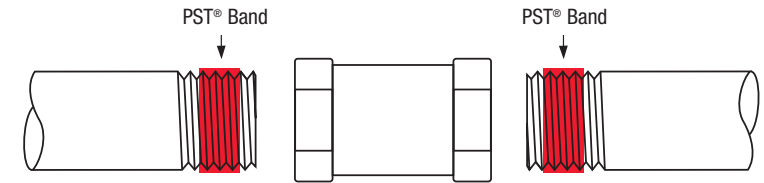
- OPTION 1. Drill out damaged hole to oversize, then follow STANDARD THREAD REPAIR.
- OPTION 2. Apply Loctite® FORM-A-THREAD® to screw and insert into damage hole. Clamp in place while product cures.

## STUD INSTALLATION – PERMANENT (LIGHT DUTY)

1. Use stud or cut “all thread” to desired length.
2. Do NOT apply release agent to stud.
3. Proceed as with STANDARD THREAD REPAIR.
4. Allow 30 minutes to cure.
5. Assemble as required.

# THREAD SEALING

## STANDARD FITTINGS – PIPES, HYDRAULIC, OR AIR



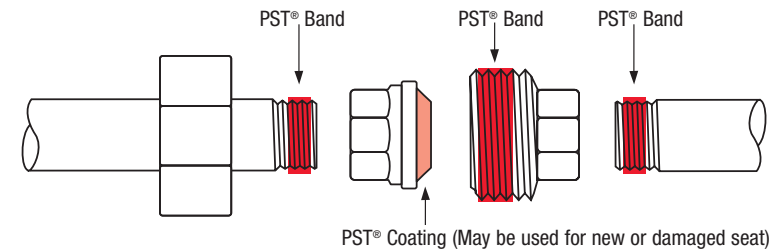
1. Clean parts of contamination. If necessary, spray Loctite® 7649™ Primer N™ onto threaded parts (male and female). Allow to dry.
2. Apply a band of Loctite® PST® Thread Sealant to male threads starting one to two threads from end of pipe.
3. Assemble parts snugly. Do not overtighten.
4. If initial pressure exceeds 1000 psi\*, wait 30 minutes before pressurizing.

Note: • For stainless steel components, use Loctite® 567™ PST® Thread Sealant.

- For general purpose thread sealing, use Loctite® 565™ PST® Thread Sealant or Loctite® QuickStix™ 561™ PST® Pipe Sealant.
- For fine filtration systems requiring zero contamination, use Loctite® 545™ Thread Sealant for hydraulic/pneumatic fittings.
- For easier disassembly or large diameter fittings, use Loctite® 564™ Thread Sealant.
- If sealing chemicals or strong acids/bases, refer to Fluid Compatibility Chart (LT-836).
- Do not use on oxygen or strong oxidizers (chlorine).
- For PVC or ABS pipe, use Loctite® No More Leaks™.

\*Depending on conditions

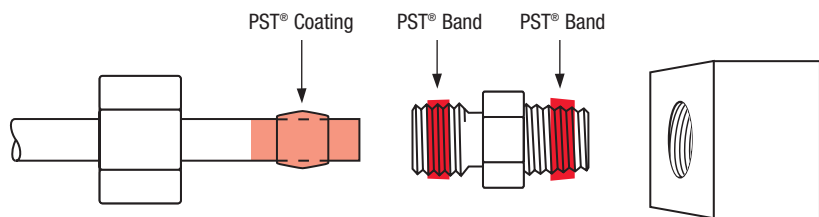
## PIPE UNIONS



1. Disassemble and, if necessary, spray all components with Loctite® 7649™ Primer N™. Allow to dry.
2. Apply a thin coating of Loctite® PST® Thread Sealant to union face.
3. Apply a band of Loctite® PST® Thread Sealant to male threads.
4. Assemble parts snugly.

# THREAD SEALING

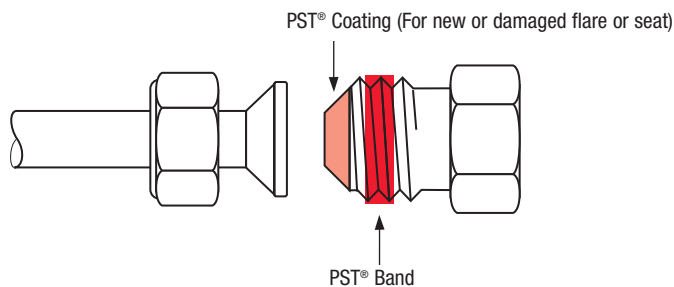
## COMPRESSION FITTINGS



1. Slide fitting nut and ferrule back approximately  $\frac{3}{4}$ " from end of tubing.
2. If necessary, spray the entire assembly with Loctite® 7649™ Primer N™. Allow to dry.
3. Apply a thin coating of Loctite® PST® Thread Sealant to tubing where ferrule will be located.
4. Slide ferrule forward over Loctite® PST® Thread Sealant coated tubing, then apply a thin bead of Loctite® PST® Thread Sealant coating to ferrule.
5. Slide ferrule forward over Loctite® PST® Thread Sealant coated tubing.
6. Apply a small band of Loctite® PST® Thread Sealant to male threads.
7. Assemble and tighten normally.

**Note:** Do not use on plastic fittings or tubing.

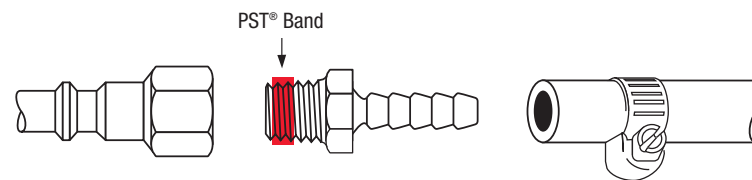
## FLARED/SWAGED FITTINGS



1. Disassemble and if necessary, spray all components with Loctite® 7649™ Primer N™. Allow to dry.
2. Apply a thin coating of Loctite® PST® Thread Sealant to fitting face.
3. Apply a band of Loctite® PST® Thread Sealant to male threads.
4. Assemble parts snugly.

# THREAD SEALING

## HOSE ENDS – AIR & HYDRAULIC



1. If necessary, spray adapter threads with Loctite® 7649™ Primer N™. Allow to dry.
2. Insert barbed hose stem into hose I.D. with slight twisting motion.
3. Install appropriate hose clamp.
4. Apply a band of Loctite® PST® Thread Sealant to male hose stem threads upon installation or adding accessory device. Tighten snugly.

**Note:** Loctite® PST® Thread Sealant may attack synthetic rubber tubing.

## LOCTITE® BRAND THREAD SEALANT QUICK SELECTOR (TAPERED THREADS)

Application	Product	Primer	Instant Seal	Max. Pressure	Steam Pressure	Temp. Range
Stainless Steel and All Other Metal Fittings	<b>567™ PST® Thread Sealant</b>	Primer N™	500 psi	10,000 psi (24 hours)	235 psi	-65°F to +400°F
Most Metal Fittings Except Stainless Steel	<b>565™ or 561™ PST® Pipe Sealant</b>	Primer N™	500 psi	10,000 psi (24 hours)	n/a	-65°F to +300°F
High Filtration/Zero Contamination Systems	<b>545™ Thread Sealant – Hydraulic/Pneumatic</b>	Primer N™	500 psi (10 min.)	10,000 psi (24 hours)	n/a	-65°F to +300°F
Stainless Steel and All Other Metal Fittings (lower strength)	<b>564™ Thread Sealant</b>	Primer N™	500 psi	10,000 psi (24 hours)	n/a	-65°F to +300°F

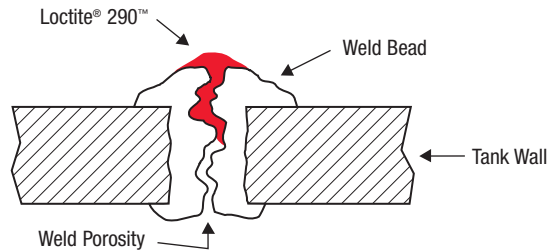
**DO NOT USE THESE PRODUCTS ON OXYGEN OR STRONG OXIDIZERS.**

## FLUID COMPATIBILITY

1. Refer to Fluid Compatibility Chart – LT-836.
2. Contact your local Industrial Distributor.
3. Call Henkel Technical Information. See back cover for the Henkel Technical Information number in your area.

# POROSITY SEALING

## EXISTING WELD POROSITIES AND CASTINGS



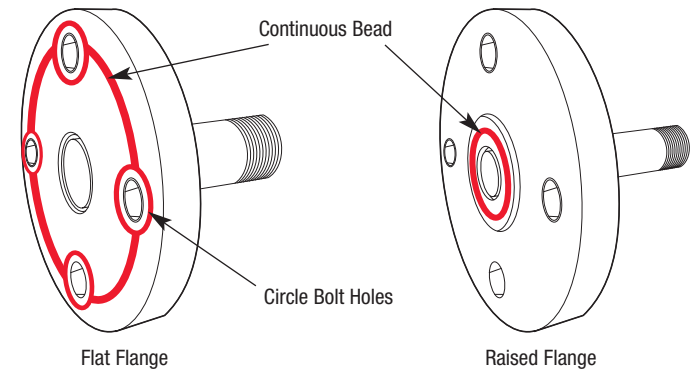
1. **IMPORTANT! TAKE PROPER SAFETY PRECAUTIONS IF WORKING WITH FLAMMABLE LIQUID TANKS. AVOID USE WITH COMPRESSIBLE GASSES.**
2. Wire brush to remove paint, rust, etc. from repair area.
3. Clean repair area with Loctite® ODC-Free Cleaner & Degreaser.
4. Apply localized heat to bring repair area to approximately 250°F.
5. Allow repair area to cool to approximately 185°F.
6. Brush or spray sealant on repair area.
  - Note:**
    - Steel – Use Loctite® 290™ Threadlocker at 185°F.
    - Aluminum/Stainless Steel – Use Loctite® 290™ Threadlocker at 120°F.
  - Note:**
    - Not recommended for “blowholes”.
    - Maximum porosity sealed – .005”.
7. Allow to cure for 30 minutes (High Pressure, above 150 psi – 1 hour).
8. Clean with Loctite® ODC-Free Cleaner & Degreaser to remove excess sealant. Do not grind.
9. Paint as required.
  - Note:** Casting repair uses same procedure.

## SEALING NEW WELDS – PREVENTATIVE MAINTENANCE

1. Remove all slag and scale while hot.
2. Apply sealant when weld is 185°F and falling.
3. Follow information above.

# FORM-IN-PLACE GASKETING

## SEALING CAST RIGID FLANGES



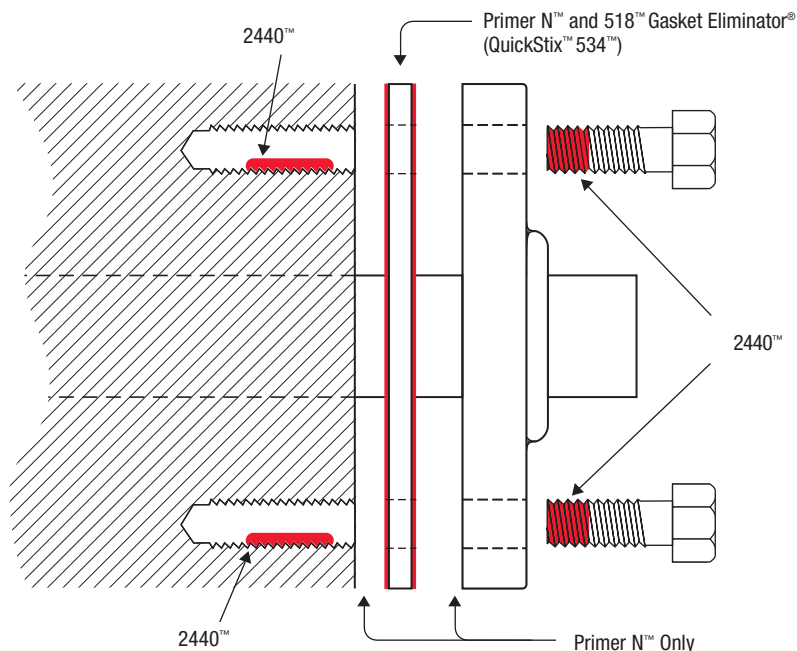
1. Remove old gasketing material and other heavy contaminants with Loctite® Chisel® Gasket Remover. Use mechanical removal technique if required.
  - Note:** Avoid grinding.
2. Clean both flanges with Loctite® ODC-Free Cleaner & Degreaser.
3. Spray Loctite® 7649™ Primer N™ on only one surface. Allow 1-2 minutes to dry.
4. Apply a continuous bead of Loctite® Gasket Eliminator® Flange Sealant to the other surface.
  - Note:** Circle all bolt holes with sealant, if appropriate.
5. Mate Parts. Assemble and tighten as required.
  - Note:** Immediate assembly not required; however avoid delays over 45 minutes.
6. Allow to cure:
  - a. No pressure – immediate service
  - b. Low pressure (up to 500 psi) – 30 to 45 minutes
  - c. High pressure (500 to 2500 psi) – 4 hours
  - d. Extreme high pressure (2500 to 5000 psi) – 24 hours

## LOCTITE® BRAND GASKETING QUICK SELECTOR

Use	Product	Gap Fill	Temp. Range
General	518™ Gasket Eliminator®	.050"	-65°F to 300°F
General	515™ Gasket Eliminator®	.050"	-65°F to 300°F
High Temperature	510™ Gasket Eliminator®	.020"	-65°F to 400°F
General/Overhead	QuickStix™ 548™ Gasket Eliminator®	.010"	-65°F to 300°F

# GASKET DRESSING

## SEALED FLANGES



1. Remove old gasketing material and other heavy contaminants with Loctite® Chisel® Gasket Remover. Use mechanical removal technique if required.

**Note:** Avoid grinding.

2. Clean both flanges with Loctite® ODC-Free Cleaner & Degreaser.
3. Spray Loctite® 7649™ Primer N™ on both flange faces and both sides of the precut gasket. Allow 1-2 minutes to dry.
4. Smear Loctite® Gasket Eliminator® Flange Sealant to both sides of precut gasket with a clean applicator.
5. Place coated gasket on flange surface and assemble parts immediately.

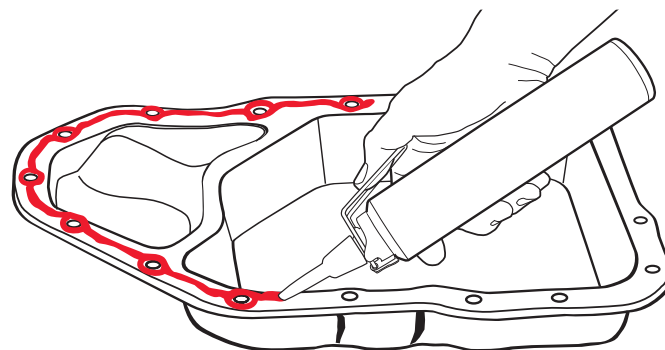
**Note:** • If cover bolts into blind holes (as above), apply Loctite® 2440™ Threadlocker into hole and on threads. Tighten normally.

- If it is a through bolt assembly, apply Loctite® 2440™ Threadlocker or Loctite® QuickStix™ 248™ Threadlocker to bolt threads.

6. Tighten normally.

# FORM-IN-PLACE SILICONES

## STAMPED OR SHEET METAL FLANGES



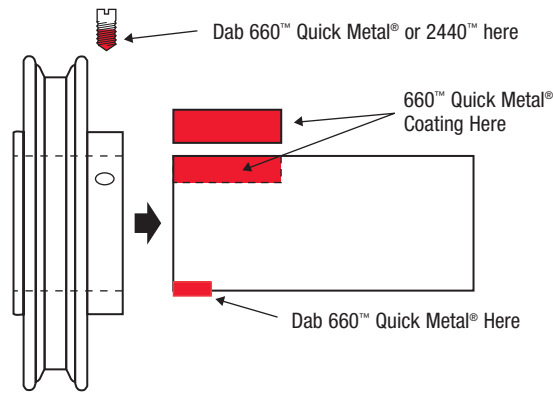
1. Remove old gasketing material and other heavy contaminants with Loctite® Chisel® Gasket Remover.
2. Clean both flanges with Loctite® ODC-Free Cleaner & Degreaser.
3. Apply a continuous bead of Loctite® Instant Gasket or Loctite® high performance silicones to sealing surface. Circle all bolt holes.  
**Note:** • Use proper bead diameter to seal flange width and depth.  
• Minimize excessive material “squeeze in”.
4. Assemble within 10 minutes by pressing together. Tighten as required.
5. Clean up any excess or squeeze out.
6. Cure times will vary with temperature, humidity, and gap. Typical full cure time is 24 hours.

	Loctite® Instant Gasket*	Loctite® 587™ Blue
COLOR	Black	Blue
VISCOSITY, cP	Paste	Paste
GAP FILL	¼"	¼"
CURE METHOD	Moisture/Oxime	Moisture/Oxime
CURE SPEED		
Tack-Free	30 minutes	30 minutes
Full Cure	24 hours	24 hours
SERVICE TEMP. RANGE		
Intermittent	-75°F to 500°F -59°F to 260°C	-75°F to 500°F -59°F to 260°C

\*Loctite® Instant Gasket provides a low pressure instant seal (100 psi at zero gap).

# STRENGTHEN KEYED ASSEMBLIES

## STANDARD DUTY



### ASSEMBLY

1. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray all parts (I.D. and O.D.) with Loctite® 7649™ Primer N™.
3. Apply Loctite® 660™ Quick Metal® Retaining Compound coating into keyway and on key.
4. Apply dab(s) of Loctite® 660™ Quick Metal® Retaining Compound onto shaft opposite keyway or evenly spaced around shaft.
5. Assemble parts. Wipe off excess.
6. Apply Loctite® 660™ Quick Metal® Retaining Compound dab to set screw.
7. Tighten set screw.
8. Allow 5-10 minutes prior to service.

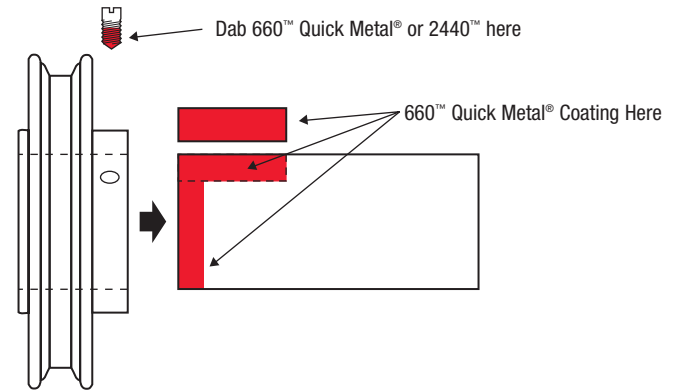
**Note:** • Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010" on shaft or keyway.  
• See REPAIRING BADLY WALLOUED KEYWAY for procedure page 18.

### DISASSEMBLY

1. Tap component and key with hammer.
2. Pull as usual.

# STRENGTHEN KEYED ASSEMBLIES

## HEAVY DUTY



### ASSEMBLY

1. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
2. Apply a Loctite® 660™ Quick Metal® Retaining Compound coating around shaft, into keyway, and on key.
3. Assemble parts. Wipe off excess.
4. Apply a Loctite® 660™ Quick Metal® Retaining Compound dab to screw.
5. Tighten set screw.
6. Allow 30 minutes prior to service.

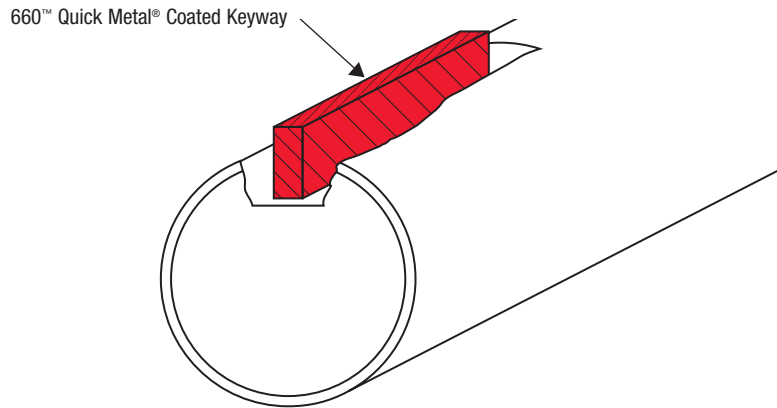
**Note:** • If gap exceeds .005", use Loctite® 7649™ Primer N™ on appropriate area (shaft or keyway).  
• Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010" on shaft or keyway.  
• See REPAIRING BADLY WALLOUED KEYWAY for procedure page 18.

### DISASSEMBLY

1. Tap component and key with hammer.
2. If necessary, apply localized heat (450°F for five minutes).
3. Pull while hot.

# STRENGTHEN KEYED ASSEMBLIES

## REPAIRING BADLY WALLOUED KEYWAY



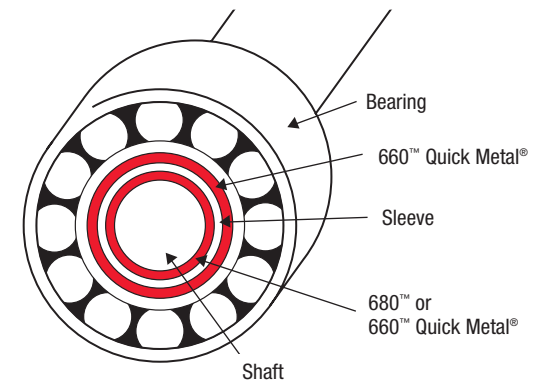
1. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray all parts with Loctite® 7649™ Primer N™. Allow to dry.
3. Apply a Loctite® 660™ Quick Metal® Retaining Compound coating into keyway.
4. Assemble as required using Loctite® 660™ Quick Metal® Retaining Compound.
5. Allow 30-60 minute cure time.

**Note:**

- Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for lateral gaps exceeding .010".
- Higher strengths are obtained by NOT using Loctite® 7649™ Primer N™ with small (.002"-.004") gap, and allowing longer cure (4-24 hours).

# SHAFT MOUNTED ASSEMBLIES

## REPAIRING BADLY WORN SHAFT



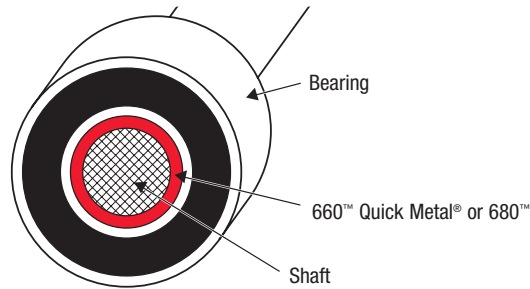
1. Determine a minimum radial gap.
2. Select and trim appropriate sleeve to allow component slip fit.
3. Roughen sleeve O.D. with emery cloth.
4. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
5. Apply a Loctite® 680™ or Loctite® 660™ Quick Metal® Retaining Compound coating around the shaft.
6. Install sleeve.
7. Apply a coating of Loctite® 660™ Quick Metal® Retaining Compound to sleeve O.D.
8. Install component as required onto sleeved shaft.
9. Allow 30-60 minute cure.

**Note:**

- Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010".
- Higher strengths are obtained by NOT using Loctite® 7649™ Primer N™ with small (.002"-.004") gap, and allowing longer cure (4-24 hours).

# SHAFT MOUNTED ASSEMBLIES

## SLIP FIT - LIGHT/HEAVY DUTY



### ORIGINAL

1. Machine shaft to .002" radial slip fit with 50-80 rms finish (second cut).
2. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser.
3. Spray all parts (I.D. and O.D.) with Loctite® 7649™ Primer N™. Do NOT use primer for heavy duty applications.
4. Apply a Loctite® 660™ Quick Metal® Retaining Compound coating around shaft and engagement area.
5. Assemble parts with rotating motion.
6. Wipe off excess.
7. Allow 2 hours prior to service.

### WORN SHAFT

Follow directions above except:

1. Determine radial gap.
2. If radial gap exceeds .005", Loctite® 7649™ Primer N™ must be used.
3. Take steps to maintain concentricity with large gaps.
4. Larger gaps require longer cure times (30-60 minutes).
5. Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010".
6. See procedure for BADLY WORN SHAFT page 19.

**Note:** Loctite® 660™ Quick Metal® Retaining Compound is very fast fixturing (30 seconds or less) with Loctite® 7649™ Primer N™.

### MAXIMUM STRENGTH

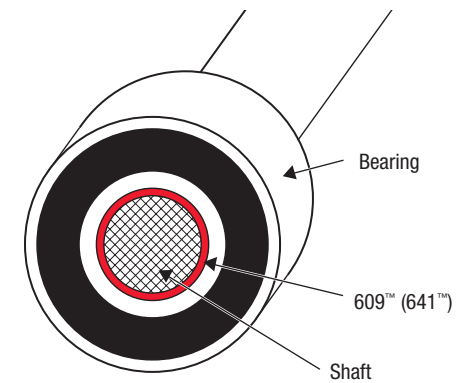
1. Same as above, except use Loctite® 680™ Retaining Compound with Loctite® 7471™ Primer N™ or no primer.
2. Allow 4-24 hours to cure.

### MAXIMUM TEMPERATURE (400°F continuous)

1. Same as above, except use Loctite® 620™ Retaining Compound with Loctite® 7471™ Primer N™.

# SHAFT MOUNTED ASSEMBLIES

## PRESS FIT



### STANDARD

1. Clean shaft O.D. and component I.D.
2. Apply a bead of Loctite® 609™ (641™) Retaining Compound to circumference of shaft at leading edge of insertion or leading area of engagement.  
**Note:** • Retaining compound will always be squeezed to the outside when applied to shaft.  
• Do NOT use with Loctite® Anti-Seizes or similar product.
3. Press as usual. Wipe off excess.
4. No cure time required.  
**Note:** Loctite® 609™ (641™) Retaining Compound is used due to low viscosity and wetting properties.

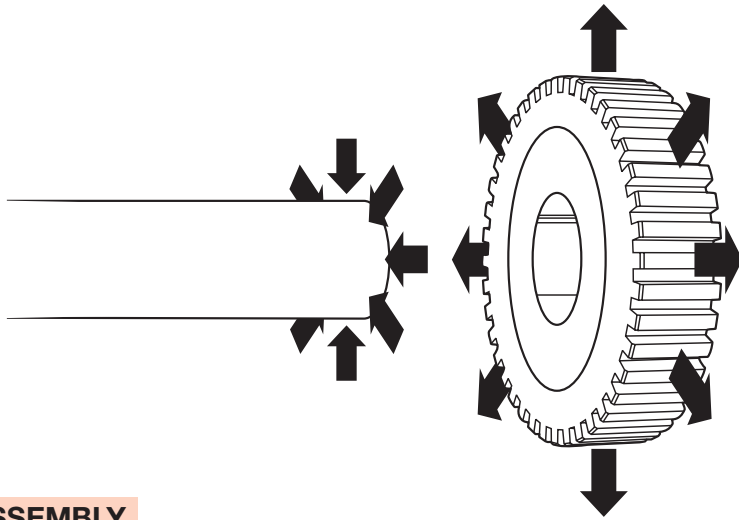
### TANDEM MOUNT

1. Apply retaining compound to bore of inside component.
2. Continue assembly as above.



# SHAFT MOUNTED ASSEMBLIES

## SHRINK FIT



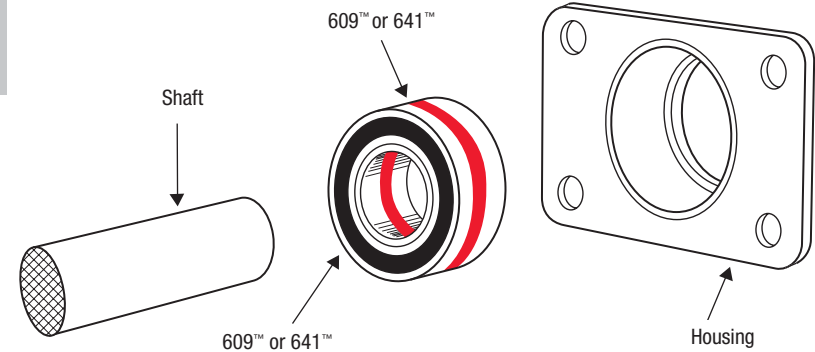
### ASSEMBLY

1. Clean the shaft O.D. and component I.D.
2. Cool the shaft to cause contraction, or heat the component to cause expansion.
3. Apply a brush film of Loctite® 641™ Retaining Compound to the shaft or lower temperature part.
4. Install component and allow temperatures to equilibrate.
5. Wipe off excess.

**Note:** Loctite® 641™ Retaining Compound will add lubricity for easier assembly while sealing and protecting the bond area from environmental exposure and filling gaps for a more complete contact area.

# HOUSED COMPONENTS

## SLIP FIT



### ORIGINAL

1. Select component to fit shaft.
2. Machine to reduce component O.D. or increase housing I.D. to permit approximate .002"-.004" diametral slip fit.
3. Clean all parts with Loctite® ODC-Free Cleaner & Degreaser and spray with Loctite® 7649™ Primer N™.
4. Apply Loctite® 609™ or 641™ Quick Metal® Retaining Compound to component O.D.
5. Install component. Do not rotate.
6. Wipe off excess.
7. Allow five minutes prior to service.

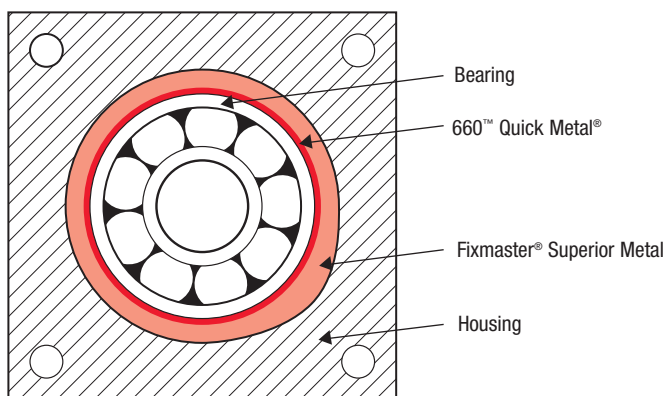
### WORN

Procedures identical to original slip fit, except:

1. Determine the maximum radial gap.
2. If the maximum gap exceeds .005", Loctite® 7649™ Primer N™ must be used.
3. Take steps to maintain concentricity on large gaps.
4. Large gaps require longer cure times (30-60 minutes).
5. Loctite® 660™ Quick Metal® Retaining Compound is NOT recommended for radial gaps exceeding .010".
6. See procedure for BADLY WORN HOUSING page 24.

# HOUSED COMPONENTS

## REPAIRING BADLY WORN HOUSING



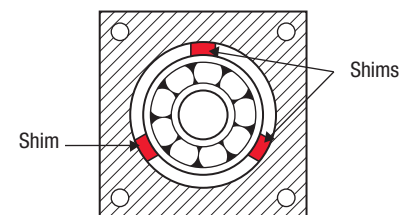
### ASSEMBLY

1. Roughen housing I.D. with emery cloth or abrasive media.
2. Clean the housing I.D. with Loctite® ODC-Free Cleaner & Degreaser.
3. Clean the component O.D. and apply a release agent.
4. Prepare (mix) Loctite® Fixmaster® Superior Metal.
5. Apply a coating of Loctite® Fixmaster® Superior Metal to the I.D. of the housing.
6. Position the component in housing. Maintain concentricity.
7. Pack Loctite® Fixmaster® Superior Metal into the gaps and voids.
8. Wipe off excess material.
9. Allow to cure 30 minutes.
10. Pull component.
11. Clean the release agent from component O.D.
12. Clean and roughen the housing I.D.
13. Assemble with Loctite® 660™ Quick Metal® Retaining Compound as required.
14. Recommended for light duty service.

**Note:** This procedure is for use when machining is not an option. If you want a procedure for using Loctite® Fixmaster® Superior Metal and machining back to original tolerance, then contact your local Henkel Adhesive and Sealants Specialist.

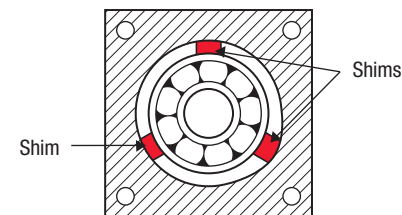
# HOUSED COMPONENTS

## COMPONENT CENTERING



### EXCESSIVE / EVEN WEAR

1. Position the component in bore.
2. Select three equilateral mounting points.
3. Determine the radial gap at those points.
4. Select appropriate shim stock.
5. Cut three pieces approximately 1/8" wide to fit bore depth.
6. Bond the shims to bore at mounting points using Loctite® 380™ Black Max® Instant Adhesive.
7. Assemble per instructions on page 23.



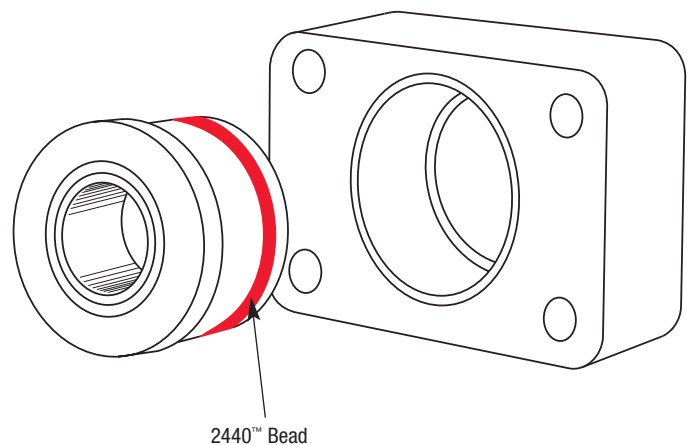
### EXCESSIVE / UNEVEN WEAR

1. Position the component in bore.
2. Select three equilateral mounting points.
3. Determine the radial gap at those points.
4. Select and cut appropriate shim stock for each point.
5. Bond the shims to bore at mounting points using Loctite® 380™ Black Max® Instant Adhesive.
6. Assemble per instructions on page 24.

# HOUSED COMPONENTS

# RETAINING COMPOUNDS

## SEALING/RETAINING – METALLIC SEAL



1. Clean the housing I.D. and seal O.D. with Loctite® ODC-Free Cleaner & Degreaser.
2. Spray both the housing and seal with Loctite® 7649™ Primer N™.
3. Apply a bead of Loctite® 2440™ (QuickStix™ 248™) Threadlocker to the leading edge of metallic seal O.D.

**Note:** Virtually any Loctite® Threadlocking product will work here. Medium strength liquid is recommended due to normal gap and strength requirement.

4. Install as usual.
5. Wipe off excess.
6. Allow to cure 30 minutes.

**Note:**

- Loctite® 2440™ (QuickStix™ 248™) Threadlocker is normally used with worn seal housings to prevent leakage or slippage.
- It is not generally necessary to remove pre-applied sealant from seal O.D.

## LOCTITE® RETAINING COMPOUND QUICK SELECTOR

Application	Loctite® Product	Loctite® Primer
<b>Shaft Mount – Press fit</b>		
Medium Strength	<b>609™</b> (QuickStix™ <b>668™</b> ) Retaining Compound	NONE
	<b>641™</b> Retaining Compound	N™
<b>Shaft Mount – Shrink fit</b>		
Medium Strength	<b>641™</b> Retaining Compound	NONE
<b>Shaft Mount – Slip Fit</b>		
Small Gap (.002" Radial max.)	<b>609™</b> (QuickStix™ <b>668™</b> ) Retaining Compound	N™
Larger Gap (.010" Radial max.)	<b>660™</b> Quick Metal® Retaining Compound	N™
Maximum Strength (.010" Radial max.)	<b>680™</b> Retaining Compound	N™
Maximum Temperature (400°F) (.008" Radial max.)	<b>620™</b> Retaining Compound	N™
Medium Strength	<b>641™</b> Retaining Compound	N™
<b>Housing Mount – Press Fit</b>		
Maximum Strength	<b>609™</b> (QuickStix™ <b>668™</b> ) Retaining Compound	NONE
Medium Strength	<b>641™</b> Retaining Compound	N™
Low Strength	<b>2440™</b> Threadlocker	NONE
<b>Housing Mount – Slip Fit</b>		
Maximum Strength	<b>680™</b> Retaining Compound	NONE
High Strength	<b>660™</b> Quick Metal® Retaining Compound	NONE
Controlled Strength	<b>660™</b> Quick Metal® Retaining Compound	N™
Medium Strength	<b>641™</b> Retaining Compound	N™
Low Strength	<b>2440™</b> (QuickStix™ <b>648™</b> ) Threadlocker	N™

- Note:**
- Softer metals (Aluminum, Bronze, etc.) provide lower shear strengths than ferrous components.
  - Excessive gap reduces shear strengths.
  - Ideal surface finish – 50 to 80 rms.

Refer to Technical Data Sheets for more information.

# DISASSEMBLY

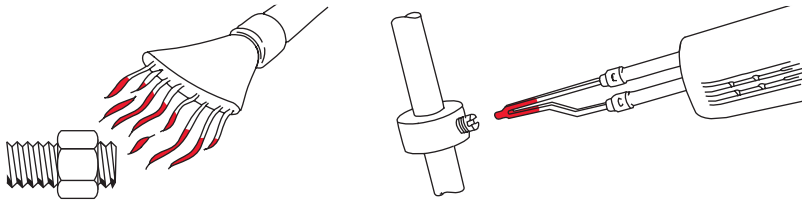
## THREADLOCKING, THREAD SEALING & RETAINING

### LOW AND MEDIUM STRENGTH PRODUCTS

Disassemble with hand tools.

### HIGH STRENGTH PRODUCTS

- Apply localized heat (500°F or higher) to assembly for 5 minutes.
- Disassemble with hand tools while hot.

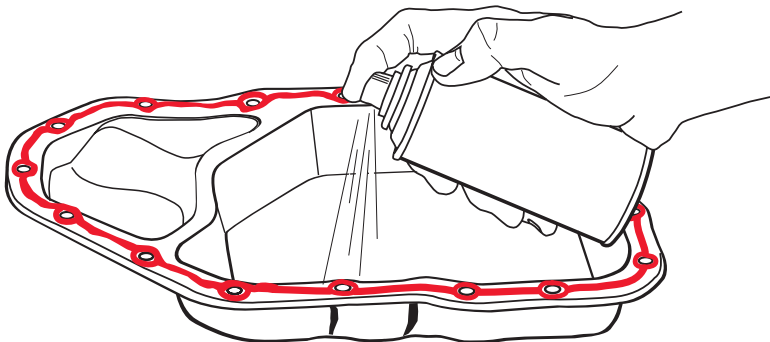


## GASKETING

- Disassemble flange using hand tools.

**Note:** For anaerobic gaskets, clean with Loctite® Chisel® Gasket Remover.

For silicone gaskets, clean with Loctite® Chisel® MC-Free Gasket Remover.



# SHAFT REPAIR

## GENERAL INFORMATION

Figure A

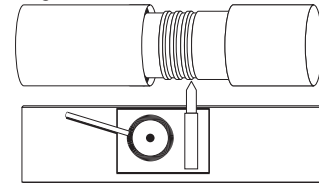


Figure B

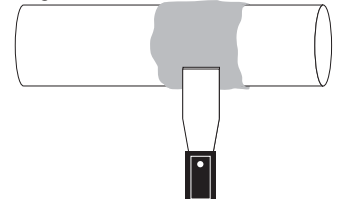
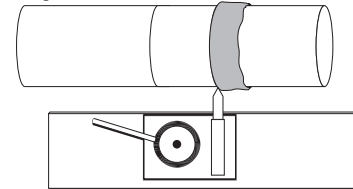


Figure C



1. Using a lathe, undercut desired depth according to the table below:

Shaft diameter	Desired undercut
½" to 1" (13 - 25 mm)	⅛" (1.5 mm)
1" to 3" (25 - 74 mm)	⅜" (3.0 mm)

2. Finish undercutting by machining a rough-cut surface or “gramophone” pattern; the larger the diameter of the shaft, the deeper the threads. (See Figure A)
3. Clean the shaft of any cutting fluids or oils with Loctite® ODC-Free Cleanser & Degreaser.
4. Apply a very thin layer of Loctite® Fixmaster® Superior Metal by forcing it into the bottom of the threads. Turn the shaft at a very low speed and continue to apply more material by using a tool, such as a putty knife, that can be bent. (See Figure B)
5. Allow the product to cure for the required period at 70°F (20°C) or higher (if necessary, apply dry heat to speed up the cure).
6. Machine repaired area to original dimensions of the shaft (see Figure C) using the guidelines below:

Lathe Speed: 150 ft./min. (46 m/min.)

Feed Rate: • Roughening: 0.025 in./rev. (0.64 mm/rev.)

• Finishing: 0.010 in./rev. (0.25 mm/rev.)

Top Rake/Side and Front Clearance: 3°

**Note:** Cut dry; use carbide or high-speed steel bits. If polishing is required, use only wet 400 to 600 grit emery paper.

## INTRODUCTION TO BONDING ADHESIVES

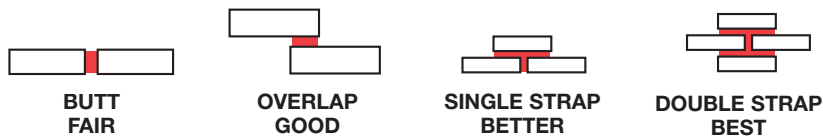
Within the broad range of Loctite® brand adhesives you will always find the solution to your bonding challenge. It is however, extremely important to have at least basic knowledge of adhesive methodology in order to successfully bond two substrates together. The three major causes of bonding failures are attributed to:

- Poor evaluation of the bonding assembly
- Inadequate substrate preparation
- Improper adhesive selection

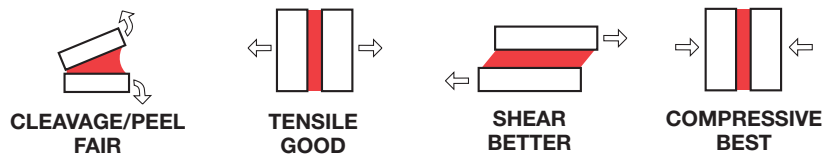
## BONDING ASSEMBLY

Bonding assembly has a direct impact in the adhesive performance. Choose a combination of types of joints or joint stress distribution that maximizes bonding strength. Below are different types of joints and stress distribution:

### TYPES OF JOINTS

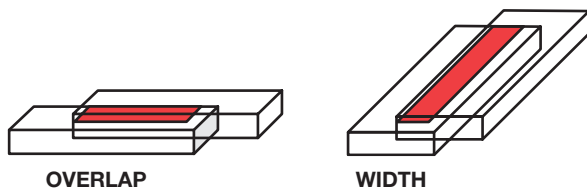


### TYPES OF JOINT STRESS DISTRIBUTION



### JOINT WIDTH VS. OVERLAP

A wider bond line (Width) will be stronger than a lengthier one (Overlap):



## SURFACE PREPARATION

### Abrasive Methods

Rubbing or striking a surface with hard, coarse material.

Abrasive examples:

- Sanding: Rubbing with abrasive paper or cloth (for small area/superficial wear-down)
- Blasting: Striking with steel grit, sand, or other abrasive material (for large areas/deep wear-down)

### Chemical Methods

Cleaning process that uses solvents to dissolve contaminants.

Chemical examples:

- Solvent Dip: Immersing in solvent
- Solvent Wipe: Rubbing with solvent-soaked wipe
- Vapor Degreasing: Solvent in vapor form
- Ultrasonic Cleaning: Solvent dip method with high-frequency sound waves that vibrate the dirt away

## LOCTITE® BRAND ADHESIVE QUICK SELECTOR

Product	Loctite® 404™ Quick Set™ Instant Adhesive	Loctite® 330™ Depend® Adhesive	Loctite® Fixmaster® Poxy Pak™ Adhesive	Loctite® H8600™ Weld Eliminator™ Structural Adhesive
Color	Clear	Pale Yellow	Clear	Blue
Temperature Range	Up to 180°F	Up to 250°F	Up to 180°F	Up to 300°F
Bond Time*	20 to 40 seconds	5 minutes	5 minutes	45 minutes
Full Cure*	24 hours	24 hours	1 hour	24 hours
Gap Fill	Small Gaps	Medium Gaps	Large Gaps	Medium Gaps
Agency Approvals	CFIA, ABS, Mil-Spec	CFIA	CFIA, ABS	In Progress
Bonds to a wide range of materials, including:	Metal, plastic, and rubber	Ferrite, wood, ceramic, plastic, and metal	Glass, hard plastics, rubber, and metal	Galvanized steel, other metals, and most plastics
Application Examples	Make o-rings, bond cuts in conveyer belts, nylon rails in production line, brass rings on spacer shafts	Bond metal labels to equipment, aggregate wear plates, vibration analysis pickup discs to equipment	Repair cracks in equipment, fill in damage on fiberglass tanks, general purpose bonding	Patching metal surfaces, sleeving metal conduit and ducts, metal fabrication (e.g. wagons, box trailers, material handling containers)

\* Times are based on average room temperature of 70°F and may vary depending on the temperature and substrates used.

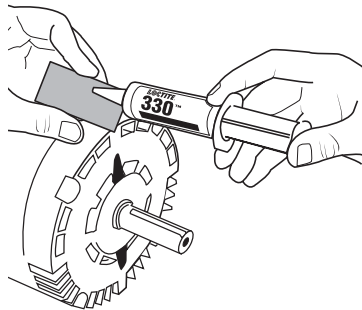
# BONDING

## O-RING MAKING



1. Cut the starting end of the cord stock with a clean razor blade. Ensure the cut is clean and square. Do not touch the clean cut end.
2. Measure cord stock to appropriate length. For precise measurement, use Loctite® O-Ring Tool or the ruler provided in the Loctite® O-Ring Making Kit.
3. Cut the measured end of the cord stock with a clean razor blade. Ensure the cut is clean and square to optimize bond area.
4. Apply one drop of Loctite® 404™ Quick Set™ Instant Adhesive and mate the two ends of the cord stock.

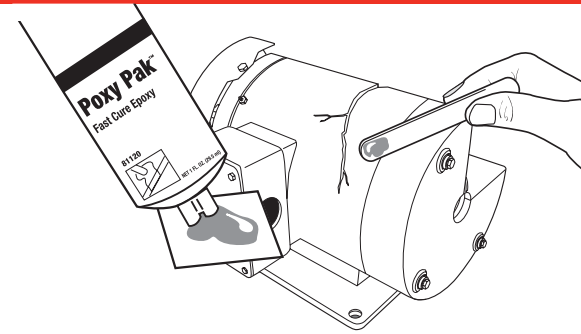
## BONDING METAL LABEL



1. Clean surface.
2. Spray Loctite® 7387™ Depend® Activator onto main part. Let dry for two minutes.
3. Apply Loctite® 330™ Depend® Adhesive onto back of label.
4. Press label onto activated surface and hold for a few seconds.
5. Reaches handling strength in 5 minutes. Full cure in 24 hours.

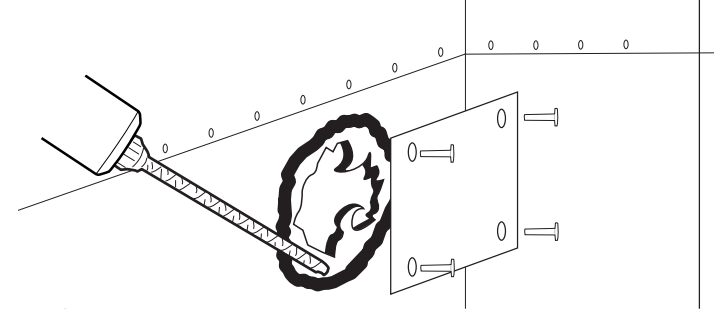
# BONDING

## FILLING CRACKS



1. Clean surface.
2. Mix Loctite® Fixmaster® Poxy Pak™ Epoxy Adhesive according to package directions.
3. Spread mixed material over crack.
4. Sets in 5 minutes, full cure in 8 hours.
5. For maximum protection, a piece of material can be applied over the top of the crack to spread the load after applying the mixed adhesive. The adhesive will hold it in place.

## STRUCTURAL BONDING



1. Prepare the surface using Loctite® ODC-Free Cleaner and Degreaser.
2. Attach mix nozzle to the Loctite® H8600™ Weld Eliminator™ Structural Adhesive cartridge.
3. Dispense 50 mm (2") of material to prime nozzle.
4. Apply a continuous bead of adhesive in the area you want to patch and/or seal.
5. Assemble patch using pneumatic pins or rivets, or run screws to hold parts together while the adhesive reaches full cure.
6. Equipment can be back in operation after 24 hours.

## OPTIMUM USE OF LOCTITE® EXTEND® RUST TREATMENT

### SURFACE PREPARATION – OLD STEEL:

Loose or “flaky” rust must be removed. Only conversion of firmly bonded rust will result in durable protection. Oil, grease, old paint, mill scale, form oil, fingerprints, water soluble surfaces and chlorides must be removed to allow Loctite® Extend® Rust Treatment to react with rust. Ideal surfaces will show light rust as well as bare metal surfaces.

### RUST CONVERSION TIME AND APPEARANCE:

Two coats of Loctite® Extend® Rust Treatment are recommended.

The first coat should develop a purple-black color within seconds. The second coat should dry to a black color. The second coat should be applied within 15-30 minutes of the first coat.

### APPLICATION CONDITIONS:

Loctite® Extend® Rust Treatment may be applied when surface and air are between 50°F and 90°F. Reaction is slower at lower temperatures. If temperature is too hot, film may surface dry and bubble. High humidity is beneficial; it slows drying but assists rust conversion. Loctite® Extend® Rust Treatment should not be applied in conditions of condensing humidity (e.g. fog, dew), on ice, in rain or in heavy sea (salt) spray atmospheres. Steel surface may be damp but not wet (i.e. continuous visible film of water). **DO NOT APPLY LOCTITE® EXTEND® RUST TREATMENT TO SURFACES IN DIRECT SUNLIGHT.**

### APPLICATION EQUIPMENT METHODS:

Loctite® Extend® Rust Treatment may be applied by brush, roller, or spray. Brush or roller is suitable for small areas. Avoid sags and ridges and keep edges wet by coating about a square yard at a time. Roll away from previously coated area and then roll back. Do not pour unused material back into the original container. **NEVER** add solvents to Loctite® Extend® Rust Treatment.

Spray application is recommended for larger areas. Airless spray equipment is faster, and provides more effective conversion due to improved surface penetration. Conventional air-spray equipment may be used, but Loctite® Extend® Rust Treatment may require thinning up to 10% with water for proper spraying.



## GENERAL PURPOSE PARTS CLEANING

In general, Loctite® Natural Blue® Biodegradable Cleaner & Degreaser cleaning effectiveness is enhanced by:

- a. Higher concentrations of Loctite® Natural Blue® Biodegradable Cleaner & Degreaser
- b. Longer cleaner on-part times
- c. Dilution with warm water (150°F to 180°F)
- d. Agitation of parts or scrubbing



### DIRECTIONS

1. Dilute Loctite® Natural Blue® Biodegradable Cleaner & Degreaser concentrate with water to most economical/effectiveness level. See package labels for suggested ratios.
2. Spray, dip or wipe dilution onto parts or surface to be cleaned.
3. Soak parts or scrub (if needed).
4. Flush soil/cleaner mixture off of parts or surfaces with water.
5. Disposal: Loctite® Natural Blue® Biodegradable Cleaner & Degreaser contains no hazardous ingredients. It should be disposed of in accordance with state and local regulations and will not harm sewage treatment microorganisms. Once Loctite® Natural Blue® Biodegradable Cleaner & Degreaser is mixed with hazardous waste, it must be treated as hazardous waste and disposed of accordingly.

**Note:** Loctite® ODC-Free Cleaner & Degreaser is recommended for cleaning substrates before Loctite® machinery adhesive use.

1. What type of failure is occurring? Has the application worked before?
2. Was proper and adequate adhesive/sealant used?
3. Was proper and adequate primer/activator used?
4. Do service conditions exceed the capability of the adhesive sealant?
  - (a) operating temperature
  - (b) excessive pressure too soon
  - (c) fluid compatibility
  - (d) impact on environment
5. Were parts adequately cleaned prior to applying adhesive?
 

**Note:** If adhesive failure, is cured residue on one or both parts?  
If one part is bare, check that part for contamination.
6. Were proper assembly techniques utilized?
7. Was adhesive/sealant allowed adequate cure time prior to service?
8. Do assembly/part conditions exceed capability of the adhesive/sealant?
  - (a) excessive gaps
  - (b) component materials
  - (c) improper joint design
  - (d) inadequate clamping/fixturing
9. If additional assistance is required, please call our HENKEL TECHNICAL INFORMATION LINE. See back cover for the Henkel Technical Information number in your area.

**Note:** Reference Materials

- (a) Product selection, cure times, gap fill, etc.; use Product Selector Slide Rule (LT-776)
- (b) Fluid Compatibility Chart (LT-836)

## LIMITATION OF WARRANTY

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof.

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## PRODUCT LISTING/ORDER INFO.

LOCTITE® ADHESIVES	SIZE	ITEM NO.
330™ DEPEND® ADHESIVE – NO-MIX	25 ml syringe kit	20251
	250 ml tube kit	20252
	250 ml tube	33058
	300 ml cartridge	33064
380™ BLACK MAX® INSTANT ADHESIVE – TOUGHENED	3 g tube	38004
	1 oz. bottle	38050
	1 lb. bottle	38061
404™ QUICK SET™ INSTANT ADHESIVE	½ oz. bottle	46551
	4 oz. bottle	46548
	1 lb. bottle	46561
H8600™ WELD ELIMINATOR™ STRUCTURAL ADHESIVE	50 ml dual cartridge	40875
	400 ml dual cartridge	38762
LOCTITE® CLEANERS	SIZE	ITEM NO.
CHISEL® GASKET REMOVER	18 oz. net wt.	79040
NATURAL BLUE® BIODEGRADABLE CLEANER & DEGREASER	24 fl. oz. spray	82249
	1 gallon bottle	82251
ODC-FREE CLEANER & DEGREASER	15 oz. aerosol	22355
	16 fl. oz. pump spray	20162
LOCTITE® EPOXIES	SIZE	ITEM NO.
FIXMASTER® SUPERIOR METAL	1 lb. kit.	97473
	4 lb. kit.	40900
FIXMASTER® POXY PAK™	1 oz. syringe	81120
LOCTITE® GASKETING PRODUCTS	SIZE	ITEM NO.
510™ GASKET ELIMINATOR® FLANGE SEALANT – HIGH TEMPERATURE	50 ml tube	51031
	250 ml tube	51041
515™ GASKET ELIMINATOR® FLANGE SEALANT	6 ml tube	51517
	50 ml tube	51531
	300 ml cartridge	51580
518™ GASKET ELIMINATOR® FLANGE SEALANT	6 ml tube	51817
	50 ml tube	51831
	300 ml cartridge	51845
QUICKSTIX™ 548™ GASKET ELIMINATOR® FLANGE SEALANT INSTANT GASKET	19 g stick	39156
	90 ml can	40479
	5 oz. cartridge	30509
	7 oz. can	30507
587™ BLUE RTV SILICONE GASKET MAKER	70 ml tube	58730
	8.75 oz. can	30567
	300 ml cartridge	58775
	300 ml cartridge	82046



# ORDERING

## PRODUCT LISTING/ORDER INFO.

LOCTITE® GENERAL MAINTENANCE PRODUCTS	SIZE	ITEM NO.
EXTEND® RUST TREATMENT	10.25 oz. aerosol	30539
	1 quart bottle	75430
	1 gallon bottle	75448
FORM-A-THREAD® STRIPPED THREAD REPAIR	4.8 ml syringe	28654
O-RING MAKING KIT	Kit	00112

LOCTITE® PRIMERS	SIZE	ITEM NO.
7387™ DEPEND® ACTIVATOR	1.75 fl. oz. bottle	18861
7649™ PRIMER N™ (Acetone)	25 g aerosol	21347
	1.75 fl. oz. bottle	19269
	4.5 oz. aerosol	21348

LOCTITE® RETAINING COMPOUNDS	SIZE	ITEM NO.
609™ RETAINING COMPOUND – GENERAL PURPOSE	10 ml bottle	60921
	50 ml bottle	60931
	250 ml bottle	60941
620™ RETAINING COMPOUND – HIGH TEMPERATURE	10 ml bottle	62015
	50 ml bottle	62040
	250 ml bottle	62070
641™ RETAINING COMPOUND – MEDIUM STRENGTH	10 ml bottle	28802
	50 ml bottle	21458
660™ QUICK METAL® RETAINING COMPOUND – PRESS FIT REPAIR	6 ml tube	66010
	50 ml tube	66040
	250 ml tube	30287
680™ RETAINING COMPOUND – HIGH STRENGTH/HIGH VISCOSITY	10 ml bottle	68015
	50 ml bottle	68035
	250 ml bottle	68060

# ORDERING

## PRODUCT LISTING/ORDER INFO.

LOCTITE® THREADLOCKERS	SIZE	ITEM NO.
220™ THREADLOCKER – LOW STRENGTH WICKING	10 ml bottle	37388
	250 ml bottle	22041
222MS™ THREADLOCKER – SMALL SCREWS	10 ml bottle	22221
	50 ml bottle	22231
	250 ml bottle	22241
2440™ THREADLOCKER – REMOVABLE	10 ml bottle	33946
	50 ml bottle	33947
	250 ml bottle	33948
QUICKSTIX™ 248™ THREADLOCKER – REMOVABLE	9 g stick	37684
	19 g stick	37087
2760™ THREADLOCKER – PERMANENT	10 ml bottle	32526
	50 ml bottle	32525
	250 ml bottle	32527
QUICKSTIX™ 268™ THREADLOCKER – HIGH STRENGTH	9 g stick	37685
	19 g stick	37686
277™ THREADLOCKER – LARGE STUD	10 ml bottle	21434
	50 ml bottle	27731
	250 ml bottle	27741
290™ THREADLOCKER – WICKING	10 ml bottle	29021
	50 ml bottle	29031
	250 ml bottle	29041

LOCTITE® THREAD SEALANTS	SIZE	ITEM NO.
545™ THREAD SEALANT – HYDRAULIC/PNEUMATIC	10 ml bottle	32439
	50 ml bottle	54531
	250 ml bottle	54541
QUICKSTIX™ 561™ PST® PIPE SEALANT	19 g stick	37127
564™ THREAD SEALANT	50 ml tube	28754
	250 ml tube	28755
565™ PST® THREAD SEALANT – CONTROLLED STRENGTH	50 ml tube	56531
	250 ml tube	56541
	300 ml cartridge	56571
567™ PST® THREAD SEALANT – HIGH TEMPERATURE	50 ml tube	56747
	250 ml tube	56765
	350 ml brush can	33241

## Loctite® Fixmaster® Marine Chocking

Loctite® Fixmaster® Marine Chocking is a two-part epoxy system recommended for the installation of main engines and other equipment. Achieves 100% surface coverage, precise equipment alignment, high compressive strength and long term durability. Loctite® Fixmaster® Marine Chocking was specifically developed for chocking marine main propulsion and auxiliary machinery. Other shipboard applications include: Sterntube and Strut Bearings, Pintle and Rudder Bearings, Pedestal Bearings, Steering Gears, Stern Winches, Engine Room Pumps, Cargo Pumps, Cable Penetrations, Large Ball or Roller Bearings, Bow Thrusters and Anchor Windlasses.



- Self-Leveling, Fast Curing, Non-Shrinking
- Excellent Chemical and Vibration Resistance
- Excellent Compression Strength



ABS



NAVSEA CFIA

Product	Item Number	Container	Color	Coverage	Mixture Viscosity (cP)	Maximum Temperature (°F)	Compressive Strength (PSI)	Working Time (Minutes)	Functional Cure (Hours)	Mix Ratio by Volume (Resin: Hardener)	Mix Ratio by Weight (Resin: Hardener)
Loctite® Fixmaster® Marine Chocking	39136	1 gallon kit	Green	120 in. <sup>3</sup>	15,000	250	22,000	15	24	100: 11.6	100: 6.9
	97572	2 gallon kit		370 in. <sup>3</sup>							
Loctite® Fixmaster® Marine Chocking	37316	1 gallon kit	Orange	120 in. <sup>3</sup>	15,000	250	22,000	15	24	100: 11.6	100: 6.9
	96102	2 gallon kit		370 in. <sup>3</sup>							



## Other Recommended Loctite® Products Approved for the Marine Industry

	Product Name	Item Number	Container	Color	ABS	NEHC*	Lloyds
Trowelable Metal-Filled Epoxies	Loctite® Fixmaster® Fast Set Steel Epoxy	39917	1 lb. kit	Grey	●	●	●
	Loctite® Fixmaster® Steel Putty	99913	1 lb. kit	Grey	●	●	●
		99914	4 lb. kit				
		99912	25 lb. kit				
	Loctite® Fixmaster® Steel Liquid	97483	1 lb. kit	Grey	●	●	●
		97484	4 lb. kit				
	Loctite® Fixmaster® Aluminum Putty	97463	1 lb. kit	Aluminum	●	●	●
Loctite® Fixmaster® Aluminum Liquid	97453	1 lb. kit	Aluminum	●	●	●	
Loctite® Fixmaster® Stainless Steel Putty	97443	1 lb. kit	Grey	●	●	●	
Loctite® Fixmaster® Superior Metal	97473	1 lb. kit	Dark Grey	●	●	●	
	40900	4 kg kit					
Wearing Compounds	Loctite® Nordbak® Wearing Compound	99813	5 lb. kit	Grey	●	●	●
	Loctite® Nordbak® Pneu-Wear	98383	3 lb. kit	Grey	●	●	●
		98382	25 lb. kit				
Loctite® Nordbak® Brushable Ceramic Grey	98733	2 lb. kit	Grey	●	●	●	
	98732	6 lb. kit					
Special Products	Loctite® Fixmaster® Wear Resistant Putty	98742	1 lb. kit	Grey	●	●	●
		98743	3 lb. kit				
	Loctite® Fixmaster® Flex 80™ Putty	97423	1 lb. kit	Black	●	●	●
		97422	6 lb. kit				
Loctite® Fixmaster® Wet Surface Repair Putty	96583	1 lb. kit	Grey	●	●	●	
Loctite® Extend® Rust Treatment	30539	10.25 oz. aerosol	Clear Black Black	●	●	●	
	75430	1 quart bottle					
	75448	1 gallon bottle					
Threadlockers, Thread Sealants, Retaining Compounds	Loctite® 242® Threadlocker – Medium Strength	24221	10 ml bottle	Blue	●	●	●
		24231	50 ml bottle				
	Loctite® 262™ Threadlocker – Medium to High Strength	26221	10 ml bottle	Red	●	●	●
		26231	50 ml bottle				
	Loctite® 545™ Thread Sealant	32429	10 ml tube	Purple	●	●	●
		54531	50 ml tube				
	Loctite® 567™ PST® Thread Sealant – High Temperature	56707 56747	6 ml tube 50 ml tube	White	●	●	●
	Loctite® 620™ Retaining Compound – Slip Fit/High Temperature	62015 62040	10 ml bottle 50 ml bottle	Green	●	●	●
Loctite® 680™ Retaining Compound – Slip Fit/High Strength	68015 68035	10 ml bottle 50 ml bottle	Green	●	●	●	
Loctite® 587™ Blue, High Performance RTV Silicone Gasket Maker	58730	70 ml tube	Blue	●	●	●	
	58775 30567	300 ml cartridge 8.75 oz. can					
Loctite® 598™ Black, High Performance RTV Silicone Gasket Maker	59830	70 ml tube	Black	●	●	●	
	59875 59866	300 ml cartridge 8.75 oz. can					
Bonding	Loctite® 404™ Quick Set™ Instant Adhesive – General Purpose	46551	1/3 oz. bottle	Clear	●	●	●
		46548	4 oz. bottle				
	Loctite® 454™ Prism® Instant Adhesive – Surface Insensitive Gel	45404	3 gm tube	Clear	●	●	●
	Loctite® 495™ Super Bonder® Instant Adhesive	49504	3 gm tube	Clear	●	●	●
Loctite® Fixmaster® Poxy Pak™, Fast Cure Epoxy	81120	1 oz. syringe	Clear	●	●	●	
Anti-Seize	Loctite® Marine Grade Anti-Seize	39395	8 oz. brush top	Black	●	●	●
		34026	16 oz. brush top				
	Loctite® Silver Grade Anti-Seize	76732	8 oz. brush top	Silver	●	●	●
76764		16 oz. brush top					
Loctite® Nickel Anti-Seize	77124	8 oz. brush top	Silver	●	●	●	
	51102	16 oz. brush top					

\*NAVY Environmental Health Center



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