Maintenance Solutions Guide for Cat Dealers

2012

Henkel

LOCTITE

CONTENTS

ANTI-SEIZE LUBRICANTS 1

BONDING & REPAIR PRODUCTS 2
ASSEMBLING SEPARATE PARTS

CLEANERS, DEGREASERS & RUST TREATMENTS 4

GASKETING PRODUCTS 6
SEALING OF FLANGES

KITS / SPECIAL PRODUCTS / DISPENSING EQUIPMENT 8

LUBRICANTS 10

METAL REBUILDING & WEAR PREVENTION PRODUCTS 11

PRIMERS 12

RETAINING COMPOUNDS 13
SECURING CYLINDRICAL ASSEMBLIES

THREAD SEALANTS 14

THREADLOCKERS 15

SEAM SEALING & WINDOW GLAZING PRODUCTS 16

APPLICATION Q&As 17

ENGINE APPLICATIONS 21

ADDITIONAL TECH TIPS 23

GLOBAL AVAILABILITY 31

LOCTITE PRODUCT DESCRIPTION INDEX 40

CATERPILLAR PRODUCT NUMBER INDEX 44

ANTI-SEIZE LUBRICANTS

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

ANTI-SEIZE LUBRICANTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	TEMPERATURE RESISTANCE	COLOR	K-VALUE*
LOCTITE C5-A COPPER ANTI-SEIZE LUBRICANT	222-3114 4C-5598 4C-5599 5P-3931	Protects metal parts against high temperature seizing and galling. Versatile application base as it can be used on copper, brass, cast iron, steel and alloys, including stainless steel.	1800°F (982°C)	Copper	0.16
LOCTITE GRAPHITE-50 ANTI-SEIZE	4C-5592 4C-5593 6V-4876, 186-1531	Non-metallic anti-seize lubricant with good electrical conductivity between metal-to-metal joints. Ideal for threaded joints that require electrical conductivity and also for press fit and slip joints.	900°F (482°C)	Black	0.13
LOCTITE MOLY PASTE, METAL-FREE	—	High molybdenum disulfide content of 65% gives it unsurpassed lubricity and low frictional coefficient of 0.06. It is ideal for threaded fasteners that require high clamping force for same torsional load to create reliable assemblies.	750°F (400°C)	Black	0.11
LOCTITE NICKEL ANTI-SEIZE	337-7965	Ideal for protection against seizing and galling of slow moving parts under high pressure. Also easy disassembly of parts exposed to corrosive or hot environments.	2400°F (1315°C)	Silver	0.13
LOCTITE C5-A COPPER ANTI-SEIZE STICK	—	Semisolid stick offers the same performance characteristic as C5-A paste in convenient semisolid stick form. Stick offers more portability and less mess.	1800°F (982°C)	Copper	0.16
LOCTITE SILVER GRADE ANTI-SEIZE STICK	—	Semisolid stick offers the same performance characteristic as Silver Anti-seize paste in convenient semisolid stick form. Stick offers more portability and less mess.	1600°F (871°C)	Silver	0.18

* See K-value below.

Torque Guide

Proper clamp load is an essential part of any bolted assembly for trouble-free operations. Torquing either nut or bolt creates the clamp load. An anti-seize lubricant used on a bolt helps to develop greater clamp load for the same torque compared to a non-lubricated bolt. An additional benefit is greater uniformity in clamp load among a series of bolts. The relationship between torque and clamp load is expressed in the following equation: T = KFD.

Where:

T = Torque (in.-lb., ft.-lb., N-m)
F = Clamp load (lb., N)
D = Nominal diameter of bolt (in., ft., m)
K = Torque coefficient or nut factor, determined experimentally

K Factors: K factors are obtained on grade 8, ½ in. steel bolts and grade 5 nuts by a test procedure that measures torque tension properties. Lubricant was applied to the bolt threads and both faces of the washer.

See the properties chart (above) for the torque coefficient or K-value for the anti-seize compounds.

Henkel Corporation believes that this data fairly represents expected performance. However, Henkel makes no guarantee of specific performance on any individual fastener. In critical applications, it is necessary to determine K-values independently.

Note: There are two "coefficients" used to express the relationship between torque and tension. Torque coefficient (also called "nut factor") is the most commonly used. A different concept is the "friction coefficient," which has a value of ⅔ (or 67%) of the torque coefficient.

BONDING & REPAIR PRODUCTS

- Bond a variety of substrates
- Assemble parts quickly and easily
- Repair broken parts
- Bond dissimilar parts

INSTANT ADHESIVES

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	TYPICAL USE	COLOR	VISCOSITY (cP)	TEMPERATURE RANGE	FIXTURE SPEED
LOCTITE 380 BLACK MAX INSTANT ADHESIVE	152-9155	Rubber-toughened instant adhesive with increased flexibility and enhanced resistance to shock. Bonds variety of substrates like metal, rubber and plastics with excellent peel and shear strength.	Close-fitting parts	Black	300	-65°F to 225°F (-54°C to 107°C)	90 seconds
LOCTITE 401 INSTANT ADHESIVE, SURFACE INSENSITIVE	—	Designed for the assembly of difficult-to-bond materials, which require uniform stress distribution and strong tension and/or shear strength. The product provides rapid bonding of a wide range of materials like metals, plastics and elastomers. Also suited for bonding porous materials such as wood, paper, leather and fabric.	General-purpose	Clear	110	-65°F to 180°F (-54°C to 82°C)	15 seconds
LOCTITE 406 INSTANT ADHESIVE	—	Designed for bonding of plastics and elastomeric materials where very fast fixturing is required. Quick setting feature makes it ideal for temporary 'O' rings making.	Wicking grade	Clear	20	-65°F to 180°F (-54°C to 82°C)	15 seconds
LOCTITE 410 INSTANT ADHESIVE, TOUGHENED	—	Rubber-toughened instant adhesive for higher gap filling with increased flexibility and peel strength along with enhanced resistance to shock.	Gap filling	Black	3,500	-65°F to 225°F (-54°C to 107°C)	90 seconds
LOCTITE 411 INSTANT ADHESIVE	—	General-purpose, gap filling instant adhesive suitable for bonding rubber, plastic and metals. Exhibits excellent peel strength and added heat resistance.	Gap filling	Clear	5,000	-65°F to 210°F (-54°C to 99°C)	30 seconds
LOCTITE 414 INSTANT ADHESIVE	157-7228	General-purpose instant adhesive for bonding plastics, rubber and metal.	Plastic bonder	Clear	110	-65°F to 180°F (-54°C to 82°C)	20 seconds
LOCTITE 426 INSTANT ADHESIVE, BLACK, TOUGHENED GEL	—	Designed for porous substrates and vertical or overhead applications with added benefits provided by elastomer-modified instant adhesive. It exhibits impact and peel strength along with improved resistance to heat and humidity.	Porous surfaces	Black	Gel	-65°F to 210°F (-54°C to 99°C)	20 seconds
LOCTITE 454 INSTANT ADHESIVE	—	Designed for the assembly of difficult-to-bond materials which require uniform stress distribution and strong tension and/or shear strength. Particularly suited for bonding porous and absorbent materials. Exhibits faster cure speed on dry and acidic surfaces.	Porous surfaces	Clear	Gel	-65°F to 180°F (-54°C to 82°C)	15 seconds
LOCTITE 480 INSTANT ADHESIVE, BLACK, TOUGHENED	—	Low viscosity, elastomer-modified instant adhesive. Bonds metal and rubber. Excellent peel, impact and shear strength with enhanced resistance to shock.	General filling	Black	200	-65°F to 180°F (-54°C to 82°C)	90 seconds
LOCTITE 495 INSTANT ADHESIVE	—	General-purpose instant adhesive for bonding variety of substrates.	General-purpose	Clear	45	-65°F to 180°F (-54°C to 82°C)	20 seconds
LOCTITE 496 INSTANT ADHESIVE	—	General-purpose instant adhesive and is particularly suited to bonding of metal, rubber and plastic substrates	General-purpose rubber bonder	Clear	125	-65°F to 180°F (-54°C to 82°C)	30 seconds
LOCTITE 498 INSTANT ADHESIVE	—	General-purpose adhesive suitable for applications where heat resistance is required. It is formulated to resist thermal cycling and exhibits superior resistance to humidity.	Thermal cycling	Clear	500	-65°F to 180°F (-54°C to 82°C)	50 seconds
LOCTITE QUICKTITE GEL	—	Designed for the rapid bonding of a wide range of materials, including metals, plastics and elastomers. Particularly suited for bonding porous or absorbent materials such as wood, paper, leather and fabric.	Porous surfaces	Clear	Gel	-65°F to 180°F (-54°C to 82°C)	45 seconds

BONDING & REPAIR PRODUCTS

CONTINUED

STRUCTURAL ADHESIVES

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	FEATURES	WORK LIFE	FIXTURE TIME	CURE TIME	SHEAR STRENGTH* (psi)	TEMPERATURE RESISTANCE
LOCTITE FIXMASTER FAST CURE EPOXY MIXER CUPS	266-3144	Premeasured epoxy mixer cups are ideally suited for applications requiring only small amount of epoxy. Fills porosity and cracks. Adheres to metal, glass, wood and hard plastics. Sets in 5 minutes.		5 minutes	10 minutes	12 hours	2,000	180°F (82°C)
LOCTITE FIXMASTER GENERAL-PURPOSE EPOXY MIXER CUPS	—	Premeasured epoxy mixer cups are ideally suited for applications requiring only small amount of epoxy. Fills porosity, cracks and may be used for rebuilding of worn-out parts. Adheres to metal, glass, ceramic, most plastics, wood and stone. Sets in 5 minutes.		1.5 hours	—	24 hours	4,000	
LOCTITE 3034 STRUCTURAL ADHESIVE, TOUGHENED, POLYOLEFIN BONDING, 2-PART ACRYLIC	—	Bonds wide variety of substrates like fiberglass, thermoplastics, polycarbonates, ABC, PVC, low and high density polyethylene. Extended open time allows adjustment of parts.	Toughened	13 minutes	75** minutes (HDPE)	72 hours	≥1,160	—
LOCTITE 332 STRUCTURAL ADHESIVE SEVERE ENVIRONMENT	—	Activator-cured, no-mix structural adhesive that provides high temperature and chemical resistance.	No Mix/ Small Gap	N/A	3 minutes	24 hours	3,000	400°F (204°C)
LOCTITE H3000 STRUCTURAL ADHESIVE	209-0987	Low viscosity, two-component methacrylate adhesive having excellent bond strength on variety of substrates with minimum surface preparation. It maintains resilient bond over wide range of temperatures with excellent environmental resistance.	High Strength	5 minutes	15 minutes	24 hours	4,150	—

SPECIALTY ADHESIVES

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	TEMPERATURE RANGE	FIXTURE/BOND TIME	FULL CURE
LOCTITE 330 DEPEND ADHESIVE	308-3506, 185-4003	One-component, high viscosity acrylic adhesive for bonding wide range of materials including wood, metal, ferrite, ceramic and plastics.	250°F (121°C)	5 minutes	24 hours
LOCTITE BLACK CONTACT ADHESIVE	5H-2471, 185-4591	Solvent-based adhesive with neoprene. Withstands temperatures and resistant to gasoline, kerosene, and other solvents. Fast drying and waterproof. Allows repositioning of parts after initial contact.	Up to 180°F (82°C)	Let breathe 2-3 minutes; sets in 5-15 minutes.	24 hours
LOCTITE CONTACT ADHESIVE	—	Solvent-based, general-purpose contact cement with neoprene rubber. Used for all types of weather stripping, porous and nonporous surfaces. Repositionable after initial assembly.	Up to 180°F (82°C)	Let breathe 2-3 minutes; sets in 5-15 minutes.	24 hours
LOCTITE MAXIMUM STRENGTH HEADLINER ADHESIVE	—	A high strength aerosol product designed for bonding foam, carpet, fabric, plastic, rubber, etc. Resistant to extreme seasonal temperature, is water resistant and sprays on clear.	Up to 170°F (77°C)	Let dry 15-20 minutes before assembly. Spray both sides to be bonded for maximum strength.	24 hours
LOCTITE ALL-PURPOSE SPRAY ADHESIVE	222-3113	Solvent-based, general-purpose contact cement with neoprene rubber. Used for all types of weather stripping, porous and nonporous surfaces. Repositionable after initial assembly.	Up to 170°F (77°C)	Let dry 15-20 minutes before assembly. Spray both sides to be bonded for maximum strength.	24 hours

* Grit-blasted steel.
** HDPE.

CLEANERS, DEGREASERS & RUST TREATMENTS

CLEANERS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	FUNCTION	APPLICATION
LOCTITE ODC-FREE CLEANER & DEGREASER	—	Non-aqueous, hydrocarbon based, non-CFC solvent for cleaning and degreasing of surfaces to be bonded with LOCTITE adhesives. Removes most greases, oils, lubrication fluids, metal cuttings and fines from all surfaces. It can be used as a spray or in immersion cleaning processes at room temperature or heated. (Formerly referenced as 7070.)	Removes grease, oil, lubrication fluids, metal cuttings and filings from parts, equipment and machinery.	Use as a spray or in immersion cleaning processes, at room temperature or heated. Recommended as a final pre-assembly cleaning treatment for all surfaces bonded with adhesives.
LOCTITE CHISEL PAINT STRIPPER, METHYLENE CHLORIDE	—	Removes gasket from any type of assembly in 10 to 15 minutes. Prepares metal parts for new gaskets, eliminating, scraping and sanding. Works on wood; noncorrosive on aluminum.	Removes precut conventional gasket cements as well as formed-in-place chemical gaskets.	Removes silicones, baked-on gaskets, gaskets from aluminum, small difficult-to-reach components, weather-stripping adhesive, dried oil, grease, paint and varnish.
LOCTITE CHISEL MC-FREE PAINT STRIPPER	—	Free from methylene chloride (MC). Has foaming action that lifts off gaskets from any 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. Convenient spray liquid penetrates and clean intricate shapes.	Removes precut conventional gasket cements as well as formed-in-place chemical gaskets.	Removes silicones, baked-on gaskets, gaskets from aluminum, small difficult-to-reach components, weather-stripping adhesive, dried oil, grease, paint and varnish.
LOCTITE NATURAL BLUE BIODEGRADABLE CLEANER & DEGREASER, ALL-PURPOSE	—	It can be economically diluted with water in different rations based upon cleaning requirements. Formulated for wipe down, pressure spraying and immersion cleaning processes. Contains no ozone-depleting chemicals.	Removes grease, grime, oil, soot, cutting fluids, mildew, stains, light carbon, animal fat, polishing compounds and ink.	Cleans engine parts, ovens, exhaust hoods and drilling rigs. Can be diluted for general wipe-down cleaning. Formulated for pressure spraying and immersion cleaning processes, at room temperature or heated.
LOCTITE NON-CHLORINATED PARTS CLEANER	222-3117 222-3118	Penetrates, dissolve and removes dirt and oxidized oil (gum) and asphalt from metal parts. Leaves no residue. It penetrates through dirt and corrosion and flushes them away; eliminates the need for disassembly. Ideal for aluminum surfaces.	Cleaner for removing oil, grease and asphalt with no chlorinated solvent runoff.	All-purpose metal parts cleaner. Ideal for aluminum surfaces.
LOCTITE ELECTRICAL CONTACT CLEANER, NONFLAMMABLE	222-3124, 222-3119	Removes grease, oil, and other contaminants from electrical parts to prevent contact failure. Dries residue-free in seconds. Nonconductive, noncorrosive, nonflammable. Contains no CFC or class 1 ozone-depleting chemicals.	Removes grease, dirt, oil, flux and surface contaminants from sensitive electrical/electronic devices. Also used for equipment requiring nonconductive, low residue degreasing agents. Contains HCFC-141b. Nonflammable.	Switches, relays, motor controls, pc boards, connectors, tape heads, sensors, control panels and electrically driven equipment.
LOCTITE PRO STRENGTH PARTS CLEANER	—	Aggressively penetrates, dissolves and removes oil and grease from parts. Dries quickly with no residue. Contains no ozone-depleting chemicals.	Removes oil, grease, brake fluids, oxidized oils (gum) and asphalt. Penetrates through dirt and corrosion and flushes them away.	All-purpose metal parts cleaner.
LOCTITE INDUSTRIAL HAND WIPES	—	Hand cleaners that remove tough grease and grime while premium skin conditioners and antiseptic agents keep sensitive hands protected and conditioned.	Remove grease, grime, inks, soil, paint, gasket cements, epoxies and glues.	Available in various formats in various countries; wipes, smooth liquid, and liquid with pumice. *Contact your local Henkel representative for availability in your region.*
LOCTITE HANDCLEANER WITH PUMICE	—			
LOCTITE SMOOTH HANDCLEANER	—			

CLEANERS, DEGREASERS & RUST TREATMENTS

CONTINUED

CLEANERS (CONTINUED)

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	DRY TIME	APPLICATION METHOD
LOCTITE 7012	—	Multipurpose cleaner for mechanical parts, tools and machines. It can be used for cleaning of all substrates like metals, rubbers and painted surfaces. Cleans soils, grease, oil and all kind of dirt. Can be used in spray, brush or manual.		
LOCTITE 7013	—	Water-based cleaner for cleaning of mechanical parts in small spray parts washers (cleaning table) at room temperature. It can be used on all metals, synthetic materials, rubber and painted surfaces. Provides temporary corrosion protection for intermediate storage of cleaned parts.		
LOCTITE 7018	—	A very efficient heavy duty cleaner for mechanical parts made of iron or light metals like aluminum. Suitable for high pressure cleaning applications. Provides good foaming properties and temporary corrosion protection.		
TURCO WHITE SOLVE 'EC' ELECTRICAL CONTACT CLEANER	—	Removes grease, oil, and other contaminants from electrical parts to prevent contact failure. Dries residue free in seconds.		
YUK-OFF BRAKE AND PARTS CLEANER	—	This non-chlorinated cleaner instantly removes fluids, grease and dirt, leaving no contaminant-attracting residue.		

SURFACE TREATMENT PRODUCTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	DRY TIME	APPLICATION METHOD
LOCTITE EXTEND RUST TREATMENT	—	Converts existing rust into stable base (rust required). Cured product acts as primer with oil- or solvent-based paints. Protects from further corrosion.	Re-coat in 20 minutes	Brush or commercial sprayer
LOCTITE MAXI-COAT, RUST INHIBITOR	222-3121	Heavy duty waxy coating provides long term corrosion protection for metal parts, equipment and machinery. Great for protecting parts in storage.	3 to 6 hours	Brush on

GASKETING PRODUCTS

SEALING OF FLANGES

- Provide precise, reliable sealing
- 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
- Resist high pressure when fully cured

SILICONE GASKETING PRODUCTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	COLOR	TEMPERATURE RANGE (Intermittent)	SEALING TIME
LOCTITE 5699 GREY HIGH PERFORMANCE RTV SILICONE GASKET MAKER	—	For rigid flange assemblies. Provides excellent sealing and oil resistance on flanges of transmissions and cast iron housings.	Grey	-75°F to 625°F (-59°C to 329°C)	Tack-free – 30 minutes Full Strength – 24 hours
LOCTITE 587 BLUE HIGH PERFORMANCE RTV SILICONE GASKET MAKER	141-5831	Forms tough, flexible gaskets directly on the flange. Offers excellent adhesion on oily surfaces. Low odor, nonvolatile and noncorrosive. Resistant to most chemicals and solvents.	Blue	-75°F to 500°F (-59°C to 260°C)	Tack-free – 30 minutes Full Strength – 24 hours
LOCTITE 598 BLACK HIGH PERFORMANCE RTV SILICONE GASKET MAKER	4C-9612	Retains high flexibility and oil resistance for longer gasket life. Low odor, noncorrosive, low volatility. Resistant to most chemicals and solvents.	Black	-75°F to 625°F (-59°C to 329°C)	Tack-free – 30 minutes Full Strength – 24 hours
LOCTITE 5900 FLANGE SEALANT	165-2601 8T-0065, 186-1527	Superior flexibility and adhesion. Provides excellent seal and fluid resistance. Noncorrosive, low odor, low volatility.	Black	-65°F to 500°F (-54°C to 260°C)	—
LOCTITE 5999 FLANGE SEALANT	—	Intended for design, service, manufacture and rebuild applications, especially in automotive powertrain applications. Provides instant seal. Excellent fluid resistance. Noncorrosive, low odor, low volatility.	Grey	-75°F to 625°F (-59°C to 329°C)	
LOCTITE INSTANT GASKET	—	Makes high performance, leak-proof gaskets in one minute. Equipment can be returned to service immediately. Blow-off resistant. Outperforms solid gaskets.	Black	-75°F to 500°F (-59°C to 260°C)	Operating strength 15 psi – 1 minute
LOCTITE SUPERFLEX 593 RTV SILICONE SEALER, BLACK	3S-6252, 185-3986	Superior bonding and sealing properties to most surfaces (not recommended for concrete). This product resists aging, weathering and thermal cycling without hardening or shrinking.	Black	-65°F to 450°F (-54°C to 232°C)	
LOCTITE SUPERFLEX 595 RTV SILICONE ADHESIVE, CLEAR	119-0781	Superior bonding and sealing properties to most surfaces. This product resists aging, weathering and thermal cycling without hardening or shrinking. Resistance to UV light and ozone makes it suitable for open or exposed conditions.	Clear	-65°F to 450°F (-54°C to 232°C)	
LOCTITE SUPERFLEX 596 HIGH TEMP RTV SILICONE ADHESIVE, RED	4C-9614 8T-9013, 205-8857	Withstands high temperature and has excellent solvent and chemical resistance. Fills gaps up to 0.010 in. (0.254 mm). Maintains clamping loads for strong, leak proof assemblies. Makes or dresses gaskets in rigid assemblies.	Red	-75°F to 600°F (-59°C to 316°C)	
LOCTITE SUPERFLEX RTV SILICONE ADHESIVE SEALANT, BLACK	141-5830	Black in color, general-purpose silicone adhesive sealant. Will not slump in overhead or vertical applications. Resistance to extreme thermal cycling, UV light and ozone makes it suitable for open or exposed applications.	Black	-65°F to 450°F (-54°C to 232°C)	
LOCTITE SUPERFLEX RTV SILICONE ADHESIVE SEALANT, BLUE	8T-9022, 185-3987	Blue in color, general-purpose silicone adhesive sealant. Will not slump in overhead or vertical applications. Resistance to extreme thermal cycling, UV light and ozone makes it suitable for open or exposed applications.	Blue	-65°F to 500°F (-54°C to 260°C)	
LOCTITE SUPERFLEX RTV SILICONE ADHESIVE SEALANT, RED	—	Makes gasket that have high temperature resistance. Resists aging, thermal cycling without shrinkage.	Red	-75°F to 600°F (-59°C to 316°C)	
LOCTITE SUPERFLEX NONCORROSIVE RTV SILICONE ADHESIVE, CLEAR	8T-9014, 205-8858	General-purpose clear silicone adhesive sealant. Will not slump in overhead or vertical applications. Resistance to extreme thermal cycling, UV light and ozone makes it suitable for open or exposed applications.	Clear	-65°F to 450°F (-54°C to 232°C)	

GASKETING PRODUCTS

CONTINUED

ANAEROBIC GASKETING PRODUCTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	TEMPERATURE RANGE	FIXTURE / CURE TIME
LOCTITE 5127 FLEXIBLE ANAEROBIC GASKET FLANGE SEALANT	4C-5300, 185-3984	Flexible anaerobic gasketing compound that exhibits high elongation properties. Flexes with flange movement caused by vibration, pressurization, or thermal change.	-65°F to 300°F (-54°C to 150°C)	Primed – 1 to 24 hours Unprimed – 4 to 24 hours
LOCTITE 515 FLANGE SEALANT	—	Makes flexible gaskets for rigid machine flanges with less than 0.050" (1.27 mm) gap. Provides resistance to low pressures immediately after assembly of flanges. Flexes with flange movement caused by vibration, pressurization, or thermal change.	-65°F to 300°F (-54°C to 150°C)	Unprimed – 1 to 12 hours Primed – 15 minutes to 2 hours
LOCTITE HIGH FLEX FORM-IN-PLACE GASKET	1U-8846, 185-3983	Flexible form-in-place gasket that provides high temperature resistance and more flexibility. Fills gaps to 0.020" (0.5 mm) and cures to a tough solvent resistant gasket that flexes with flange movement caused by vibration, pressurization, or thermal change.	-65°F to 500°F (-54°C to 260°C)	Sets in 5 minutes
LOCTITE HI-TEMPERATURE FLANGE SEALANT	6V-6640, 185-3985	Withstands high temperature and has excellent solvent and chemical resistance. Fills gaps up to 0.010" (0.254 mm). Maintains clamping loads for strong, leak-proof assemblies. Makes or dresses gaskets in rigid assemblies.	-65°F to 350°F (-54°C to 149°C)	Full Strength – 24 hours
LOCTITE 534 HI-TACK GASKET DRESSING STICK	—	Tacking/dressing compound used in conjunction with cork and cut gaskets. Holds gasket in place during assembly. Wax-like semisolid, conveniently packaged in a self-feeding stick applicator.	-65°F to 300°F (-54°C to 150°C)	Sets in 5 minutes
LOCTITE 548 FLANGE SEALANT STICK	—	Sealing on rigid flanges, for example on transmissions and cast metal housings. It is supplied as a wax-like semisolid, conveniently packaged in a self-feeding stick applicator.	-65°F to 300°F (-54°C to 150°C)	Less than 3 hours with or without a primer

SOLVENT GASKETING PRODUCTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	TEMPERATURE RANGE	CURE TIME
LOCTITE 5923 AVIATION GASKET SEALANT	4C-9505	Reliable, liquid gasket sealant, dressing and coating. Thin brushable dressing and sealant for close-fitting parts. Resistant to gasoline and other solvents.	-65°F to 400°F (-54°C to 204°C)	Full Strength – 12 hours
LOCTITE GASKET SEALANT #1	4C-9501	Reliable paste-like gasket sealant, dressing and coating. Extends gasket life and prevents leakage when used for gasket dressing.	-65°F to 400°F (-54°C to 204°C)	Full Strength – 12 hours
LOCTITE GASKET SEALANT #2	4C-9502	Reliable paste-like gasket sealant, dressing and coating. Sets slowly to pliable film. Best for nonrigid vibrating assemblies. Increases reliability of gasket seals.	-65°F to 400°F (-54°C to 204°C)	Remains tacky
LOCTITE HI-TACK GASKET SEALANT	138-8436, 185-4590	Solvent-based gasket dressing liquid that also holds gasket in place during assembly. Sets quickly to very tacky film and enhances life of solid gaskets. Contains no ozone-depleting compounds.	-65°F to 500°F (-54°C to 260°C) [aerosol to 600°F/316°C]	

TYPE OF FLANGE SEALING	SOLUTIONS	BENEFITS
MACHINED / RIGID FLANGES	Anaerobic Gasket	• Allows for metal-to-metal contact • Eliminates gasket "compression set" • Fills surface imperfections that leads to leaks • Highly resistant up to 400°F (205°C) • Fills gaps up to 0.500" • Can be used to tack cut gaskets
STAMPED / FLEXIBLE FLANGES	Silicone Gaskets	• Flexible sealant • Resists temperature up to 700°F (370°C) • Fills large gaps up to 0.250"
FLANGES WITH CUT GASKETS	Solvent Gaskets	• Tack gasket in place • Gasket shellac • Fast setting

KITS / SPECIAL PRODUCTS / DISPENSING EQUIPMENT

CONCRETE REPAIR PRODUCTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	MAXIMUM TEMPERATURE	COMPRESSIVE STRENGTH (psi)	WORKING TIME
LOCTITE FIXMASTER MAGNA-CRETE	—	A two-component, rapid setting concrete repair and grouting system. Functional cure in just 1 hour and attains compressive strength much higher than concrete when fully cured. It bonds to old and new concrete and most other construction materials.	2,000	13,000	5 to 20 minutes

DISPENSING EQUIPMENT

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	USED TO DISPENSE	MIX RATIOS
50 ML MIX NOZZLE, 6.0 MM, STEPPED TIP, 10:1 RATIOS-S STYLE CARTRIDGE (USED WITH 50 ML DUAL CQ)	—	Stepped Tip, 6.2" Overall Length, 6.5 mm ID, 20 elements; 10:1-S cartridges only.	Two-Component Epoxies, Urethanes, Methacrylates	10:1
HAND HELD DUAL CARTRIDGE DISPENSE FOR 50 ML (USED WITH 50 ML DUAL CQ)	—	—	Two-Component Epoxies, Urethanes, Methacrylates	E-04SS
LOCTITE 400 ML CARTRIDGE MANUAL DISPENSER	—	—	Two-Component Epoxies, Urethanes, Methacrylates	E-04SS
LOCTITE CONVERTER KIT, FOR HOUSEHOLD CAULKING GUN, ACCEPTS 50 ML	—	Allow the use of a standard 300 ml caulking to dispense LOCTITE 50 ml 2-part epoxy cartridges.	Two-Component Epoxies, Urethanes, Methacrylates	
LOCTITE LUER/STEPPED NOZZLES FOR 50 ML – STRUCTURAL ADHESIVE (10 PER PACK)	—	—		
LOCTITE STATIC MIXER NOZZLE, MC08-24 1:1/2:1	—	—		E-04SS
NEEDLE, 18GA, ¼" SS, GRN, 50PK	—	—		

LAPPING / MACHINING COMPOUNDS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	GRADE	GRIT
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 80 GRIT	226-6624	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.	G	80
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 240 GRIT		Medium-fine grit typically used for cylinder lapping.	B	240
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 400 GRIT		Very fine grit for fine polishing and lapping.	2A	400
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 800 GRIT		Extremely fine grit for polishing and high precision lapping.	5A	800

KITS / SPECIAL PRODUCTS / DISPENSING EQUIPMENT

CONTINUED

SEALANTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION
LOCTITE INSULATING & SEALING WRAP, BLACK, 2" x 36'	—	Non-sticky, self-fusing, multipurpose wrap. Insulate electrical, seals, leaks, improve grip. It can withstand extreme conditions, such as salt water, fuel and acid fluid exposure and wide temperature range.
LOCTITE INSULATING & SEALING WRAP, BLACK, 1" x 10'	—	Non-sticky, self-fusing, multipurpose wrap. Insulate electrical, seals, leaks, improve grip. It can withstand extreme conditions, such as salt water, fuel and acid fluid exposure and wide temperature range.
LOCTITE INSULATING & SEALING WRAP, RED, 1" x 10'	—	Non-sticky, self-fusing, multipurpose wrap. Insulates electrical, seals leaks, improves grip. It can withstand extreme conditions, such as salt water, fuel and acid fluid exposure and wide temperature range.

KITS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION
LOCTITE O-RING MAKING KIT	—	Makes replacement, high performance 'O' rings in less than a minute. It even eliminates the need for inventory of different sized O-rings. Joints made with LOCTITE 404 or 406 are as strong as rubber itself.
LOCTITE SEMISOLID STICK EMPTY HOLSTER, PROMO ITEM WHILE SUPPLIES LAST	—	Holds the self-feeding stick applicator products.
LOCTITE TOOLBOX (CONTAINS 220, 222, 243, 263, 248, 249, 268, 518, 545, 561, 565, 587, 660, 7649, 404, 7088, C5-A)	—	It contains 16 of the latest and best LOCTITE technologies to solve the most common mechanical failures. This kit has everything that a professional needs to increase reliability at base-component level.
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 1,538 lbs. on torque (on 1 in bolt). Resists most shop fluids.

LUBRICANTS

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

LUBRICANTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	TEMPERATURE RESISTANCE
LOCTITE DIELECTRIC GREASE	—	Silicone dielectric compound prevents leakage around an electrical connector, such as a spark plug boot, thereby ensuring a strong spark in a high energy ignition system. Translucent paste. An excellent lubricant on rubber, plastic and ceramic surfaces. Corrosion resistant.	400°F (204°C)
LOCTITE FREEZE & RELEASE	—	Light mineral oil-based penetrant with freezing effect. Shock freezing effect will instantly cool parts down to -43°C and cause microscopic cracks in the layer of rust, allowing the penetrating oil to wick into the rust.	N/A
LOCTITE GEAR, CHAIN & CABLE LUBRICANT	222-3110	Foaming action permits fast, deep penetration. Formulated to reduce “throw off” from centrifugal force. Repels dirt, sand and dust. Clear color. Does not contain CFC.	250°F (121°C)
LOCTITE MOLY DRY FILM LUBRICANT	242-6990	Withstands high temperatures and high static loads. Will not attract dirt or dust. Heavy duty lubricant, ideal for continuous sliding friction applications.	750°F (400°C)
LOCTITE PENETRATING OIL	222-3123	Brown liquid aerosol penetrating oil. Protects tools against rust. Dries wet metal parts in minutes.	
LOCTITE SILICONE LUBRICANT	—	Translucent silicone grease. A non-curing silicone paste that seals, lubricates, protects and waterproofs metal, rubber and plastic parts. Water and steam resistant. High and low temperature stability.	400°F (204°C)
LOCTITE SOLVO-RUST SUPER PENETRATING OIL	222-3115	Clear liquid aerosol penetrating oil. Will not affect painted surfaces. Low surface tension. Does not contain CFC.	250°F (121°C)
LOCTITE VIPERLUBE HIGH PERFORMANCE SYNTHETIC GREASE	—	NLGI Grade 2/Severe Duty GC-LB, PAO based, advanced multipurpose grease. Excellent where wide range of operating temperatures and environments are encountered.	400°F (204°C) continuous 500°F (260°C) intermittent

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

METAL REBUILDING & WEAR PREVENTION PRODUCTS

METAL-FILLED REPAIR EPOXIES

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	MAXIMUM TEMPERATURE	COMPRESSIVE STRENGTH (psi)	HARDNESS (SHORE D)	WORKING TIME	FUNCTIONAL CURE
LOCTITE FIXMASTER FAST SET STEEL PUTTY	1U-6140, 207-7532	Steel reinforced epoxy. Hardens in 10 minutes. Cures to a metal-like finish. Non sagging.	200°F (93°C)	10,800	80	3 minutes	10 minutes
LOCTITE FIXMASTER METAL MAGIC STEEL	8T-9018 8T-9019	Epoxy stick that applies like a putty and cures to a steel-like finish. No measuring or mixing tools required. Cures in 10 minutes. Knead by hand and apply.	250°F (121°C)	12,000	80	3 minutes	10 minutes
LOCTITE FIXMASTER SUPERIOR METAL	1U-6136, 207-7530	An epoxy filled with ferro-silicon, a noncorrosive ferroalloy. Resists corrosion, abrasion, and chemical attack. High adhesion and can be machined once cured.	225°F (107°C)	13,500	86	25 minutes	6 hours

WEAR-RESISTANT COATINGS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	MAXIMUM TEMPERATURE	WORK LIFE	FULL CURE
LOCTITE FIXMASTER WEAR RESISTANT PUTTY	1U-6132, 207-7531	An epoxy filled with ceramic fibers to provide excellent wear and abrasion resistance. Will not sag or shrink.	200°F (93°C)	3 minutes	7 hours
LOCTITE FIXMASTER FLEX 80 PUTTY	144-7779	Thick black liquid. Flexible coating that resists abrasion, impact, and corrosion. Unaffected by oil, grease or water. Ideal for repairing and protecting metal, rubber and urethane parts that are subject to impact abrasion.	180°F (82°C)	10 minutes	8 hours

PRIMERS

- Adhesion promoter
- Nonflammable and noncombustible formulas
- Brush and wipe application options

ANAEROBIC PRIMERS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	COLOR	VISCOSITY (cP)	BASE	ON-PART LIFE	APPLICATION
LOCTITE 7088 PRIMER STICK	—	A paste primer contained in a self-feeding stick package. Designed to promote the cure speed of LOCTITE anaerobic products. Particularly useful in applications with passive metals or inert surfaces and cold parts.	Teal	Semisolid	No solvent	30 days	Anaerobics
LOCTITE 7090 PRIMER/ ACTIVATOR, SOLVENTLESS	—	A solventless primer/activator for LOCTITE anaerobic products. Can be sprayed or brushed on.	Dark Blue	17.5	No solvent	1 hour	Anaerobics
LOCTITE 7091 PRIMER (FOR DICHROMATED SURFACES)	—	A solventless primer/activator for LOCTITE anaerobic products, designed particularly for dichromated surfaces. For use in difficult-to-bond applications where galvanized steel or zinc electroplated surfaces are involved.					
LOCTITE 7649 PRIMER N	169-5464, 185-4004	Primer/activator for anaerobic products. Solvent based. Can be sprayed or brushed on. Speeds the anaerobic cure, increases cure through depth, allows for curing on inert metal surfaces, and particularly useful on cold parts.	Clear/ Green	2	Acetone	30 days	Anaerobics

SURFACE PRIMERS

LOCTITE Surface Primers are used with LOCTITE Instant Adhesives to increase adhesion strengths to difficult-to-bond substrates, which include polyethylene, polypropylene, PTFE and thermoplastic rubber materials. To obtain the highest performance, assemblies should be bonded shortly after surface primer base flashes off.

CYANOACRYLATE PRIMER

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	COLOR	VISCOSITY (cP)	BASE	ON-PART LIFE	DRY TIME	APPLICATION
LOCTITE 770 PRIMER (FOR CYANOACRYLATES)	—	Primer for LOCTITE cyanoacrylate adhesives (instant adhesives). Designed to make polyolefin and other low energy surfaces suitable for bonding with LOCTITE cyanoacrylate adhesives.	Colorless	1.25	Heptane	8 hours	30 seconds	All Cyanoacrylates

Tech Tip

WHEN SHOULD I USE A LOCTITE PRIMER FOR ANAEROBICS (THREADLOCKERS, THREAD SEALANTS, GASKETING AND RETAINING)?

Speed up cure – Significantly speed up the cure time of LOCTITE threadlockers when assembling metal parts that are cold, have large gaps or deep threads.

Inactive metal assemblies – When assembling metal parts with inactive surfaces, LOCTITE primers are recommended to ensure proper performance of LOCTITE threadlockers.

INACTIVE METALS* (PRIMERS RECOMMENDED)		ACTIVE METALS (PRIMERS OPTIONAL)
Plated Parts	Silver	Iron
Anodized Aluminum (Alodine, Irridite)	Gold	Plain Steel
Titanium	Zinc	Copper
Stainless Steel	Pure Aluminum	Brass
Galvanized Steel	Cadmium	Bronze
Magnetite Steel	Magnesium	Nickel
Inconel™	Natural or Chemical Black Oxide	Manganese
		Monel™
		Kovar™

*** Please note:** LOCTITE Anaerobic Machinery Adhesives cure in the absence of air and presence of metal ions. When assembling inactive metal parts, which are low in metal ions, the use of LOCTITE Primers are recommended to ensure proper performance of LOCTITE Anaerobic Machinery Adhesives.

RETAINING COMPOUNDS

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

RETAINING COMPOUNDS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	MAX. GAP FILL (DIAMETER)	VISCOSITY (cP)	TEMPERATURE RANGE	CURE SPEED
LOCTITE 232 RETAINING COMPOUND, WHEEL MOUNT, HIGH LUBRICITY, LOW STRENGTH	—	Medium strength retaining compound designed with lubricating properties to facilitate assembly when heavy interference or high torque values are utilized. Prevents galling and pick-up during disassembly.	0.004"	3600 - 8800	-65°F to 300°F (-54°C to 150°C)	Fixture – 4 - 6 minutes Full – 72 hours
LOCTITE 540 ADHESIVE/SEALANT, CUP/CORE PLUG	—	High strength sealant designed for sealing engine block cup and core plugs and many other high strength sealing applications where nonmigration is required.	N/A	7,000 - 12,000	-65°F to 300°F (-54°C to 150°C)	N/A
LOCTITE 603 RETAINING COMPOUND	—	High strength, oil tolerant, for close-fitting cylindrical parts.	0.005"	100 - 150	-65°F to 300°F (-54°C to 150°C)	Fixture – 25 minutes Full – 24 hours
LOCTITE 609 RETAINING COMPOUND, PRESS FIT, GENERAL-PURPOSE	4C-4032 7M-7456, 185-3994	Medium strength for press fitted parts	0.005"	125	-65°F to 300°F (-54°C to 150°C)	Fixture – 10 minutes Full – 24 hours
LOCTITE 620 RETAINING COMPOUND, SLIP FIT, HIGH TEMPERATURE	4C-9506 4C-9507, 185-3988	High strength, high temperature resistance, for slip fitted parts	0.015"	8,500	-65°F to 450°F (-54°C to 232°C)	Fixture – 30 minutes Full – 24 hours
LOCTITE 638 RETAINING COMPOUND, SLIP FIT, MAXIMUM STRENGTH	—	High strength retaining compound for slip fitted parts.	0.015"	2,500	-65°F to 300°F (-54°C to 150°C)	Fixture – 5 minutes Full – 24 hours
LOCTITE 640 RETAINING COMPOUND	—	High strength, high temperature retaining compound.	0.007"	600	-65°F to 400°F (-54°C to 204°C)	Fixture – 30 minutes Full – 24 hours
LOCTITE 648 RETAINING COMPOUND, PRESS FIT, HIGH STRENGTH, RAPID CURE	—	High strength, rapid curing, higher temperature resistance retaining compound for press fitted cylindrical parts.	0.006"	500	-65°F to 300°F (-54°C to 150°C)	Fixture – 5 minutes Full – 24 hours
LOCTITE 660 RETAINING COMPOUND, PRESS FIT	269-1943	Designed for the bonding of cylindrical parts, particularly where bond gaps can approach 0.50 mm (0.02").	0.020"	250,000/ 1,500,000 Thixotropic	-65°F to 300°F (-54°C to 150°C)	Fixture – 20 minutes Full – 24 hours
LOCTITE 668 RETAINING COMPOUND STICK	—	Medium strength, high temperature resistance wax-like retaining compound in a self-feeding stick applicator.	0.005"	Semisolid	-65°F to 400°F (-54°C to 204°C)	Fixture – 30 minutes Full – 24 hours

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

THREAD SEALANTS

THREAD SEALANTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	VISCOSITY	TEMPERATURE RANGE	PRESSURE RESISTANCE (psi)
LOCTITE HEAD BOLT & WATER JACKET SEALANT	—	Medium strength threadlocker and thread sealant, designed to provide lubricity during disassembly of fasteners that are through-holes into water jackets.	Paste	-65°F to 300°F (-53°C to 148°C)	10,000
LOCTITE 536 LOW BREAKLOOSE PIPE SEALANT	5P-3413, 185-3992	High temperature resistant thread sealant that is designed to provide low breakaway torque even when the threads are exposed to continuous heat.	Paste	-65°F to 300°F (-53°C to 148°C)	10,000
LOCTITE 545 THREAD SEALANT, HYDRAULIC/PNEUMATIC FITTINGS	—	Designed for the locking and sealing of hydraulic and pneumatic metal pipes and fittings. Formulated to offer lubricity for easy assembly.	14,000	-65°F to 300°F (-53°C to 148°C)	10,000
LOCTITE 577 THREAD SEALANT	—	Medium strength, coarse threads, particularly suitable for use on stainless steel without the need for surface activation.			
LOCTITE 592 THREAD SEALANT, CONTROLLED STRENGTH	—	Medium strength, high temperature resistant thread sealant.	200,000 - 500,000	-65°F to 400°F (-53°C to 204°C)	10,000
LOCTITE 561 PIPE SEALANT WITH PTFE STICK	—	General-purpose, wax-like thread sealant in a self-feeding stick applicator.	Semisolid	-65°F to 300°F (-53°C to 148°C)	10,000
LOCTITE PTFE THREAD SEALING TAPE, ½" x 520" x 0.003"	—	PTFE thread lubricating tape.	—	Up to 500°F (260°C)	—

Tech Tip

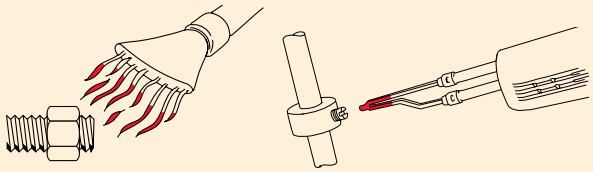
THREADLOCKING, THREAD SEALING & RETAINING DISASSEMBLY

LOW AND MEDIUM STRENGTH PRODUCTS

- Disassemble with hand tools.

HIGH STRENGTH PRODUCTS

- Apply localized heat (500°F [260 °C] or higher) to assembly for 5 minutes.
- Disassemble with hand tools while hot.



THREADLOCKERS

THREADLOCKERS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	COLOR	VISCOSITY (cP)	TORQUE IN.-LBS. (BREAK/ PREVAIL)	TEMP. RANGE	CURE SPEED (STEEL @ 25ºC)
LOCTITE 222 THREADLOCKER, LOW STRENGTH, SMALL SCREW	—	Low strength purple threadlocker designed for fasteners smaller than 1/4" in diameter.	Purple	1,200 / 5,000 Thixotropic	53 / 30	-65°F to 300°F (-53°C to 148°C)	Fixture – 20 minutes Full – 24 hours
LOCTITE 242 THREADLOCKER, MEDIUM STRENGTH	4C-4030 9S-3263, 185-3996	Medium strength blue threadlocker, ideal for fasteners 1/4" to 3/4".	Blue	1,200 / 5,000 Thixotropic	110 / 43	-65°F to 300°F (-53°C to 148°C)	Fixture – 5 minutes Full – 24 hours
LOCTITE 243 THREADLOCKER, MEDIUM STRENGTH, SURFACE INSENSITIVE	—	Medium strength blue threadlocker, primerless, high temperature resistance and will cut through light oils on fasteners. Ideal for fasteners 1/4" to 3/4".	Blue	1,300 / 3,000 Thixotropic	230 / 40	-65°F to 300°F (-53°C to 148°C)	Fixture – 10 minutes Full – 24 hours
LOCTITE 263 THREADLOCKER, HIGH STRENGTH	—	High strength threadlocker, primerless, high temperature resistance and will cut through light oils on fasteners. Ideal for fasteners up to 3/4".	Red	400 / 600	290 / 290	-65°F to 360°F (-53°C to 182°C)	Fixture – 5 minutes Full – 24 hours
LOCTITE 271 THREADLOCKER, HIGH STRENGTH	154-9731 155-0695, 185-3998	High strength for fasteners up to 1" in diameter (25 mm).	Red	500	250 / 275	-65°F to 300°F (-53°C to 148°C)	Fixture – 10 minutes Full – 24 hours
LOCTITE 272 THREADLOCKER, HIGH TEMPERATURE	—	High strength, high temperature threadlocker. Ideal for fasteners greater than 7/8".	Red	9,500	200 / 220	-65°F to 450°F (-53°C to 232°C)	Fixture – 1 hour Full – 24 hours
LOCTITE 277 THREADLOCKER, LARGE HEAVY DUTY BOLTS	—	High strength threadlocker for fasteners greater than 7/8" in diameter.	Red	7,000	275 / 275	-65°F to 300°F (-53°C to 148°C)	Fixture – 60 minutes Full – 24 hours
LOCTITE 290 THREADLOCKER, HIGH STRENGTH, WICKING GRADE	4C-9509	Medium/high strength penetrating threadlocker. Designed to be applied to fasteners that have already been torqued.	Green	25	90 / 260	-65°F to 300°F (-53°C to 148°C)	Fixture – 20 minutes Full – 24 hours
LOCTITE 248 THREADLOCKER STICK, MEDIUM STRENGTH	—	Medium strength blue threadlocker in a wax-like form contained in a self-feeding stick applicator.	Blue	Semisolid	110 / 43	-65°F to 300°F (-53°C to 148°C)	Fixture – 5 minutes Full – 24 hours
LOCTITE 268 THREADLOCKER STICK, HIGH STRENGTH	—	High strength red threadlocker in a wax-like form contained in a self-feeding stick applicator.	Red	Semisolid	220 / 34	-65°F to 300°F (-53°C to 148°C)	Fixture – 5 minutes Full – 24 hours
LOCTITE QUICKTAPE 249	—	Medium strength threadlocker in a tape form. Tape is dry to the touch and will lock and seal threads when assembled. Can be preapplied long before assembly.	Blue	Tape	74 / 47	-65°F to 300°F (-53°C to 148°C)	Fixture – 30 minutes Full – 24 hours

SEAM SEALING & WINDOW GLAZING PRODUCTS

SEAM SEALANTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION	SKIN/WORK TIME	SHEAR STRENGTH (psi)
LOCTITE 5510 CLEAR ADHESIVE/SEALANT	—	An adhesive/sealant that offers fast skin time and cures to a tack-free surface. Its outstanding adhesion and toughness make it ideal for bonding and sealing between dissimilar substrates that are subjected to joint movement or impact.	30 minutes skin time	250
LOCTITE 5512 BLACK ADHESIVE/SEALANT	—	A black adhesive/sealant that exhibits very high strength and flexibility. It demonstrates high adhesion without a primer to a wide variety of substrates and is compatible with suitable paint systems. Its UV resistance allows for both interior and exterior applications.	5 minutes skin time	270
LOCTITE HYSOL E-04SS	—	An epoxy adhesive that cures to a metallic appearance, bonds well to stainless steel and other metal surfaces, can be painted, sanded and powder coated, resists cracking and shrinking even in baking processes.	3 minutes	1,100

WINDOW GLAZING PRODUCTS

CLICK ON PRODUCT NAME TO VIEW GLOBAL AVAILABILITY

LOCTITE PRODUCT	CAT PART NUMBER	DESCRIPTION
TEROSON TEROSTAT 8519 H GLASS PRIMER	—	An all-in-one glass primer/activator to promote adhesion of direct glazing adhesives/sealants. Use on the metal frame, the windscreen and the remaining cut bead.
TEROSON TEROSTAT 8517 P PRIMER/ACTIVATOR	—	A black, liquid primer based on polyurethane. Used to promote adhesion of TEROSON TEROSTAT 8597 HMLC in direct glazing on glass and glass ceramics.
TEROSON TEROSTAT 8597 PL HMLC DIRECT GLAZING ADHESIVE	—	A direct glazing adhesive/sealant that is cold applied and is extremely sag-resistant, has high elasticity, has excellent adhesion to glass, glass with a ceramic coating, and to painted surfaces, and also adheres to any remaining glazing material.
TEROSON FL+		A universal cleaner containing no chlorinated hydrocarbons; it is not harmful to automotive paints when used on a short-term basis. Will not inhibit the curing of polyurethane-based adhesives/sealants. Mainly used to clean and degrease substrates prior to the application of adhesives and sealants.

APPLICATION Q&As

GENERAL, GASKETING, THREADLOCKING & BONDING

GENERAL APPLICATIONS

Q: How can LOCTITE brand Adhesive/Sealants improve the quality of service repairs for my customers?

A: Quality service repairs with LOCTITE brand products do the following:

1. Prevent fasteners from loosening. Use LOCTITE 243 Threadlocker – Medium Strength liquid or LOCTITE 248 Threadlocker Stick.
2. Seal leaky threaded fittings. Use LOCTITE Thread Sealant.
3. Keep bearings from spinning out. Use LOCTITE 609 Retaining Compound.
4. Restore fit between worn bearings, sleeves, gears, pulleys. Use LOCTITE 660 Retaining Compound – Press Fit Repair.
5. Seal flanged assemblies. Use LOCTITE Flexible or High Temperature Flange Sealant.

Improve customer satisfaction with all of the above! Don't put your CSAs at risk with inferior performing products.

Q: How do these adhesive/sealants work?

A: Applied as a liquid or a paste, they automatically harden into a tough resin between metal threads or close-fitting parts. They lock and seal after assembly.

Q: Can I get the parts apart?

A: Yes. Use a little extra elbow grease and ordinary tools on fasteners. Use a bearing puller or a press for bearings or sleeves. Heating at 550°F (288°C) will help loosen parts. Take apart while hot.

Q: Can I re-use the parts?

A: Yes. Knock or blow off the loose particles and re-apply the adhesive/sealant. Material can be removed by wire brush, if necessary.

Q: How do I know which product to use?

A: Bottles or tubes are named to indicate usage. For example: Threadlocker indicates use on threaded fasteners.

Q: How do I clean the parts?

A: Clean with LOCTITE 7649 Primer N.

Q: What happens if I apply adhesive sealant and it doesn't work?

A: Four things that could have happened:

1. Sufficient material was not applied to fill the joint.
2. Insufficient time was allowed for cure.
3. Parts were excessively oily, dirty or greasy, which may prevent the adhesive/sealant from curing.
4. The surfaces required a primer before the adhesive/sealant was applied.

Q: What should I do then?

A: Clean all parts thoroughly, using a wire wheel or a putty knife and a solvent. When all parts are clean and dry, apply LOCTITE 7649 Primer N. Let it dry, then apply the adhesive/sealant. Allow sufficient time to cure.

Q: Will hydraulic oil, motor oil, fuel or water dissolve the adhesive/sealant?

A: No. These adhesive/sealants are solvent-resistant to all ordinary liquids and gases.

Q: How do I apply adhesive/sealant?

A: Simply apply from bottle nozzle or tube to one part. Apply sufficient amount to fill the gap between parts. An adhesive/sealant will not harden while in contact with air – it hardens only in the joint after assembly.

Q: What happens if I leave the cap off a bottle or tube of anaerobics (threadlocking, thread sealant, gasketing, retaining)?

A: Nothing. It won't harden in the tube or bottle or evaporate.

APPLICATION Q&As

GENERAL, GASKETING, THREADLOCKING & BONDING

GASKETING APPLICATIONS

Q: How does LOCTITE High Temperature Flange Sealant work?

A: LOCTITE High Temperature Flange Sealant forms the gasket "in place." When confined between the assembled flanges, the gel-like material automatically converts into a tough sealing gasket. It resists heat to 350°F (177°C). It also resists water, oil and solvents. One tube makes many sizes and shapes of gaskets.

Q: How do I apply LOCTITE High Temperature Flange Sealant?

A: Apply directly from the nozzle applicator on the tube. No mixing. No heat cure. For most joints, apply a 1/16" (1.59 mm) diameter bead around the bolt holes and between the bolt holes centered on the flanges. Material does not cure until flanges are mated together. Be sure that the material will be in contact with both flanges when parts are assembled.

Q: Can I get the flanges apart?

A: Yes. Tap on flanges to loosen.

Q: How do I clean off the cured material?

A: For most flanged joints, it is not necessary to remove the cured material. Wipe off surface with a clean shop towel and apply a new bead, or if it is a very critical dimension joint, remove all residue by scraping with a putty knife or with a wire wheel. Then clean up with LOCTITE 7649 Primer N before reassembly.

Q: Where can I use LOCTITE High Temperature Flange Sealant?

A: Rigid flanges such as hydrostatic transmission flanges, flywheel housings and other rigid covers or plates. Use only where the change in joint thickness will not affect internal clearances.

Q: Where do I use LOCTITE Flexible Anaerobic Gasket Flange Sealant?

A: It's specified for sealing flywheel housings to the block on series 3114, 3116 and 3200 engines. It is also specified on differential steering systems on the D-6, 7, 8, 9 and 10 tractors.

Q: What do I use to seal track pins to track link bores which may be scratched, scored or rusted on sealed and lubricated track?

A: LOCTITE High Flex Form-In-Place Gasket has been successfully used in service to seal these worn parts. Coat both the pin and bore, then press together.

Q: Where can I use LOCTITE brand RTV Silicone Gasketing/Sealants?

A: Use for applications where a highly flexible compound is needed for bonding, sealing, weatherproofing or gasketing. Typical applications are form-in-place gasketing at low pressures, caulking of sheet metal duct work, sealing of electrical boxes, insulating and sealing of electrical wires and terminals, and potting (except around electronic circuits). Use to insulate or seal metal, glass, ceramic, painted and enameled surfaces, and most plastics and rubber, including silicone rubber. Cured sealant will not accept standard paint.

Q: Where do I use LOCTITE 587 Blue, High Performance RTV Silicone Gasket Maker?

A: Use as a general-purpose silicone adhesive sealant. It is the best silicone for oil resistance, low odor, non-corrosiveness and low volatility. Suggested for salvage operation sealing on minor damaged flange surfaces at low pressures. Seals gear covers, oil pans, valve covers, transmission and PTO covers. Withstands temperatures to 400°F (204°C) continuous.

Q: What temperature will LOCTITE SUPERFLEX Red High Temp RTV withstand?

A: LOCTITE SUPERFLEX High Temp Red RTV bonds, seals, gaskets, caulks, pots and insulates on applications to 600°F (316°C). Use on applications that require maximum heat resistance. Suggested for engines, heat exchangers, air side of turbo chargers and aftercoolers. Also bonds insulation for hard-wrap.

APPLICATION Q&As

GENERAL, GASKETING, THREADLOCKING & BONDING

GASKETING APPLICATIONS (CONTINUED)

Q: Where do I use LOCTITE Gasket Sealants 1 and 2, and LOCTITE Aviation Gasket Sealant?

A: Use to repair damaged flange surfaces that require gasket dressing. Suggested for oil pans, transmission covers, water pump flanges, heater valve and similar flanges. Fill uneven surfaces. Withstand pressures to 5,000 psi (34,450 KPA) and temperatures to 400°F (204°C). Resist leaks of gasoline, kerosene, fuel and diesel oils, engine lubricants, hot and cold water, antifreeze and water mixtures, grease, mild acids, alkalis, and steam.

Q: How do I know which LOCTITE brand Gasket Sealant to use?

A:
1. LOCTITE Gasket Sealant 1 – Hardening formula (recommended for rigid assemblies). Fills uneven surfaces and seals damaged flanges. Dries quickly to hard set.
2. LOCTITE Gasket Sealant 2 – Non-hardening formula (best suited for non-rigid assemblies). Dries slowly. Sets to a pliable film for easy disassembly. Suggested for sealing gasket T-joints on flexible flanges.
3. LOCTITE Aviation Gasket Sealant – Thin, brushable formula; seals close fitting, finely machined surfaces. Dries slowly to a pliable film. Seals most gaskets, machined surfaces and screw thread connections on engines. Excellent solvent resistance. Meets MIL-S-45180C (Ord.) Type III.

THREADLOCKING APPLICATIONS

Q: How can I prevent "rusting in" between linkage pins and cartridge pins and the mating bores?

A: Use LOCTITE 242 or LOCTITE 248 Threadlocker Stick to coat the pin and bore prior to assembly for a rust-free barrier. Applying LOCTITE 242 or LOCTITE 248 Threadlocker Stick eliminates the need for burning out pins on loader linkage arms, excavator sticks, and booms or similar assemblies.

Q: Are there any performance differences between the new LOCTITE brand Thread Treatment Sticks (LOCTITE 248 and LOCTITE 268) and the traditional LOCTITE brand Threadlocker liquids (LOCTITE 242 and LOCTITE 271)?

A: No. Both of the new LOCTITE brand Thread Treatment Sticks were designed to maintain the exact performance characteristics of the liquid alternatives.

Q: Is a primer, like LOCTITE 7649 Primer N, necessary when using threadlockers?

A: If the parts are contaminated with dirt and grease, they should be cleaned with a primer in order to ensure optimal performance. Other alternatives are to utilize new threadlocking technology such as LOCTITE 243 Threadlocker – Oil Resistant. When the metals are inactive, a primer should be used.

Q: Which LOCTITE Threadlocker product is best suited for a high shock or vibration application?

A: LOCTITE 271 Threadlocker – High Strength is best suited for heavy equipment applications where shock or vibration are common, such as suspension bolts, motor, and pump mounts.

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 (232°C). Disassemble while hot.

Q: What about preassembled fasteners? Is there a LOCTITE brand Threadlocker I can use to post-apply to the assembly?

A: Yes. LOCTITE 290 Threadlocker – Medium Strength is a wicking grade. This means that the Threadlocker can be applied to preassembled fasteners and the liquid will seep into the assembly to strengthen the fastener.

APPLICATION Q&As

GENERAL, GASKETING, THREADLOCKING & BONDING

BONDING APPLICATIONS

Q: On what bonding applications can I use the LOCTITE FIXMASTER Fast Cure Epoxy?

A: Use for bonding broken parts, patching holes and resurfacing corroded areas (can be sanded or painted after cure). Bonds metal, glass, wood, concrete and some plastics. Bonds identification, name and information plates. Fills large gaps.

Q: How do I use LOCTITE 330 DEPEND Adhesive?

A: Unlike epoxies, LOCTITE 330 DEPEND Adhesive does not require mixing, measuring or heating. Make sure all parts are cleaned and dry. Spray activator, then apply adhesive to parts that are to be assembled. Please see the kit box for complete directions. Handling strength in two minutes. Cures to tough powerful bond. Works on all metals, wood, cork, ceramic, glass and most plastics. May eliminate drilling, tapping, riveting or welding. Easy syringe application. Oil resistant. Heat resistant to 250°F (121°C).

Q: What are some key applications for LOCTITE 330 DEPEND Adhesive?

A: Use to bond name plates and serial plates on equipment. Bonds control knobs that loosen under vibration. Bonds dissimilar materials such as metal, wood, plastic and concrete. Bonds porous surfaces. Bonds glass to steel. Use to bond rear view mirror brackets to windshields.

Q: How do LOCTITE FIXMASTER Fast Cure Epoxy, Mixer Cups differ from the other LOCTITE brand adhesive products previously described?

A: LOCTITE FIXMASTER Fast Cure Epoxy, Mixer Cups have two parts which must be mixed together. When mixed, the epoxy will cure in air. Comes in a convenient mixer cup for mixing. No mess. No guess. No waste.

RETAINING APPLICATIONS

Q: Can I use LOCTITE 609 Retaining Compound to fill the clearance between a bearing and worn housing or shaft?

A: Yes. It will fill a clearance up to 0.005" (0.13 mm). Holding power is equal to a press fit.

Q: How do I use LOCTITE 609 Retaining Compound to mount bearings?

A:
1. Spray parts with LOCTITE 7649 Primer N. Let dry 2 or 3 minutes.
2. Apply LOCTITE 609 Retaining Compound.
3. Assemble in normal way.
4. Cure 2 hours at room temperature.

Q: How do I install parts with LOCTITE 620 Retaining Compound, High Strength?

A:
1. Spray parts with LOCTITE 7649 Primer N. Let dry 2 or 3 minutes.
2. Spread parts with LOCTITE 620 Retaining Compound – Slip Fit.
3. Install gear.
4. Press fits can be used at once. On slip fits, allow 2 hours.

ENGINE APPLICATIONS

FUEL LINE SEALING
- LOCTITE 592 Thread Sealant
- LOCTITE 561 Pipe Sealant with PTFE Stick

INTAKE MANIFOLD BOLTS
- LOCTITE 243 Threadlocker
- LOCTITE 248 Threadlocker Stick

VALVE COVER
- LOCTITE 5900 Flange Sealant

PUMP FLANGE
- LOCTITE High Flex Form-In-Place Gasket

VALVE COVER GASKET – CORK/COMPOSITE GASKET
- LOCTITE Hi-Tack Gasket Sealant

EXHAUST MANIFOLD STUDS
- LOCTITE C5-A Copper Anti-Seize Stick

CYLINDER HEAD BOLTS
- LOCTITE 271 Threadlocker

INTAKE MANIFOLD GASKET
- LOCTITE 5900 Flange Sealant

HYDRAULIC LINES
- LOCTITE 545 Thread Sealant

TURBO MOUNTING FLANGE
- LOCTITE C5-A Copper Anti-Seize Stick

OIL/WATER COOLING LINES
- LOCTITE 592 Thread Sealant
- LOCTITE 561 Pipe Sealant with PTFE Stick

DIPSTICK SLEEVE
- LOCTITE 660 Retaining Compound

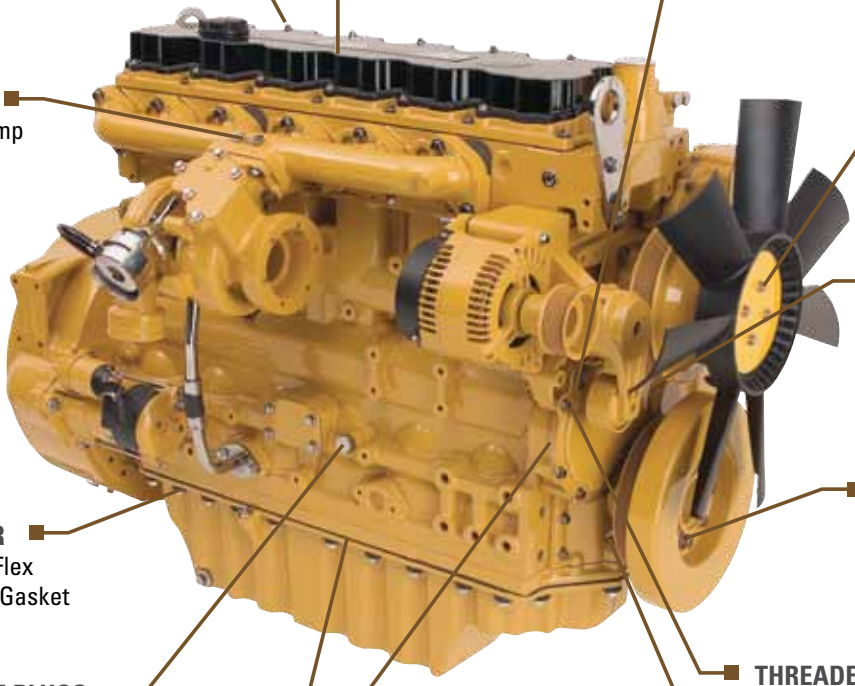
FLYWHEEL BOLTS
- LOCTITE 268 Threadlocker Stick
- LOCTITE 263 Threadlocker

OIL FILTER MOUNTING BLOCK O-RINGS
- LOCTITE Dielectric Grease

OIL PAN GASKET
- LOCTITE 534 Hi-Tack Gasket Dressing Stick

THREADED CORE PLUG
- LOCTITE 540 – Cup/Core Plug Sealant

ENGINE APPLICATIONS



GLOW PLUGS
- LOCTITE C5-A Copper Anti-Seize Stick

DIESEL INJECTORS
- LOCTITE 243 Threadlocker

WATER PUMP MOUNTING HARDWARE PULLEY BOLTS
- LOCTITE 243 Threadlocker
- LOCTITE 248 Threadlocker Stick

TURBO FLANGE
- LOCTITE High Temp Flange Sealant

CLUTCH FAN BOLTS
- LOCTITE 243 Threadlocker

WATER PUMP GASKET
- LOCTITE Hi-Tack Gasket Sealant

HARMONIC BALANCE BOLTS
- LOCTITE 271 Threadlocker

OIL PAN COVER
- LOCTITE High Flex Form-In-Place Gasket

THREADED WATER PUMP FITTINGS
- LOCTITE 592 Thread Sealant
- LOCTITE 561 Pipe Sealant with PTFE Stick

THREADED CORE PLUGS
- LOCTITE 592 Thread Sealant
- LOCTITE 561 Pipe Sealant with PTFE Stick

TIMING COVER/FRONT COVER
- LOCTITE High Flex Form-In-Place Gasket

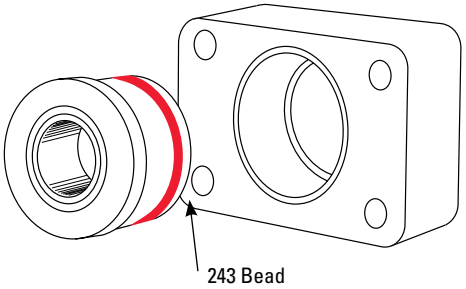
CRANKSHAFT SLEEVE SEAL
- LOCTITE High Flex Form-In-Place Gasket

CONNECTING ROD CAP BOLTS
- LOCTITE 263 Threadlocker
- LOCTITE 248 Threadlocker Stick

ADDITIONAL TECH TIPS

HOUSED COMPONENTS

SEALING/RETAINING — METALLIC SEAL



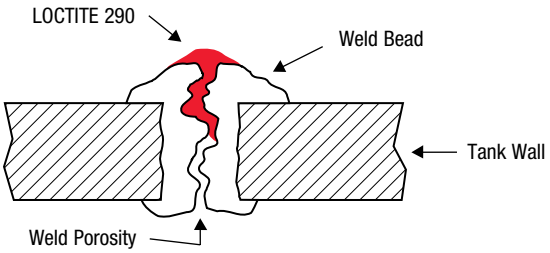
1. Clean the housing I.D. and seal O.D. with parts cleaner.
2. Spray both the housing and seal with LOCTITE 7649 Primer N.
3. Apply a bead of LOCTITE 243 or LOCTITE 248 Threadlocker Stick to the leading edge of metallic seal O.D.

   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 243 or LOCTITE 248 Threadlocker Stick 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.

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 parts cleaner.
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 – 0.005".
7. Allow to cure for 30 minutes (High Pressure, above 150 psi - 1 hour).
8. Clean with parts cleaner to remove excess sealant. Do not grind.
9. Paint as required.

   Note: Casting repair uses same procedure.

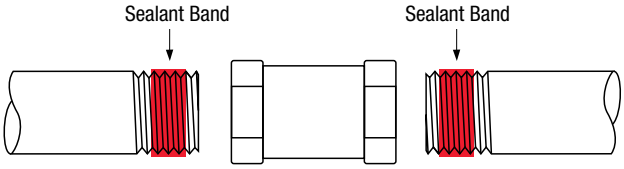
SEALING NEW WELDS — PREVENTIVE MAINTENANCE

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

ADDITIONAL TECH TIPS

THREAD SEALING

STANDARD FITTINGS – PIPES, HYDRAULIC, OR AIR

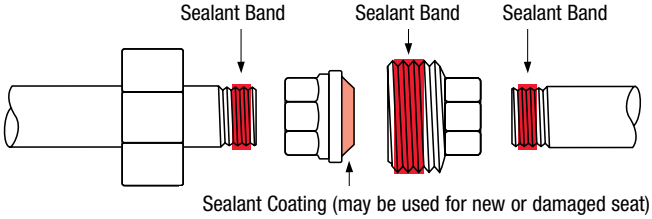


1. Clean parts of contamination. If necessary, spray LOCTITE 7649 Primer N onto threaded parts (male and female). Allow to dry.
   Note: Primer is not required for brass parts.
2. Apply a band of LOCTITE Thread Sealant to male threads starting one to two threads from end of pipe.
3. Assemble parts snugly.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

Note:
- For stainless steel components, use LOCTITE 561 Pipe Sealant Stick.
- For general-purpose thread sealing, use LOCTITE 561 Pipe Sealant Stick.
- For fine filtration systems requiring zero contamination, use LOCTITE 545 Thread Sealant for hydraulic/pneumatic fittings.
- Do not use with systems containing oxygen or strong oxidizers (chlorine).

** Depending on conditions*

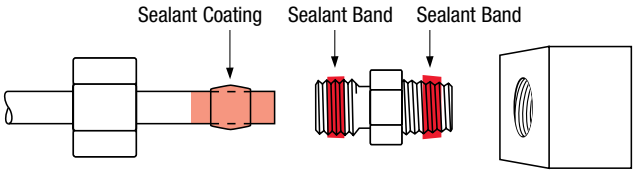
PIPE UNIONS



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

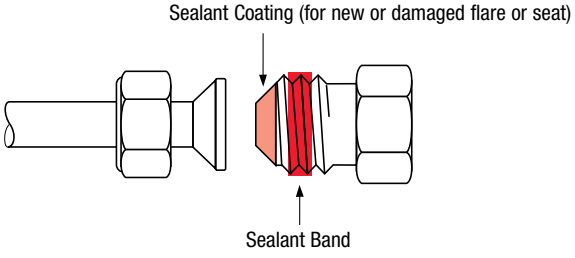
THREAD SEALING

COMPRESSION FITTINGS



1. Slide fitting nut and ferrule back approximately ¾" from end of tubing.
2. If necessary, spray the entire assembly with LOCTITE 7649 Primer N. Allow to dry.
   Note: Primer is not required for brass parts.
3. Apply a thin coating of LOCTITE Thread Sealant to tubing where ferrule will be located.
4. Slide ferrule forward over LOCTITE Thread Sealant coated tubing, then apply a thin bead of LOCTITE Thread Sealant coating to ferrule.
5. Slide ferrule forward over LOCTITE Thread Sealant coated tubing.
6. Apply a small band of LOCTITE Thread Sealant to male threads.
7. Assemble and tighten normally.
   Note: Do not use on plastic fittings or tubing.

FLARED/SWAGED FITTINGS

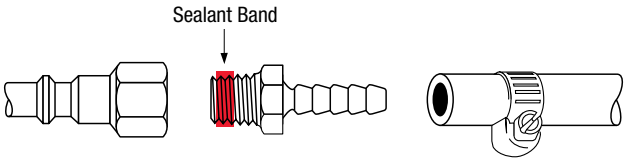


1. Disassemble and, if necessary, spray all components with LOCTITE 7649 Primer N. Allow to dry.
2. Apply a thin coating of LOCTITE Thread Sealant to fitting face.
3. Apply a band of LOCTITE Thread Sealant to male threads.
4. Assemble parts snugly.

ADDITIONAL TECH TIPS

THREAD SEALING

HOSE ENDS – AIR & HYDRAULIC

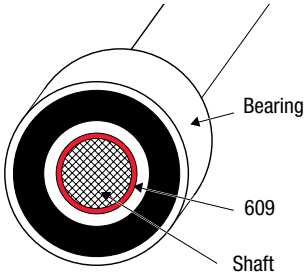


1. If necessary, spray adapter threads with LOCTITE 7649 Primer N. Allow to dry.
2. Insert barbed hose stem into hose I.D. with slight twisting motion.
3. Install appropriate hose clamp.
4. Apply a band of LOCTITE Thread Sealant to male hose stem threads upon installation or adding accessory device.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

   Note: LOCTITE Thread Sealant may attack synthetic rubber tubing.

SHAFT MOUNTED ASSEMBLIES

PRESS FIT



STANDARD

1. Clean shaft O.D. and component I.D.
2. Apply a bead of LOCTITE 609 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.

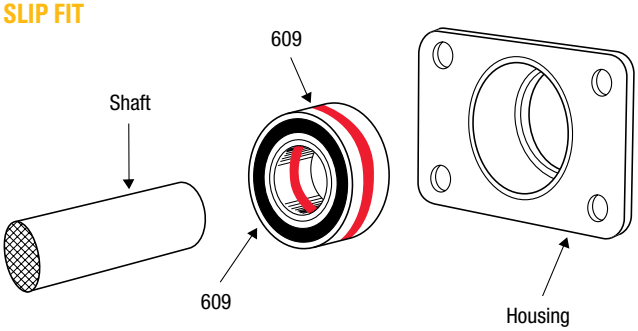
   Note: LOCTITE 609 Retaining Compound is used due to low viscosity and wetting properties.

TANDEM MOUNT

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

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 0.002"-0.004" diametral slip fit.
3. Clean all parts and spray with LOCTITE 7649 Primer N.
4. Apply LOCTITE 609 Retaining Compound to component O.D.
5. Install component. Do not rotate.
6. Wipe off excess.
7. Allow 5 minutes prior to service.

WORN

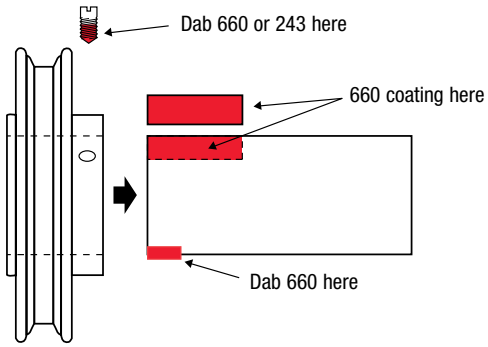
Procedures identical to original slip fit, except:

1. Determine the maximum radial gap.
2. If the maximum gap exceeds 0.005", 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 Retaining Compound is NOT recommended for radial gaps exceeding 0.010".
6. See procedure for BADLY WORN HOUSING, page 28.

ADDITIONAL TECH TIPS

STRENGTHEN KEYED ASSEMBLIES

STANDARD DUTY



ASSEMBLY

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

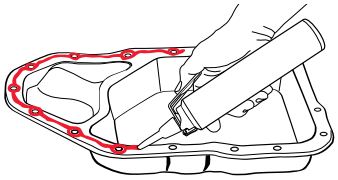
Note: • LOCTITE 660 Retaining Compound is NOT recommended for radial gaps exceeding 0.010" on shaft or keyway.

DISASSEMBLY

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

FORM-IN-PLACE SILICONES

STAMPED OR SHEET METAL FLANGES

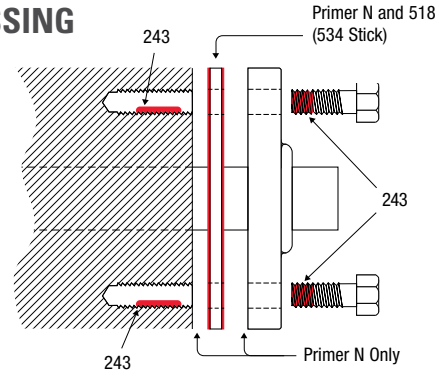


1. Remove old gasketing material and other heavy contaminants with LOCTITE CHISEL Paint Stripper.
2. Clean both flanges with parts cleaner.
3. Apply a continuous bead of LOCTITE high performance silicones (587 Blue) to sealing surface. Circle all bolt holes.

   Note: • Use proper bead diameter to seal flange width and depth.
   • Minimize excessive material "squeeze-out."
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.

GASKET DRESSING

SEALED FLANGES



1. Remove old gasketing material and other heavy contaminants with LOCTITE CHISEL Paint Stripper. Use mechanical removal technique if required.

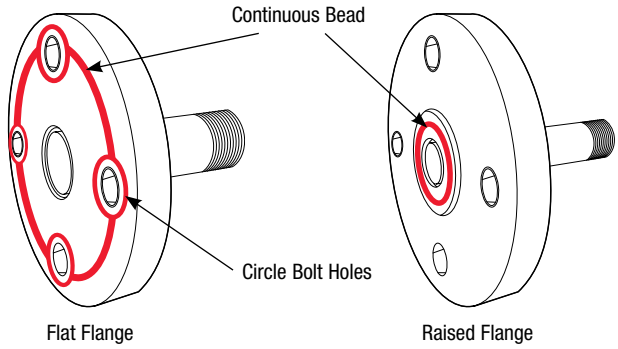
   Note: Avoid grinding.
2. Clean both flanges with parts cleaner.
3. Spray LOCTITE 7649 Primer N on both flange faces and both sides of the precut gasket. Allow 1-2 minutes to dry.
4. Smear LOCTITE Flange Sealant to both sides of precut gasket with a clean applicator.
5. Place coated gasket on flange surface and assemble parts immediately.

   Note: • If cover bolts into blind holes (as above), apply LOCTITE 243 Threadlocker into hole and on threads. Tighten normally.
   • If it is a thru hole bolt assembly, apply LOCTITE 243 or LOCTITE 248 Threadlocker Stick to bolt threads.
6. Tighten normally.

ADDITIONAL TECH TIPS

FORM-IN-PLACE GASKETING

SEALING CAST RIGID FLANGES



1. Remove old gasketing material and other heavy contaminants with LOCTITE CHISEL Paint Stripper. Use mechanical removal technique if required.
   Note: Avoid grinding.
2. Clean both flanges with parts cleaner.
3. Spray LOCTITE 7649 Primer N on only one surface. Allow 1-2 minutes to dry.
4. Apply a continuous bead of LOCTITE 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 Flange Sealant**	0.050"	-65°F to 300°F (-54°C to 150°C)
General	**515 Flange Sealant**	0.050"	-65°F to 300°F (-54°C to 150°C)
General/Overhead	**548 Flange Sealant Stick**	0.010"	-65°F to 300°F (-54°C to 150°C)

RUSTPROOFING

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 (10°C and 32°C). 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:

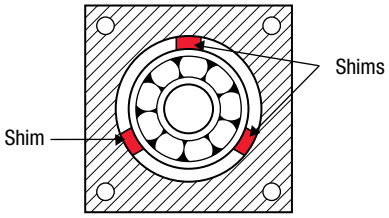
LOCTITE EXTEND Rust Treatment may be applied by brush, roller, or spray. Brush or roller is suitable for small areas. Avoid sags and ridges and keep edges wet by coating about a square yard at a time. Roll away from previously coated area and then roll back. Do not pour unused material back into the 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.

ADDITIONAL TECH TIPS

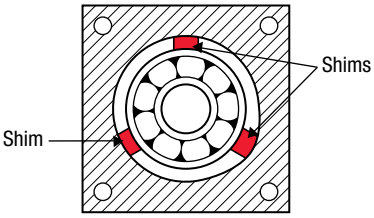
HOUSED COMPONENTS

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 ⅛" wide to fit bore depth.
6. Bond the shims to bore at mounting points using LOCTITE 480 Instant Adhesive.
7. Assemble per instructions on page 25.

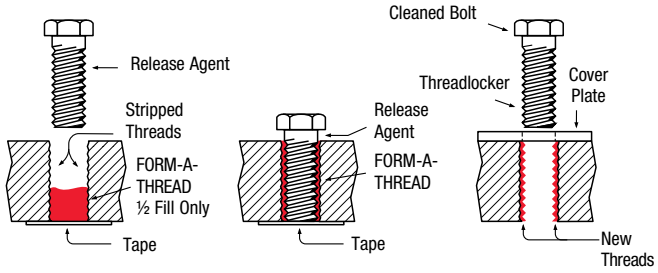


EXCESSIVE/UNEVEN WEAR

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 Prism Instant Adhesive.
6. Assemble per instructions above.

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 damaged 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.

ADDITIONAL TECH TIPS

BONDING

INTRODUCTION TO BONDING ADHESIVES

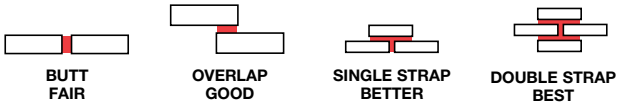
Within the broad range of LOCTITE brand adhesives you will always find the solution to your bonding challenge. It is, however, extremely important to have at least basic knowledge of adhesive methodology in order to successfully bond two substrates together. The three major causes of bonding failures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

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

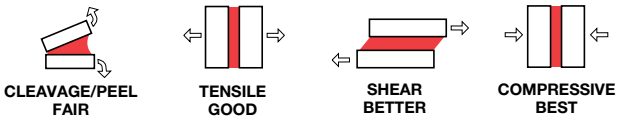
BONDING ASSEMBLY

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

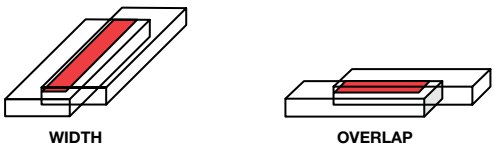


TYPES OF JOINT STRESS DISTRIBUTION



JOINT WIDTH VS. OVERLAP

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



BONDING

SURFACE PREPARATION

Abrasive Methods

Rubbing or striking a surface with hard, coarse material.
Abrasive examples:

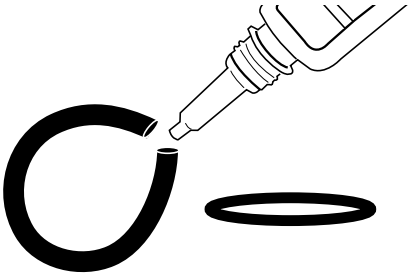
- Sanding: Rubbing with abrasive paper or cloth (for small area/superficial wear-down)
- Blasting: Striking with steel grit, sand, or other abrasive material (for large areas/deep wear-down)

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

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.

ADDITIONAL TECH TIPS

TROUBLESHOOTING

CHECKLIST

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 (c) fluid compatibility
   (b) excessive pressure too soon (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 (c) improper joint design
   (b) component materials (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.

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.

In light of the foregoing, HENKEL CORPORATION SPECIFICALLY DISCLAIMS ALL WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE ARISING FROM SALE OR USE OF HENKEL CORPORATION'S PRODUCTS. HENKEL CORPORATION SPECIFICALLY DISCLAIMS ANY LIABILITY FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES OF ANY KIND, INCLUDING LOST PROFITS. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents which may cover such processes or compositions. We recommend that each prospective user test the proposed application to determine its suitability for the purposes intended prior to incorporating any product or application in its manufacturing process using this data as a guide. Some products may be covered by one or more United States or foreign patents or patent applications.

GLOBAL AVAILABILITY

ANTI-SEIZE LUBRICANTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE C5-A COPPER ANTI-SEIZE LUBRICANT	222-3114	●	●	●	LOCTITE 8007
	4C-5598				LOCTITE 8008
	4C-5599				
	5P-3931				
LOCTITE GRAPHITE-50 ANTI-SEIZE	4C-5592	●	●	●	LOCTITE 8009
	4C-5593				
	6V-4876, 186-1531				
LOCTITE MOLY PASTE, METAL-FREE	—	●	●	●	LOCTITE 8012
LOCTITE NICKEL ANTI-SEIZE	337-7965	●	●	●	LOCTITE 8009
LOCTITE C5-A COPPER ANTI-SEIZE STICK	—	●	●	O	LOCTITE 8065
LOCTITE SILVER GRADE ANTI-SEIZE STICK	—	●	●	O	✖

SPECIALTY ADHESIVES

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 330 DEPEND ADHESIVE	308-3506, 185-4003	●	●	●	●
LOCTITE BLACK CONTACT ADHESIVE	5H-2471, 185-4591	●	●	●	ZEMENT BE weiß
LOCTITE CONTACT ADHESIVE	—	●	✖	●	TEROKAL 2444
LOCTITE MAXIMUM STRENGTH HEADLINER ADHESIVE	—	●	O	O	ADHESIN J1626
LOCTITE ALL-PURPOSE SPRAY ADHESIVE	222-3113	●	●	●	TEROSON Karosserie-Klebe-Spray

STRUCTURAL ADHESIVES

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE FIXMASTER FAST CURE EPOXY MIXER CUPS	266-3144	●	●	●	LOCTITE 3430
LOCTITE FIXMASTER GENERAL-PURPOSE EPOXY MIXER CUPS	—	●	●	O	LOCTITE 3423
LOCTITE 3034 STRUCTURAL ADHESIVE, TOUGHENED, POLYOLEFIN BONDING, 2-PART ACRYLIC	—	●	●	●	LOCTITE 3038
LOCTITE 332 STRUCTURAL ADHESIVE, SEVERE ENVIRONMENT	—	●	●	●	LOCTITE 3342
LOCTITE H3000 STRUCTURAL ADHESIVE	209-0987	●	●	●	●

● Available O Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

GLOBAL AVAILABILITY

INSTANT ADHESIVES

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 380 BLACK MAX INSTANT ADHESIVE	152-9155	●	●	●	●
LOCTITE 401 INSTANT ADHESIVE, SURFACE INSENSITIVE	—	●	●	●	●
LOCTITE 406 INSTANT ADHESIVE	—	●	●	●	●
LOCTITE 410 INSTANT ADHESIVE, TOUGHENED	—	●	●	●	●
LOCTITE 411 INSTANT ADHESIVE	—	●	●	●	LOCTITE 409
LOCTITE 414 INSTANT ADHESIVE	157-7228	●	●	●	●
LOCTITE 426 INSTANT ADHESIVE, BLACK, TOUGHENED GEL	—	●	●	●	LOCTITE 410
LOCTITE 454 INSTANT ADHESIVE	—	●	●	●	●
LOCTITE 480 INSTANT ADHESIVE, BLACK, TOUGHENED	—	●	●	●	●
LOCTITE 495 INSTANT ADHESIVE	—	●	●	●	●
LOCTITE 496 INSTANT ADHESIVE	—	●	●	●	●
LOCTITE 498 INSTANT ADHESIVE	—	●	●	●	LOCTITE 435
LOCTITE QUICKTITE GEL	—	●	LOCTITE 454	●	LOCTITE 454

CLEANERS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE ODC-FREE CLEANER & DEGREASER	—	●	●	●	●
LOCTITE CHISEL PAINT STRIPPER, METHYLENE CHLORIDE	—	●	●	●	✖
LOCTITE CHISEL MC-FREE PAINT STRIPPER	—	●	●	LOCTITE 7200	LOCTITE 7200
LOCTITE NATURAL BLUE BIODEGRADABLE CLEANER & DEGREASER, ALL-PURPOSE	—	●	●	●	LOCTITE 7840
LOCTITE NON-CHLORINATED PARTS CLEANER	222-3117, 222-3118	●	●	○	TEROSON Brake Clean
LOCTITE ELECTRICAL CONTACT CLEANER, NONFLAMMABLE	222-3124, 222-3119	●	●	○	LOCTITE 7039
LOCTITE PRO STRENGTH PARTS CLEANER	—	●	●	LOCTITE 7063	LOCTITE 7063
LOCTITE INDUSTRIAL HAND WIPES		●	✖	○	✖
LOCTITE HANDCLEANER WITH PUMICE		✖	○	○	✖
LOCTITE SMOOTH HANDCLEANER		✖	●	○	●
LOCTITE 7012	—	✖	✖	●	✖
LOCTITE 7013	—	✖	✖	●	✖

● Available ○ Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

GLOBAL AVAILABILITY

CLEANERS (CONTINUED)

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 7018	—	✖	✖	●	✖
TURCO WHITE SOLVE 'EC' ELECTRICAL CONTACT CLEANER	—	LOCTITE Electrical Contact Cleaner, Nonflammable	LOCTITE Electrical Contact Cleaner, Nonflammable	LOCTITE Electrical Contact Cleaner, Nonflammable	LOCTITE 7039
YUK-OFF BRAKE AND PARTS CLEANER	—	LOCTITE Non-Chlorinated Parts Cleaner	LOCTITE Non-Chlorinated Parts Cleaner	LOCTITE Non-Chlorinated Parts Cleaner	TEROSON Brake Clean

SURFACE TREATMENT PRODUCTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE EXTEND RUST TREATMENT	—	●	●	●	LOCTITE 7500
LOCTITE MAXI-COAT, RUST INHIBITOR	222-3121	●	●	○	LOCTITE 7803

SILICONE GASKETING PRODUCTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 5699 GREY HIGH PERFORMANCE RTV SILICONE GASKET MAKER	—	●	●	●	●
LOCTITE 587 BLUE HIGH PERFORMANCE RTV SILICONE GASKET MAKER	141-5831	●	●	●	●
LOCTITE 598 BLACK HIGH PERFORMANCE RTV SILICONE GASKET MAKER	4C-9612	●	●	●	●
LOCTITE 5900 FLANGE SEALANT	165-2601 8T-0065, 186-1527	●	●	●	●
LOCTITE 5999 FLANGE SEALANT	—	●	●	●	●
LOCTITE INSTANT GASKET	—	●	●	●	LOCTITE 5970
LOCTITE SUPERFLEX 593 RTV SILICONE SEALER, BLACK	3S-6252, 185-3986	●	●	●	LOCTITE 5970
LOCTITE SUPERFLEX 595 RTV SILICONE ADHESIVE, CLEAR	119-0781	●	●	●	LOCTITE 5366
LOCTITE SUPERFLEX 596 HIGH TEMP RTV SILICONE ADHESIVE, RED	4C-9614 8T-9013. 205-8857	●	●	●	LOCTITE 5399
LOCTITE SUPERFLEX RTV SILICONE ADHESIVE SEALANT, BLACK	141-5830	●	●	●	LOCTITE 5980
LOCTITE SUPERFLEX RTV SILICONE ADHESIVE SEALANT, BLUE	8T-9022, 185-3987	●	●	●	LOCTITE 5926
LOCTITE SUPERFLEX RTV SILICONE ADHESIVE SEALANT, RED	—	●	●	●	LOCTITE 5399
LOCTITE SUPERFLEX NONCORROSIVE RTV SILICONE ADHESIVE, CLEAR	8T-9014, 205-8858	●	●	●	TEROSTAT 9140

● Available ○ Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

GLOBAL AVAILABILITY

ANAEROBIC GASKETING PRODUCTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 5127 FLEXIBLE ANAEROBIC GASKET FLANGE SEALANT	4C-5300, 185-3984	●	●	●	Turkey - LOCTITE 5188
LOCTITE 515 FLANGE SEALANT	—	●	●	●	●
LOCTITE HIGH FLEX FORM-IN-PLACE GASKET	1U-8846, 185-3983	●	●	●	LOCTITE 5127 (128068)
LOCTITE HI-TEMPERATURE FLANGE SEALANT	6V-6640, 185-3985	●	●	●	LOCTITE 5188
LOCTITE 534 HI-TACK GASKET DRESSING STICK	—	●	O	●	✖
LOCTITE 548 FLANGE SEALANT STICK	—	●	O	O	✖

SOLVENT GASKETING PRODUCTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 5923 AVIATION GASKET SEALANT	4C-9505	●	●	●	LOCTITE 5923
LOCTITE GASKET SEALANT #1	4C-9501	●	●	●	LOCTITE 5921
LOCTITE GASKET SEALANT #2	4C-9502	●	●	●	LOCTITE 5922
LOCTITE HI-TACK GASKET SEALANT	138-8436, 185-4590	●	●	●	LOCTITE 5009

CONCRETE REPAIR PRODUCTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE FIXMASTER MAGNA-CRETE	—	●	●	●	LOCTITE 7257

● Available O Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

GLOBAL AVAILABILITY

DISPENSING EQUIPMENT

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
50 ML MIX NOZZLE, 6.0 MM, STEPPED TIP, 10:1 RATIOS-S STYLE CARDRIDGE (USED WITH 50 ML DUAL CQ)	—	●	●	●	Related Accessories are Available
HAND HELD DUAL CARTRIDGE DISPENSE FOR 50 ML (USED WITH 50 ML DUAL CQ)	—	●	●	●	Manual Hand Held Applicator (96001)
LOCTITE 400 ML CARTRIDGE MANUAL DISPENSER	—	●	●	✖	✖
LOCTITE CONVERTER KIT, FOR HOUSEHOLD CAULKING GUN, ACCEPTS 50 ML	—	●	✖	✖	✖
LOCTITE LUER/STEPPED NOZZLES FOR 50 ML STRUCTURAL ADHESIVE (10 PER PACK)	—	●	Appropriate Nozzles are Available	Appropriate Nozzles are Available	Appropriate Nozzles are Available
LOCTITE STATIC MIXER NOZZLE, MC08-24 1:1/2:1	—	●	●	●	●
NEEDLE, 18GA, ¼" SS, GRN, 50PK	—	●	Appropriate Nozzles are Available	Appropriate Nozzles are Available	Appropriate Nozzles are Available

LAPPING / MACHINING COMPOUNDS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 80 GRIT	226-6624	✖	✖	✖	✖
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 240 GRIT	—	●	✖	✖	✖
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 400 GRIT	—	●	✖	✖	✖
LOCTITE CLOVER SILICON CARBIDE GREASE MIX, 800 GRIT	—	●	✖	✖	✖

SEALANTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE INSULATING & SEALING WRAP, BLACK, 2" x 36'	—	●	✖	✖	✖
LOCTITE INSULATING & SEALING WRAP, BLACK, 1" x 10'	—	●	✖	✖	✖
LOCTITE INSULATING & SEALING WRAP, RED, 1" x 10'	—	●	✖	✖	✖

● Available ○ Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

GLOBAL AVAILABILITY

KITS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE O-RING MAKING KIT	—	●	●	●	●
LOCTITE SEMISOLID STICK EMPTY HOLSTER, PROMO ITEM WHILE SUPPLIES LAST	—	●	✖	✖	✖
LOCTITE TOOLBOX (CONTAINS 220, 222, 243, 263, 248, 249, 268, 518, 545, 561, 565, 587, 660, 7649, 404, 7088, C5-A)	—	●	●	●	✖
LOCTITE FORM-A-THREAD STRIPPED THREAD REPAIR KIT	—	●	●	●	✖

LUBRICANTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE DIELECTRIC GREASE	—	●	●	O	O
LOCTITE FREEZE & RELEASE	—	●	●	●	LOCTITE 8040
LOCTITE GEAR, CHAIN & CABLE LUBRICANT	222-3110	●	LOCTITE Lubricante Cadenas	O	LOCTITE 8101
LOCTITE MOLY DRY FILM LUBRICANT	242-6990	●	●	●	LOCTITE 8191
LOCTITE PENETRATING OIL	222-3123	●	LOCTITE Aflojatodo	O	LOCTITE 8001
LOCTITE SILICONE LUBRICANT	—	●	●	●	LOCTITE 8104
LOCTITE SOLVO-RUST SUPER PENETRATING OIL	222-3115		LOCTITE 8040	LOCTITE 8040	LOCTITE 8040
LOCTITE VIPERLUBE HIGH PERFORMANCE SYNTHETIC GREASE	—	●	●	O	LOCTITE 8102

METAL-FILLED REPAIR EPOXIES

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE FIXMASTER FAST SET STEEL PUTTY	1U-6140, 207-7532	●	●	●	LOCTITE 3473 A&B
LOCTITE FIXMASTER METAL MAGIC STEEL	8T-9018 8T-9019	●	●	●	LOCTITE 3463
LOCTITE FIXMASTER SUPERIOR METAL	1U-6136, 207-7530	●	●	●	LOCTITE 3478 A&B

● Available O Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

GLOBAL AVAILABILITY

WEAR-RESISTANT COATINGS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE FIXMASTER WEAR RESISTANT PUTTY	1U-6132, 207-7531	●	●	●	LOCTITE 3474 A&B
LOCTITE FIXMASTER FLEX 80 PUTTY	144-7779	●	●	●	TEROMIX 6700

ANAEROBIC PRIMERS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 7088 PRIMER STICK	—	●	✖	✖	✖
LOCTITE 7090 PRIMER/ACTIVATOR, SOLVENTLESS	—	●	●	●	●
LOCTITE 7091 PRIMER (FOR DICHROMATED SURFACES)	—	●	●	●	●
LOCTITE 7649 PRIMER N	169-5464, 185-4004	●	●	●	●

CYANOACRYLATE PRIMER

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 770 PRIMER (FOR CYANOACRYLATES)	—	●	●	●	●

● Available ○ Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

GLOBAL AVAILABILITY

RETAINING COMPOUNDS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 232 RETAINING COMPOUND, WHEEL MOUNT, HIGH LUBRICITY, LOW STRENGTH	—	●	●	●	●
LOCTITE 540 ADHESIVE/SEALANT, CUP/CORE PLUG	—	●	●	●	LOCTITE 549
LOCTITE 603 RETAINING COMPOUND	—	●	●	●	LOCTITE 648
LOCTITE 609 RETAINING COMPOUND, PRESS FIT, GENERAL-PURPOSE	4C-4032 7M-7456, 185-3994	●	●	●	Turkey - LOCTITE 601
LOCTITE 620 RETAINING COMPOUND, SLIP FIT, HIGH TEMPERATURE	4C-9506 4C-9507, 185-3988	●	●	●	●
LOCTITE 638 RETAINING COMPOUND, SLIP FIT, MAXIMUM STRENGTH	—	●	●	●	●
LOCTITE 640 RETAINING COMPOUND	—	●	●	●	●
LOCTITE 648 RETAINING COMPOUND, PRESS FIT, HIGH STRENGTH, RAPID CURE	—	●	●	●	●
LOCTITE 660 QUICK METAL RETAINING COMPOUND, PRESS FIT	269-1943	●	●	●	●
LOCTITE 668 RETAINING COMPOUND STICK	—	●	●	●	✖

THREAD SEALANTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE HEAD BOLT & WATER JACKET SEALANT	—	●	✖	✖	✖
LOCTITE 536 LOW BREAKLOOSE PIPE SEALANT	5P-3413, 185-3992	●	●	●	Turkey - LOCTITE 567
LOCTITE 545 THREAD SEALANT, HYDRAULIC/ PNEUMATIC FITTINGS	—	●	●	●	LOCTITE 577
LOCTITE 577 THREAD SEALANT	—	●	●	●	●
LOCTITE 592 THREAD SEALANT, CONTROLLED STRENGTH	—	●	●	●	LOCTITE 567
LOCTITE 561 PIPE SEALANT WITH PTFE STICK	—	●	●	●	✖
LOCTITE PTFE THREAD SEALING TAPE, ½" x 520" x 0.003"	—	●	●	✖	✖

● Available ○ Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

GLOBAL AVAILABILITY

THREADLOCKERS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 222 THREADLOCKER, LOW STRENGTH, SMALL SCREW	—	●	●	●	●
LOCTITE 242 THREADLOCKER, MEDIUM STRENGTH	4C-4030 9S-3263, 185-3996	●	●	●	●
LOCTITE 243 THREADLOCKER, MEDIUM STRENGTH, SURFACE INSENSITIVE	—	●	●	●	●
LOCTITE 263 THREADLOCKER, HIGH STRENGTH	—	●	●	●	LOCTITE 270
LOCTITE 271 THREADLOCKER, HIGH STRENGTH	154-9731 155-0695, 185-3998	●	●	●	●
LOCTITE 272 THREADLOCKER, HIGH TEMPERATURE	—	●	●	●	●
LOCTITE 277 THREADLOCKER, LARGE HEAVY DUTY BOLTS	—	●	●	●	●
LOCTITE 290 THREADLOCKER, HIGH STRENGTH, WICKING GRADE	4C-9509	●	●	●	●
LOCTITE 248 THREADLOCKER, MEDIUM STRENGTH STICK	—	●	●	●	●
LOCTITE 268 THREADLOCKER, HIGH STRENGTH STICK	—	●	●	●	●
LOCTITE QUICKTAPE 249	—	●	●	●	●

SEAM SEALANTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
LOCTITE 5510 CLEAR ADHESIVE/SEALANT	—	●	●	✖	✖
LOCTITE 5512 BLACK ADHESIVE/SEALANT	—		TEROSON MS 939	TEROSON MS 939	TEROSON MS 939
LOCTITE HYSOL E-04SS	—	●	●	✖	○

WINDOW GLAZING PRODUCTS

CLICK ON PRODUCT NAME TO RETURN

LOCTITE PRODUCT	CAT PART NUMBER	AVAILABILITY BY REGION			
		AMERICAS NORTH	AMERICAS SOUTH	ASIA PACIFIC	EAME
TEROSON TEROSTAT 8519 H GLASS PRIMER	—	●	TEROSON TEROSTAT 8517	●	TEROSON TEROSTAT 8517
TEROSON TEROSTAT 8517 P PRIMER/ ACTIVATOR	—	TEROSON TEROSTAT 8519	●	TEROSON TEROSTAT 8519	●
TEROSON TEROSTAT 8597 PL HMLC DIRECT GLAZING ADHESIVE	—	●	TEROSTAT 8590	●	●
TEROSON FL+	—	●	✖	✖	✖

● Available ○ Limited Availability within a Region. Contact your local Henkel Representative for more information. ✖ Not Available

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

INDEX

LOCTITE PRODUCT DESCRIPTION INDEX

PRODUCT DESCRIPTION	ALTERNATIVE PRODUCT	PAGE NO.
50 ml Mix Nozzle, 6.0 mm, Stepped Tip, 10:1 Ratios-S Style Cartridge (Used with 50 ml Dual CQ)	Related Accessories are Available	8
Hand Held Dual Cartridge Dispense for 50 ml (Used With 50 ml Dual CQ)	Manual Hand Held Applicator (96001)	8
LOCTITE 222 Threadlocker, Low Strength, Small Screw	—	15
LOCTITE 232 Retaining Compound, Wheel Mount, High Lubricity, Low Strength	—	13
LOCTITE 242 Threadlocker, Medium Strength	—	15
LOCTITE 243 Threadlocker, Medium Strength, Surface Insensitive	—	15
LOCTITE 248 Threadlocker Stick, Medium Strength	—	15
LOCTITE 263 Threadlocker, High Strength	—	15
LOCTITE 268 Threadlocker Stick, High Strength	—	15
LOCTITE 271 Threadlocker, High Strength	—	15
LOCTITE 272 Threadlocker, High Temperature	—	15
LOCTITE 277 Threadlocker, Large Heavy Duty Bolts	—	15
LOCTITE 290 Threadlocker, High Strength, Wicking Grade	—	15
LOCTITE 330 DEPEND Adhesive	—	3
LOCTITE 332 Structural Adhesive, Severe Environment	LOCTITE 3342	3
LOCTITE 380 Black Max Instant Adhesive	—	2
LOCTITE 400 ml Cartridge Manual Dispenser	—	8
LOCTITE 401 Instant Adhesive, Surface Insensitive	—	2

PRODUCT DESCRIPTION	ALTERNATIVE PRODUCT	PAGE NO.
LOCTITE 406 Instant Adhesive	—	2
LOCTITE 410 Instant Adhesive, Toughened	—	2
LOCTITE 411 Instant Adhesive	LOCTITE 409	2
LOCTITE 414 Structural Adhesive	—	2
LOCTITE 426 Instant Adhesive, Black, Toughened Gel	LOCTITE 410	2
LOCTITE 454 Instant Adhesive	—	2
LOCTITE 480 Instant Adhesive, Black, Toughened	—	2
LOCTITE 495 Instant Adhesive	—	2
LOCTITE 496 Instant Adhesive	—	2
LOCTITE 498 Instant Adhesive	LOCTITE 435	2
LOCTITE 515 Flange Sealant	—	7
LOCTITE 534 Hi-Tack Gasket Dressing Stick	No Similar Product Available	7
LOCTITE 536 Low Breakloose Pipe Sealant	Turkey - LOCTITE 567	14
LOCTITE 540 Adhesive/Sealant, Cup/Core Plug	LOCTITE 549	13
LOCTITE 545 Thread Sealant, Hydraulic/Pneumatic Fittings	LOCTITE 577	14
LOCTITE 548 Gasket Flange Sealant Stick	No Similar Product Available	7
LOCTITE 561 Pipe Sealant with PTFE Stick	No Similar Product Available	14
LOCTITE 587 Blue High Performance RTV Silicone Gasket Maker	—	6

INDEX

LOCTITE PRODUCT DESCRIPTION INDEX

PRODUCT DESCRIPTION	ALTERNATIVE PRODUCT	PAGE NO.
LOCTITE 592 Thread Sealant, Controlled Strength	LOCTITE 567	14
LOCTITE 598 Black High Performance RTV Silicone Gasket Maker	—	6
LOCTITE 603 Retaining Compound	LOCTITE 648	13
LOCTITE 609 Retaining Compound, Press Fit, General-Purpose	Turkey - LOCTITE 601	13
LOCTITE 620 Retaining Compound, Slip Fit, High Temperature	—	13
LOCTITE 638 Retaining Compound, Slip Fit, Maximum Strength	—	13
LOCTITE 640 Retaining Compound	—	13
LOCTITE 648 Retaining Compound, Press Fit, High Strength, Rapid Cure	—	13
LOCTITE 660 Retaining Compound, Press Fit	—	13
LOCTITE 668 Retaining Compound Stick	No Similar Product Available	13
LOCTITE 770 Primer (for Cyanoacrylates)	—	12
LOCTITE 3034 Structural Adhesive, Toughened, Polyolefin Bonding, 2-Part Acrylic	LOCTITE 3038	3
LOCTITE 5127 Flexible Anaerobic Gasket Flange Sealant	Turkey – LOCTITE 5188	7
LOCTITE 5510 Clear Adhesive/Sealant	—	16
LOCTITE 5512 Black Adhesive/Sealant	LOCTITE MS 939	16
LOCTITE 5699 Grey High Performance RTV Silicone Gasket Maker	—	6
LOCTITE 5900 Flange Sealant	—	6
LOCTITE 5923 Aviation Gasket Sealant	LOCTITE 5923	7

PRODUCT DESCRIPTION	ALTERNATIVE PRODUCT	PAGE NO.
LOCTITE 5999 Flange Sealant	—	6
LOCTITE 7012	—	5
LOCTITE 7013	—	5
LOCTITE 7018	—	5
LOCTITE 7088 Primer Stick	No Similar Product Available	12
LOCTITE 7090 Activator/Primer, Solventless	—	12
LOCTITE 7091 Primer (For Dichromated Surfaces)	—	12
LOCTITE 7649 Primer N	—	12
LOCTITE All-Purpose Spray Adhesive	TEROSON Karosserie-Klebe-Spray	3
LOCTITE Black Contact Adhesive	ZEMENT BE weiß	3
LOCTITE C5-A Copper Anti-Seize Stick	LOCTITE 8065	1
LOCTITE C5-A Copper Anti-Seize Lubricant	LOCTITE 8007 & LOCTITE 8008	1
LOCTITE CHISEL Paint Stripper, Methylene Chloride	No Similar Product Available	4
LOCTITE CHISEL MC-Free Paint Stripper	LOCTITE 7200	4
LOCTITE Clover Silicon Carbide Grease Mix	No Similar Product Available	8
LOCTITE Contact Adhesive	TEROKAL 2444	3
LOCTITE Converter Kit, For Household Caulking Gun, Accepts 50 ml	No Similar Product Available	8
LOCTITE Dielectric Grease	No Similar Product Available	10

INDEX

LOCTITE PRODUCT DESCRIPTION INDEX

PRODUCT DESCRIPTION	ALTERNATIVE PRODUCT	PAGE NO.
LOCTITE Electrical Contact Cleaner, Nonflammable	LOCTITE 7039	4
LOCTITE Extend Rust Treatment	LOCTITE 7500	5
LOCTITE FIXMASTER Fast Cure Epoxy Mixer Cups	LOCTITE 3430	3
LOCTITE FIXMASTER Fast Set Steel Putty	LOCTITE 3473 A&B	11
LOCTITE FIXMASTER Flex 80 Putty	TEROMIX 6700	11
LOCTITE FIXMASTER General-Purpose Epoxy Mixer Cups	LOCTITE 3423	3
LOCTITE FIXMASTER Magna-Crete	LOCTITE 7257	8
LOCTITE FIXMASTER Metal Magic Steel	LOCTITE 3463	11
LOCTITE FIXMASTER Superior Metal	LOCTITE 3478 A&B	11
LOCTITE FIXMASTER Wear Resistant Putty	LOCTITE 3474 A&B	11
LOCTITE Form-A-Thread Stripped Thread Repair Kit	No Similar Product Available	9
LOCTITE Freeze & Release	LOCTITE 8040	10
LOCTITE Gasket Sealant #1	LOCTITE 5921	7
LOCTITE Gasket Sealant #2	LOCTITE 5922	7
LOCTITE Gear, Chain & Cable Lubricant	LOCTITE 8101	10
LOCTITE Graphite-50 Anti-Seize	LOCTITE 8009	1
LOCTITE H3000 Structural Adhesive	—	3
LOCTITE Hand Cleaner with Pumice	—	4
LOCTITE Head Bolt & Water Jacket Sealant	No Similar Product Available	14
LOCTITE Hi-Tack Gasket Sealant	LOCTITE 5009	7
LOCTITE Hi-Temperature Flange Sealant	LOCTITE 5188	7
LOCTITE High Flex Form-In-Place Gasket	LOCTITE 5127 (128068)	7
LOCTITE Hysol E-04SS	—	16
LOCTITE Industrial Hand Wipes	—	4
LOCTITE Instant Gasket	LOCTITE 5970	6
LOCTITE Insulating & Sealing Wrap, Black, 1" X 10'	No Similar Product Available	9
LOCTITE Insulating & Sealing Wrap, Black, 2" X 36'	No Similar Product Available	9
LOCTITE Insulating & Sealing Wrap, Red, 1" X 10'	No Similar Product Available	9
LOCTITE Luer/Stepped Nozzles for 50 ml Speedbonder (10 Per Pack)	Appropriate Nozzles are Available	8
LOCTITE Maxi-Coat, Rust Inhibitor	LOCTITE 7803	5
LOCTITE Maximum Strength Headliner Adhesive	ADHESIN J1626	3
LOCTITE Moly Dry Film Lubricant	LOCTITE 8191	10
LOCTITE Moly Paste, Metal-Free	LOCTITE 8012	1
LOCTITE Natural Blue Biodegradable Cleaner & Degreaser, All-Purpose	LOCTITE 7840	4
LOCTITE Nickel Anti-Seize	LOCTITE 8009	1
LOCTITE Non-Chlorinated Parts Cleaner	TEROSON Brake Clean	4

INDEX

LOCTITE PRODUCT DESCRIPTION INDEX

PRODUCT DESCRIPTION	ALTERNATIVE PRODUCT	PAGE NO.
LOCTITE ODC-Free Cleaner & Degreaser	—	4
LOCTITE O-Ring Making Kit	—	9
LOCTITE Penetrating Oil	LOCTITE 8001	10
LOCTITE Pro Strength Parts Cleaner	LOCTITE 7063	4
LOCTITE PTFE Thread Sealing Tape, ½" X 520" X 0.003"	No Similar Product Available	14
LOCTITE QuickTape 249	No Similar Product Available	15
LOCTITE QuickTite Gel	LOCTITE 454	2
LOCTITE Semisolid Stick Empty Holster, Promo Item While Supplies Last	No Similar Product Available	9
LOCTITE Silicone Lubricant	LOCTITE 8104	10
LOCTITE Silver Grade Anti-Seize Stick	No Similar Product Available	1
LOCTITE Smooth Hand Cleaner	—	4
LOCTITE Solvo-Rust Super Penetrating Oil	LOCTITE 8040	10
LOCTITE Static Mixer Nozzle, MC08-24 1:1/2:1	—	8
LOCTITE SUPERFLEX 593 RTV Silicone Sealer, Black	LOCTITE 5970	6
LOCTITE SUPERFLEX 595 RTV Silicone Adhesive, Clear	LOCTITE 5366	6
LOCTITE SUPERFLEX 596 High Temp RTV Silicone Adhesive, Red	LOCTITE 5399	6
LOCTITE SUPERFLEX RTV Silicone Adhesive Sealant, Black	LOCTITE 5980	6
LOCTITE SUPERFLEX RTV Silicone Adhesive Sealant, Blue	LOCTITE 5926	6
LOCTITE SUPERFLEX RTV Silicone Adhesive Sealant, Red	LOCTITE 5399	6
LOCTITE SUPERFLEX RTV Silicone Adhesive, Clear, Noncorrosive	TEROSTAT 9140	6
LOCTITE Toolbox (Contains 220, 222, 243, 263, 248, 249, 268, 518, 545, 561, 565, 587, 660, 7649, 404, 7088, C5-A)	No Similar Product Available	9
LOCTITE VIPERLUBE High Performance Synthetic Grease	LOCTITE 8102	10
Needle, 18GA, ¼" SS, GRN, 50PK	Appropriate Needles Are Available	8
TEROSON FL+	—	16
TEROSON TEROSTAT 8517 P Primer/Activator	—	16
TEROSON TEROSTAT 8519 H Glass Primer	TEROSON TEROSTAT 8517	16
TEROSON TEROSTAT 8597 PL HMLC Direct Glazing Adhesive	—	16
Turco White Solve 'EC' Electrical Contact Cleaner	LOCTITE 7039	5
Yuk-Off Brake And Parts Cleaner	TEROSON Brake Clean	5

INDEX

CATERPILLAR PRODUCT NUMBER INDEX

CLICK ON THE CAT PART NUMBER TO LEARN MORE

CAT PART NUMBER	PRODUCT DESCRIPTION	PAGE NO.
119-0781	LOCTITE SUPERFLEX 595 RTV Silicone Adhesive, Clear	6
138-8436	LOCTITE Hi-Tack Gasket Sealant (Fomerly 30525)	7
141-5830	LOCTITE SUPERFLEX RTV Silicone Adhesive Sealant, Black	6
141-5831	LOCTITE 587 Blue High Performance RTV Silicone Gasket Maker	6
144-7779	LOCTITE FIXMASTER Flex 80 Putty	11
152-9155	LOCTITE 380 Black Max Instant Adhesive	2
154-9731	LOCTITE 271 Threadlocker, High Strength	15
155-0695, 185-3998	LOCTITE 271 Threadlocker, High Strength	15
157-7228	LOCTITE 414 Instant Adhesive	2
165-2601	LOCTITE 5900 Flange Sealant	6
169-5464, 185-4004	LOCTITE 7649 Primer N	12
1U-6132, 207-7531	LOCTITE FIXMASTER Wear Resistant Putty	11
1U-6136, 207-7530	LOCTITE FIXMASTER Superior Metal	11
1U-6140, 207-7532	LOCTITE FIXMASTER Fast Set Steel Putty	11
1U-8846, 185-3982	LOCTITE High Flex Form-In-Place Gasket	7
209-0987	LOCTITE H3000 Structural Adhesive	3
222-3110	LOCTITE Gear, Chain & Cable Lubricant	10
222-3113	LOCTITE All-Purpose Spray Adhesive	3
222-3114	LOCTITE C5-A Copper Anti-Seize Lubricant	1
222-3115	LOCTITE Solvo-Rust Super Penetrating Oil	10
222-3117 & 222-3118	LOCTITE Non-Chlorinated Parts Cleaner	4
222-3119, 222-3124	LOCTITE Electrical Contact Cleaner, Nonflammable	4
222-3121	LOCTITE Maxi-Coat, Rust Inhibitor	5
222-3123	LOCTITE Penetrating Oil	10
226-6624	LOCTITE Clover Silicon Carbide Grease Mix, 80 Grit	8
242-6990	LOCTITE Moly Dry Film Lubricant	10
266-3144	LOCTITE FIXMASTER General-Purpose Epoxy Mixer Cups	3
269-1943	LOCTITE 660 Retaining Compound, Press Fit	13
308-3506, 185-4003	LOCTITE 330 DEPEND Adhesive	3
337-7965	LOCTITE Nickel Anti-Seize	1
3S-6252, 185-3986	LOCTITE SUPERFLEX 593 RTV Silicone Sealer, Black	6
4C-4030	LOCTITE 242 Threadlocker, Medium Strength	15
4C-4032	LOCTITE 609 Retaining Compound, Press Fit, General-Purpose	13
4C-5300, 185-3984	LOCTITE 5127 Flexible Anaerobic Gasket Flange Sealant	7
4C-5592 & 4C5593	LOCTITE Graphite-50 Anti-Seize	1
4C-5598	LOCTITE C5-A Copper Anti-Seize Lubricant	1
4C-5599	LOCTITE C5-A Copper Anti-Seize Lubricant	1
4C-9501	LOCTITE Gasket Sealant #1	7
4C-9502	LOCTITE Gasket Sealant #2	7
4C-9505	LOCTITE 5923 Aviation Gasket Sealant	7
4C-9506	LOCTITE 620 Retaining Compound, Slip Fit, High Temperature	13
4C-9507, 185-3988	LOCTITE 620 Retaining Compound, Slip Fit, High Temperature	13
4C-9509	LOCTITE 290 Threadlocker, High Strength, Wicking Grade	15
4C-9612	LOCTITE 598 Black High Performance RTV Silicone Gasket Maker	6
4C-9614	LOCTITE SUPERFLEX High Temp RTV Silicone Adhesive, Red	6
5H-2471, 185-4591	LOCTITE Black Contact Adhesive	3
5P-3413, 185-3992	LOCTITE 536 Low Breakloose Pipe Sealant	14
5P-3931	LOCTITE C5-A Copper Anti-Seize Lubricant	1
6V-4876, 186-1531	LOCTITE Graphite 50 Anti-Seize	1
6V-6640, 185-3985	LOCTITE Hi-Temperature Flange Sealant	7
7M-7456, 185-3994	LOCTITE 609 Retaining Compound, Press Fit, General-Purpose	13
8T-0065, 186-1527	LOCTITE 5900 Flange Sealant	6
8T-9013, 205-8857	LOCTITE SUPERFLEX 596 High Temp RTV Silicone Adhesive Sealant, Red	6
8T-9014, 205-8858	LOCTITE SUPERFLEX RTV Silicone Adhesive, Noncorrosive, Clear	6
8T-9018 & 8T-9019	LOCTITE FIXMASTER Metal Magic Steel	11
8T-9022, 185-3987	LOCTITE SUPERFLEX RTV Silicone Adhesive Sealant, Blue	6
9S-3263, 185-3996	LOCTITE 242 Threadlocker, Medium Strength	15

FOR MORE INFORMATION AND LATEST VERSION, VISIT WWW.USELOCTITE.COM/CATERPILLAR.

EFFECTIVE 28-AUG-2012.

AMERICAS NORTH

HENKEL CORPORATION
1 Henkel Way
Rocky Hill, CT 06067
USA
Tel: 1-860-571-5100

Canada	Tel: +1-905-814-6511
Mexico	Tel: +52-55-3300-3644

AMERICAS SOUTH

HENKEL LTDA.
Rua Karl Hüller, 136
Jd. Canhema, Diadema
São Paulo, Brazil
09941-410
Tel: +55-11-3205-8955

Argentina	Tel: +54-11-4001-0100
Chile	Tel: +56-2-381-7200

ASIA PACIFIC

HENKEL ASIA-PACIFIC & CHINA HEADQUARTERS
No. 928 Zhangheng Road
Zhangjiang High-Tech Park
Pudong, Shanghai
China, 201203
Tel: +86-21-28918000

Australia	Tel: +61-3-97246444
India	Tel: +91-22-39296600
Indonesia	Tel: +62-21-27586900
Japan	Tel: +81-45-7581800
Malaysia	Tel: +60-3-22461000
New Zealand	Tel: +64-9-2726710
Philippines	Tel: +63-49-5431088
Singapore	Tel: +65-62660100
South Korea	Tel: +82-2-32791700
Taiwan	Tel: +886-2-22271988
Thailand	Tel: +66-2-2098000
Vietnam	Tel: +84-61-3835461

EUROPE, AFRICA, MIDDLE EAST

HENKEL AG & CO. KGaA HEADQUARTERS
Henkelstr. 67
40589 Düsseldorf
Germany
Tel: +49 (0)89-9268-0

Belgium	Tel: +32 2 4212555
Estonia	Tel: +372-730-58-00
France	Tel: +33 164177000
GCC Dubai	Tel: +971-4-3893-333
Italy	Tel: +39-3346059576
Netherlands	Tel: +31-30-6073850
Poland	Tel: +48-22-56-56-200
Rumania	Tel: +40-21-203-26-18
Russia	Tel: +7-495-745-55-88
Spain & Portugal	Tel: +34-93-290-49-05
Turkey	Tel: +90-216-5794000
United Kingdom	Tel: +44 (0)1442 278100

Except as otherwise noted, all marks used are trademarks and/or registered trademarks of Henkel and/or its affiliates in the U.S. and elsewhere. Cat and Caterpillar are registered trademarks of Caterpillar Inc. Inconel and Monel are trademarks of Huntington Alloys Corporation. Kovar is a trademark of CRS Holdings, Inc. Magna-Crete is a trademark of Kelly Restoration.
© Henkel Corporation, 2012. All rights reserved. 8503 (8/12)