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Technical Data Sheet

LOCTITE® 246™

January 2011

PRODUCT DESCRIPTION

LOCTITE® 246™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Dimethacrylate ester
Appearance (uncured)	Blue opaque liquid[LMS]
Fluorescence	Positive under UV light[LMS]
Components	One component - requires no mixing
Viscosity	Medium, thixotropic
Cure	Anaerobic
Secondary Cure	Activator
Application	Threadlocking
Strength	Medium

LOCTITE® 246™ is designed for the locking and sealing of threaded fasteners which require normal disassembly with standard hand tools. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. Particularly suitable for heavy duty applications such as bolts used in transmissions, construction equipment or railroad assemblies where resistance to heavy shock, vibration and stress level is required along with exposure to elevated temperatures. The thixotropic nature of LOCTITE® 246™ reduces the migration of liquid product after application to the substrate.

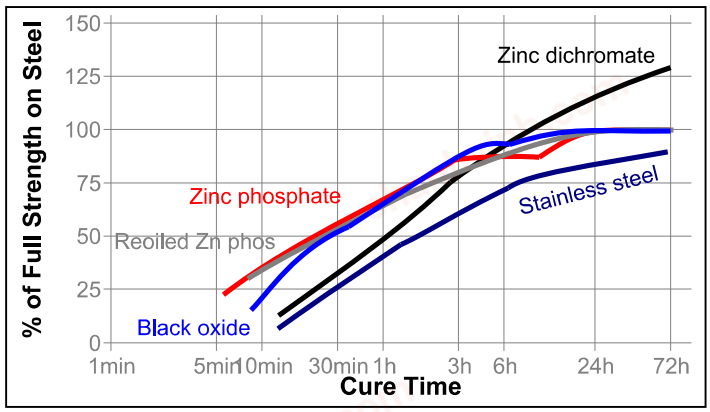
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.15
Flash Point - See SDS	
Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):	
Spindle 3, speed 20 rpm,	2,000 to 4,000[LMS]

TYPICAL CURING PERFORMANCE

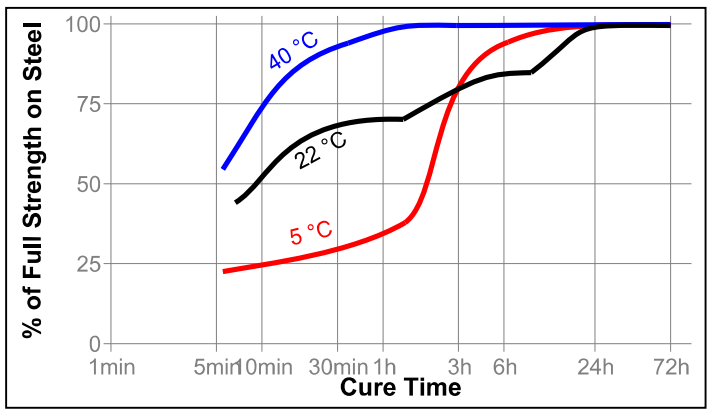
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the breakaway strength developed with time on M10 black oxide steel bolts and mild steel nuts compared to different materials and tested according to ISO 10964.



Cure Speed vs. Temperature

The rate of cure will depend on the temperature. The graph below shows the breakaway strength developed with time at different temperatures on M10 black oxide steel bolts and mild steel nuts and tested according to ISO 10964.



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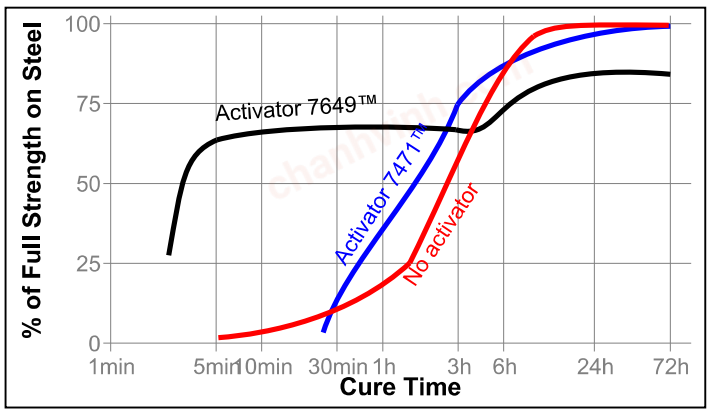
Cure Speed vs. Activator

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the breakaway strength developed with time on M10 zinc dichromate steel nuts and bolts using Activator 7471™ and 7649™ and tested according to ISO 10964.



TYPICAL PERFORMANCE OF CURED MATERIAL

After 24 hours @ 22 °C

Breakaway Torque, ISO 10964:

3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m (lb.in.)	11.3 to 22.6[LMS] (100 to 200)
3/8 x 16 zinc nuts and bolts	N·m (lb.in.)	5.7 to 22.6[LMS] (50 to 200)

Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 black oxide steel nuts and bolts	N·m (lb.in.)	15 to 24 (130 to 210)

Max. Prevail Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 black oxide steel nuts and bolts	N·m (lb.in.)	4 to 9 (35 to 80)

Lubricity, K-Factor:

3/8 x 16 phosphate & oil bolts and steel nuts		0.17

After 24 hours @ 22 °C followed by 72 hours @ 204 °C, tested @ 22 °C

Breakaway Torque, ISO 10964:

3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m (lb.in.)	≥5.7[LMS] (50)

Prevail Torque, ISO 10964:

3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m (lb.in.)	≥2.0[LMS] (18)

TYPICAL ENVIRONMENTAL RESISTANCE

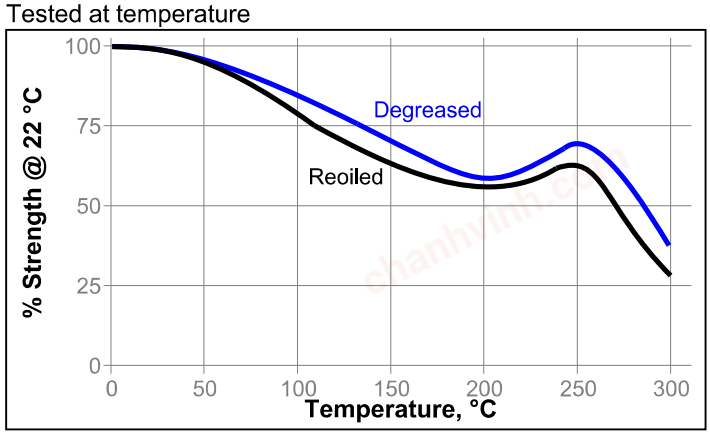
After 24 hours @ 22 °C

Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 zinc phosphate steel nuts and bolts

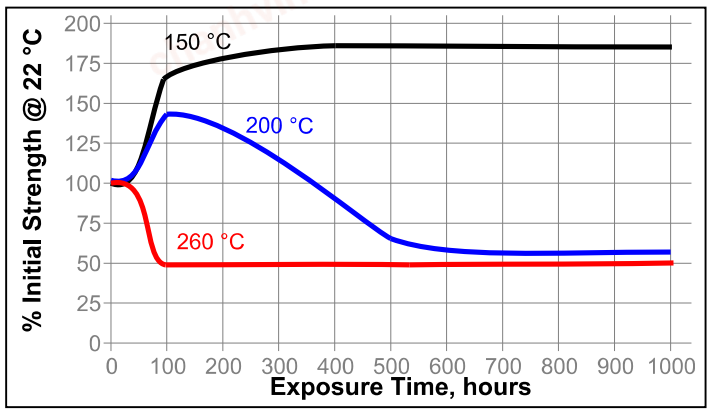
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

		% of initial strength		
Environment	**°C**	**100 h**	**500 h**	**1000 h**
Motor oil (MIL-L-46152)	125	180	180	180
Unleaded gasoline	22	95	95	95
Brake fluid	22	100	110	120
Ethanol	22	90	95	100
Acetone	22	75	75	75
Water/glycol 50/50	87	150	165	165
Transmission fluid	125	175	175	185

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GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use:

For Assembly

1. For best results, clean all surfaces (external and internal) with a LOCTITE® cleaning solvent and allow to dry.
2. If the material is an inactive metal or the cure speed is too slow, spray all threads with Activator 7471™ or 7649™ and allow to dry.
3. Shake the product thoroughly before use.
4. To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during application.
5. **For Thru Holes**, apply several drops of the product onto the bolt at the nut engagement area.
6. **For Blind Holes**, apply several drops of the product down the internal threads to the bottom of the hole.
7. **For Sealing Applications**, apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free. Force the material into the threads to thouroughly fill the voids. For bigger threads and voids, adjust product amount accordingly and apply a 360° bead of product on the female threads also.
8. Assemble and tighten as required.

For Disassembly

1. Remove with standard hand tools.
2. In rare instances where hand tools do not work because of excessive engagement length, apply localized heat to nut or bolt to approximately 250 °C. Disassemble while hot.

For Cleanup

1. Cured product can be removed with a combination of soaking in a Loctite solvent and mechanical abrasion such as a wire brush.

Loctite Material Specification[LMS]

LMS dated January 16, 1999. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties. Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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