









**Q. When should I use a primer?**




**A.** Use a primer when **both** surfaces are considered inactive. It is necessary to apply the primer to one surface, in most cases, unless gaps are excessive. See chart.

ACTIVE METALS		INACTIVE METALS	
Iron	Bronze	Plated Parts	Cadmium
Plain Steel	Nickel	Anodized Aluminum	Magnesium
Copper	Manganese	(Alodine, Iridite)	Natural or Chemical Black Oxide
Brass	Monel	Titanium	Magnetite Steel
Commercial Aluminum	Kovar	Stainless Steel	Iconel
(with copper content, e.g. 6061)		Galvanized Steel	Silver
		Zinc	Gold
		Pure Aluminum	Plastics

**LOCTITE® BRAND ACCELERATORS/PRIMERS PROPERTIES CHART**

PRODUCT	Item Number	Container	Color	Viscosity, cP	Base	On-Part Life	Dry Time	Application	Agency Approvals
712™ Tak Pak® 	20352 18636 18390	1.75 fl. oz. bottle 0.7 fl. oz. metered mist 1 gal. can	Clear/amber	1	Isopropanol	1 min.	<30 sec.	All cyanoacrylates	MIL-46050C for existing designs, CFIA
770™ Prism® 	18396 18397	1.75 fl. oz. bottle 16 fl. oz. can	Colorless	1.25	Heptane	8 hrs.	30 sec.	All cyanoacrylates	CFIA
793™ Prism® 	18650 20246	1.75 fl. oz. bottle 16 fl. oz. bottle	Clear/ light amber	3	Propylene based glycol ether/water	<2 hrs.	<10 min.	All cyanoacrylates	-
7090™ 	19368 12695	1 fl. oz. bottle 1 liter bottle	Light amber	3	No solvent	1 hr.	<10 min.	Anaerobics	-
7109™ Tak Pak II®	22440 23034	1.75 fl. oz. bottle 1 qt. bottle	Clear/amber	3	Perfluorocarbon	1 min.	<5 sec.	All cyanoacrylates	-
7113™ 	19605 19606	1.75 fl. oz. bottle 1 gal. can	Clear	0.4	Heptane	24 hrs.	1 min.	All cyanoacrylates	-
7452™ Tak Pak® 	18490 18580 18637 18575 18576	1.75 fl. oz. brush-cap bottle 1.75 fl. oz. spray-cap bottle 0.7 fl. oz. metered mist 1 qt. can 1 gal. can	Clear/amber	0.4	Acetone	1 min.	<30 sec.	All cyanoacrylates	MIL-46050C for existing designs
7453™ Tak Pak®	20282	1.75 fl. oz. bottle	Clear/amber	0.4	Acetone (electronic grade)	1 min.	<30 sec.	All cyanoacrylates	-
7471™ Primer T™ 	19267 22477 19268	1.75 fl. oz. bottle 4.5 oz. aerosol can 1 gallon can	Amber	2	Acetone/ Isopropanol	7 days	30-70 sec.	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs
7649™ Primer N™ 	19269 38402 21347 21348 19266	1.75 fl. oz. glass bottle 1.75 fl. oz. aluminum bottle 25 gm aerosol can 4.5 oz. aerosol can 1 gallon can	Clear/green	2	Acetone	30 days	30-70 sec.	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs, NSF/ANSI 61, NSF P1, CFIA

**LOCTITE® BRAND ACTIVATORS PROPERTIES CHART**

PRODUCT	Item Number	Container	Color	Viscosity, cP	Base	On-Part Life	Dry Time	Application
7075™ 	21349 22671	1 qt. can 4.5 oz. aerosol can	Amber	2	Acetone	2 hrs.	3 minutes	324, 325
7380™ Depend® 	19822 19824 19907	1 liter can 1.75 fl. oz. bottle 1 gallon can	Light brown	43	Monomer	2 hrs.	None	Structurals
7387™ Depend® 	18861 18862 21088	1.75 fl. oz. bottle 1 qt. can 4.5 oz. aerosol can	Light brown	1.5	Heptane/Isopropanol	2 hrs.	None	Structurals
25062	25062	1 liter bottle	Thin green/ fluorescent	1.03	Methacrylate	1 hr.	None	Anaerobics on dichromate surfaces

 Indicates worldwide availability.

**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](http://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 at 25°C	Oil Tolerant	Recommended Primer	Specific Gravity	Agency Approvals
220™	37388 39186 22041	10 ml bottle 50 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, ASTM D-5363,** 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, ASTM D-5363,** 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, ASTM D-5363,** 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, ASTM D-5363,** NSF P1, ABS, CFIA
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, ASTM D-5363,** UL Classified 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, ASTM D-5363**
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, ASTM D-5363,** 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

\* Break/loose value. Brookfield RVT spindle 3.20 RPM/25 RPM. \*\* For new designs.

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