



Invented by Loctite Corporation, now Henkel Corporation, as a revolutionary method to lock and seal threaded fasteners, Loctite® brand liquid threadlockers have found wide acceptance in a range of applications – from delicate electronic components to heavy construction equipment.

Loctite® brand threadlockers are available in varying viscosities and strengths for virtually any application, including exposure to extreme environments.

THREADLOCKING

LIQUID THREADLOCKERS

Loctite® 222MS™ Threadlocker

Low Strength/Small Screw

Ideal for fastener diameters of ¼" (6 mm) and smaller. Controlled lubricity for accurate clamp loads. Parts can be separated using hand tools.

Loctite® 242® Threadlocker

Medium Strength

A general purpose, removable threadlocker for fasteners between ¼" and ¾" (6 to 20 mm) diameters. Controlled lubricity for accurate clamp loads. Parts can be separated using hand tools.

Loctite® 243™ Threadlocker

Medium Strength/Oil Resistant

A general purpose, medium strength threadlocker with improved oil tolerance. For fasteners between ¼" and ¾" (6 to 20 mm) diameters.

Loctite® 246™ Threadlocker

Medium Strength/High Temperature

This threadlocker resists oil and mild surface contamination at continuous temperatures to 450°F. Suitable for fasteners between ¼" and ¾" (6 to 20 mm) diameters.

Loctite® 262™ Threadlocker

Medium to High Strength

A permanent threadlocker for fasteners up to ¾" (20 mm) diameter. High lubrication for easy assembly. Excellent for preventing rust and corrosion in extreme chemical/environmental conditions.

Loctite® 266™ Threadlocker

High Strength/High Temperature

Fast fixturing threadlocker resists oil and mild surface contamination at temperatures to 450°F. Locks fasteners up to ¾" (20 mm) in diameter.

Same Formula...New Form!
See page 96 for details on
the new semi-solid
Threadlocking Sticks.

Loctite® 271™ Threadlocker*High Strength*

A high strength, low viscosity threadlocker for fasteners up to 1" (25 mm) in diameter.

Loctite® 272™ Threadlocker*High Strength/High Temperature*

Withstands temperatures to 450°F. Provides a fast cure on most surfaces, including "as received" fasteners. Recommended for bolts up to 1½" (36 mm) in diameter. Heat and hand tools are required for disassembly.

Loctite® 277™ Threadlocker*High Strength*

Locks fasteners up to 1½" (36 mm). Protects threads from rust and corrosion. Removable with heat and hand tools.

Loctite® 290™ Threadlocker*Wicking Grade*

A medium strength threadlocker for pre-assembled bolts up to ½" (12 mm). Penetrates threads by capillary action. Secures set screws and other assemblies after settings are completed. Seals welds and porous metal parts. Protects threads from rust and corrosion. Localized heating and hand tools are needed for disassembly.

Loctite® 294™ Threadlocker*Wicking Grade/High Temperature*

Ideally suited for pre-assembled fasteners. Performs well on oily fasteners.

Loctite® 425™ Assure™ Instant Adhesive*Surface Curing Threadlocker*

Low strength, fast curing threadlocker for plastic fasteners. Can be used as a tamper-proofing agent for the head of screws. Can be applied before or after assembly.

Loctite® 2432™ Threadlocker*Low Halogen/Low Sulfur*

This medium strength threadlocker was especially developed for use on sensitive metals like Titanium, used in the Nuclear Industry. Parts can be separated using hand tools.

Loctite® 2440™ Threadlocker*Primerless/Medium Strength*

This threadlocker is particularly fast curing, thereby reducing or eliminating the need for primers. Performs well on all substrates. It develops useable strength (100 in.-lbs.) within one hour. Parts can be separated using hand tools.

Loctite® 2760™ Threadlocker*Primerless/High Strength*






This threadlocker is particularly fast curing, thereby reducing or eliminating the need for primers. Particularly suitable for heavy duty applications where resistance to heavy shock, vibration, and stress levels are required.


*For technical information
and/or product
availability, call:
1-800-LOCTITE (562-8483)
or visit us on the web at:*

www.loctite.com



**LOCTITE® BRAND
LIQUID THREADLOCKERS
PROPERTIES CHART**

PRODUCT	Item Number	Container	Typical Use	Color	Viscosity cP	Torque in. lbs. (M10 Steel Nuts & Bolts) Break/Prevail	Temperature Range	Cure Speed, Steel @25°C	Oil Tolerant	Recommended Primer	Specific Gravity	Agency Approvals
220™	37388 22041	10 ml bottle 250 ml bottle	Wicking grade for small, pre-assembled fasteners under 1/4"	Blue	20	85/170	-65°F to 300°F	Fixture - 6 min. Full - 24 hrs.	No	N™ or T™	1.08	MIL-S-46163A for existing designs, CFIA
222™ 	21463 21464	10 ml bottle 50 ml bottle	Small screws under 1/4"	Purple	1,200/ 5,000 Thixotropic	53/30	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	N™ or T™	1.05	-
222MS™	22205 22221 22231 22241	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle	Easy removal small screws under 1/4"	Purple	1,200/ 5,000 Thixotropic	53/30	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	N™ or T™	1.05	MIL-S-46163A for existing designs, NSF P1, CFIA
242®	24205 24221 24231 24241 24243	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Removable grade up to 1/4" to 3/4" bolts	Blue	1,200/ 5,000 Thixotropic	110/43	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	N™ or T™	1.07	MIL-S-46163A for existing designs, NSF/ANSI 61, NSF P1, ABS, CFIA,
243™ 	23977 24077 24078 24079 21433	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	For 1/4" to 3/4" bolts. Provides fast cure on steel without primer	Blue	2,250/ 12,000 Thixotropic	180/62	-65°F to 300°F	Fixture - 5 min. Full - 24 hrs.	-	N™ or T™	1.08	NSF/ANSI 61, CFIA
246™	29513 29514 29515	10 ml bottle 50 ml bottle 250 ml bottle	High temperature med. strength	Blue	2,600	170/48*	-65°F to 450°F	Fixture - 20 min. Full - 24 hrs.	Yes	N™ or T™	1.15	-
262™ 	26205 26221 26231 26241 26243	.5 ml capsule 10 ml tube 50 ml bottle 250 ml bottle 1 liter bottle	High strength locking up to 3/4" bolts	Red	1,800/ 5,000 Thixotropic	189/ 275	-65°F to 300°F	Fixture - 5 min. Full - 24 hrs.	-	N™ or T™	1.05	MIL-S-46163A for existing designs, NSF P1, CFIA, ABS
266™	26772 26773 26774	10 ml bottle 50 ml bottle 250 ml bottle	High strength high temperature	Red-orange	3,750- 9,000	270/75	-65°F to 450°F	Fixture - 10 min. Full - 24 hrs.	Yes	N™ or T™	1.19	CFIA
271™	27105 27121 27131 27141 27143	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength for fasteners up to 1" diam.	Red	500	250/ 275	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	-	N™ or T™	1.10	MIL-S-46163A for existing designs, UL Listed for U.S., CFIA
272™ 	27240 27270 27285	50 ml bottle 250 ml bottle 1 liter bottle	High temperature applications	Red	9,500	200/ 220	-65°F to 450°F	Fixture - 30 min. Full - 24 hrs.	-	N™ or T™	1.11	CFIA
277™	21434 27731 27741 27743	10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength for large bolts	Red	7,000	275/ 275	-65°F to 300°F	Fixture - 60 min. Full - 24 hrs.	-	N™ or T™	1.12	MIL-S-46163A for existing designs
290™ 	29005 29021 29031 29041 29043	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Wicking grade for preassembled parts	Green	12	85/ 250	-65°F to 300°F	Fixture - 6 min. Full - 24 hrs.	-	N™ or T™	1.08	MIL-S-46163A for existing designs, NSF/ANSI 61, NSF P1, CFIA
294™	27934 27935 27936 27937	.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle	High temperature, wicking grade	Green	34	289/ 237	-65°F to 450°F	Fixture - 6 min. Full - 24 hrs.	Yes	N™ or T™	1.13	-
425™ Assure™	42540 42561	20 gm bottle 1 lb. bottle	For small metal and plastic fasteners and tamper-proofing	Blue	80	4/2	-65°F to 180°F	Fixture - 1.5 min. Full - 24 hrs.	-	-	1.10	-
2432™	25523	50 ml bottle	Low halogen, low sulfur, med. strength	Blue	300	150/ 53	-65°F to 300°F	Fixture - 30 min. Full - 24 hrs.	-	-	1.08	-
2440™	33946 33947 33948	10 ml bottle 50 ml bottle 250 ml bottle	Primerless, medium strength	Blue	1,800/ 6,800 Thixotropic	215/ 53*	-65°F to 300°F	Fixture - 3 min. Full - 24 hrs.	-	N™ or T™	1.10	-
2760™	32526 32525 32527 32528	10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Primerless, high strength	Red	2,900/ 10,000 Thixotropic	325/ 320*	-65°F to 300°F	Fixture - 4 min. Full - 24 hrs.	-	N™ or T™	1.15	CFIA

 Indicates worldwide availability.

* Breakloose value. Brookfield RVT spindle 3.20 RPM/25 RPM.

CHOOSING THE RIGHT LOCTITE® BRAND THREADLOCKER FOR THE APPLICATION

Choosing the right Loctite® brand threadlocker for the application is simple. Just answer these questions.

- 1. Do you need a threadlocker that can be removed or one that is permanent?**
Loctite® brand threadlockers are available in removable or permanent formulations.
- 2. What size thread are you locking?**
Loctite® brand threadlockers are available in a variety of strengths to lock any size fastener.
- 3. Is the application a blind hole or a thru-hole?**
The application method for blind hole assemblies differs from standard thru-hole assemblies.
- 4. Are there threadlockers for pre-assembled bolts?**
Henkel offers Loctite® brand wicking grade threadlockers that secure set screws and other assemblies after settings are completed.
- 5. What kind of metal(s) will be used?**
On two inactive metals such as stainless steel, zinc, magnesium, black oxide, cadmium, anodized aluminum, passivated, titanium, and others, a primer is needed to cure Loctite® brand threadlockers. If only one inactive metal, no primer is needed.
- 6. What other environmental conditions exist?**
Loctite® brand threadlockers are formulated to meet any application need – high temperature, severe vibration, and chemical resistance.
- 7. Will your application have to meet any agency approval?**
The Loctite® brand offers the broadest line of products approved by some of the most demanding regulatory agencies – NSF*, UL*, Military.

ANSWERS TO THE MOST FREQUENTLY ASKED QUESTIONS (FAQ) ABOUT USING LOCTITE® BRAND THREADLOCKERS

- Q. How do I disassemble parts? What is the procedure?**
- A. Use standard hand tools for disassembly of low and medium strength threadlockers. For high strength threadlockers, apply localized heat to nut or stud for 5 minutes at 450°F. Disassemble while hot.
- Q. When should I use a primer with threadlockers and when is it not necessary?**
- A. Always use a primer when two inactive metals are involved, or when you need to speed up the curing process for faster return to service. See Surface Preparation section for a list of active and inactive surfaces.
- Q. Can I use threadlockers on plastic threads?**
- A. This is not recommended as softening and/or stress cracking can occur.
- Q. I have excess squeeze-out of threadlocker product. Why hasn't it cured?**
- A. The anaerobic chemistry will cure only between metal surfaces when deprived of air.
- Q. I used a permanent threadlocker on a blind hole application and the fastener still backed out with vibration. Why?**
- A. The application method for blind hole assemblies requires that product be applied to both parts. If product is only applied to the fastener, air pressure will force the liquid threadlocker to escape as you torque it down. Lack of uniform coverage creates air pockets, causing incomplete cures which result in failures.

LOW STRENGTH THREADLOCKERS



- Removable with hand tools
- Adjustment screws
- Calibration screws
- Meters and gauges
- Up to 1/4" diameters

MEDIUM STRENGTH THREADLOCKERS



- Removable with hand tools
- Machine tools and presses
- Pumps and compressors
- Mounting bolts
- Gear boxes
- Up to 3/4" diameters

HIGH STRENGTH THREADLOCKERS



- Permanent assembly
- Heavy equipment
- Suspension bolts
- Motor and pump mounts
- Bearing cap bolts and studs
- Up to 1" and larger diameters

WICKING THREADLOCKERS



- Removable with heat and hand tools
- Preassembled fasteners
- Instrumentation screws
- Electrical connectors
- Carburetors
- Up to 1/2" diameters

* NSF = National Sanitation Foundation. UL = Underwriter's Laboratories.