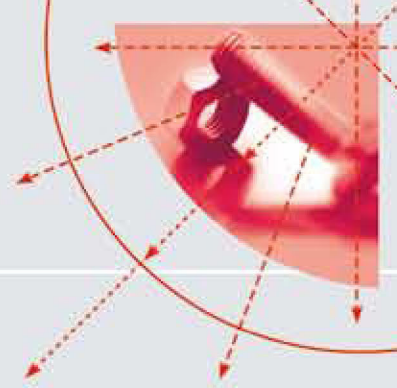




Threadlocking

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

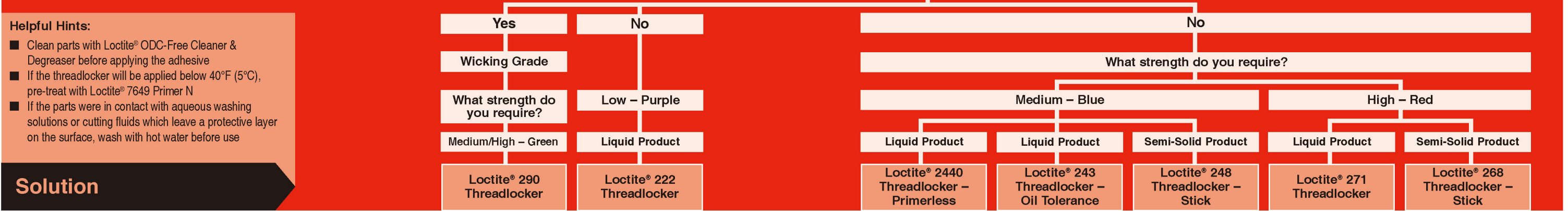


Are the parts already assembled?

Helpful Hints:

- Clean parts with Loctite® ODC-Free Cleaner & Degreaser before applying the adhesive
- If the threadlocker will be applied below 40°F (5°C), pre-treat with Loctite® 7649 Primer N
- 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



Fastener Size	#2 to 1/2" (M2 to M12)	Up to 1/4" (Up to M6)	1/4" to 3/4" (M6 to M20)	1/4" to 3/4" (M6 to M20)	1/4" to 3/4" (M6 to M20)	Up to 1" (Up to M25)	Up to 3/4" (Up to M20)
Strength	High	Low	Medium	Medium	Medium	High	High
Cure Time (Fixture / Full Strength)*	20 min./24 hr.	10 min./24 hr.	3 min./24 hr.	10 min./24 hr.	10 min./24 hr.	20 min./24 hr.	20 min./24 hr.
Breakaway / Prevail Torque lb.in. (N.m)	90/260 (10/29)	53/30 (6/3)	215/53 (24/6)	180/62 (20/7)	110/43 (12/4)	250/275 (28/31)	202/4 (22/0.5)
Temperature Resistance for Continuous Service	300°F (150°C)	300°F (150°C)	300°F (150°C)	300°F (150°C)	300°F (150°C)	300°F (150°C)	300°F (150°C)
Package Sizes – Part Number	50 ml bottle 250 ml bottle	50 ml bottle 250 ml bottle	50 ml bottle 250 ml bottle	50 ml bottle 250 ml bottle	9 g stick – 37772 19 g stick – 37773	50 ml bottle 250 ml bottle	9 g stick – 37774 19 g stick – 37775

* Typical value @ 70°F (22°C)

Additional Loctite® brand Threadlockers

Name	Strength	Breakaway/Prevail Torque lb.in. (N.m)	Features
220	Low	85/170 (9/19)	Wicking
242	Medium	110/43 (12/4)	Fasteners 1/4" to 3/4" (M6 to M20)
262	High	189/275 (21/31)	Fasteners up to 3/4" (M20)
272	High	200/220 (22/24)	High Temp up to 1 1/2" (M36)
2760	High	325/320* (36/36)	Primerless

* Breakloose value

Use Loctite® 7649 Primer N to:

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.
5. Act as a cleaning agent.

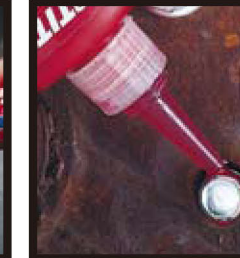
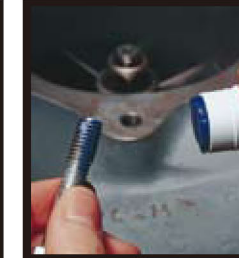
Primer is optional with:

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 Sizes: 1.75 oz., 4.5 oz.



Loctite® 290 Threadlocker

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® 222 Threadlocker

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

Loctite® 2440 Threadlocker – Primerless

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® 243 Threadlocker – Oil Tolerance

With improved oil tolerance, Loctite® 243 Threadlocker is effective on all types of metal threaded fasteners. Prevents loosening on vibrating parts such as pump, motor mounting bolts, gear boxes, or presses. Removable with hand tools. **NSF/ANSI 61. CFIA Approved.**

Loctite® 248 Threadlocker – Stick

Semi-solid stick form is convenient, portable, and great for hard-to-reach applications. Loctite® 248 Threadlocker – Medium Strength is the ideal general-purpose threadlocker for all nut and bolt applications, especially fasteners between 1/4" and 3/4" (M6 to M20). Removable with hand tools.

Loctite® 271 Threadlocker

A high strength, low viscosity threadlocker for fasteners up to 1" (25 mm) in diameter. **UL Classified for U.S. CFIA Approved.**

Loctite® 268 Threadlocker – Stick

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.