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Technical Data Sheet

LOCTITE® 2620™

November 2019

PRODUCT DESCRIPTION

LOCTITE® 2620™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Dimethacrylate ester
Appearance (uncured)	Red paste[LMS]
Components	One component - requires no mixing
Viscosity	High, thixotropic
Cure	Anaerobic
Secondary Cure	Activator
Application	Threadlocking
Strength	Medium to High

LOCTITE® 2620™ is designed for the locking and sealing of threaded fasteners. 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 suited for applications where extreme high temperature resistance is required.

TYPICAL PROPERTIES OF UNCURED MATERIAL

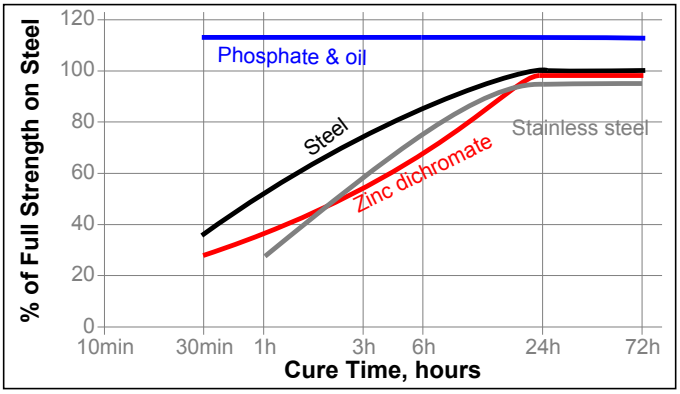
Specific Gravity @ 25 °C	1.16
Viscosity, Cone & Plate, mPa·s (cP), Physica, 50mm Parallel plates at 0.5mm gap @ 50 s-1, 25°C	20,000 to 70,000[LMS]

Flash Point - See SDS

TYPICAL CURING PERFORMANCE

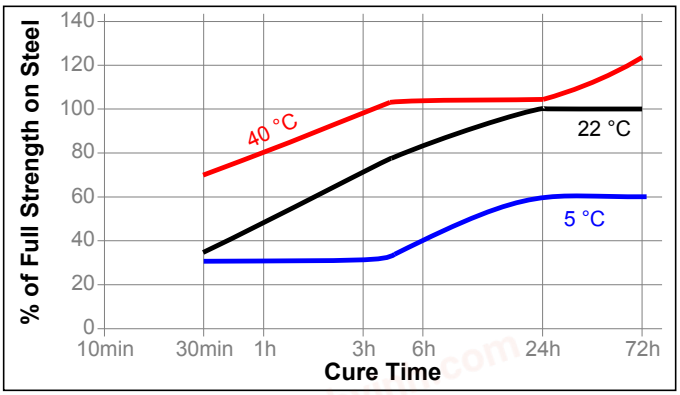
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the breakloose strength developed with time on compared to different materials and tested according to ISO 10964, pretorqued to 5 N·m.



Cure Speed vs. Temperature

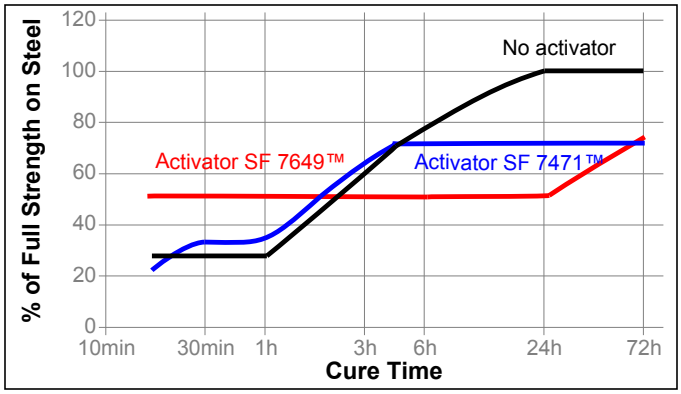
The rate of cure will depend on the temperature. The graph below shows the breakloose strength developed with time at different temperatures on 3/8 x 16 degreased steel nuts & bolts and tested according to ISO 10964, pretorqued to 5 N·m.



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 breakloose strength developed with time using Activator 7471™ and Activator 7649™ on 3/8 x 16 zinc dichromate steel nuts and bolts and tested according to ISO 10964, pretorqued to 5 N·m.

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TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

After 24 hour @ 25 °C

Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:		
3/8 x 16 steel nuts and bolts (grade 5) (degreased)	N·m (lb.in.)	11.4 to 34[LMS] (101 to 301)

After 72 hours @ 25 °C

Breakaway Torque, ISO 10964:		
3/8 x 16 steel nuts and bolts (degreased)	N·m (lb.in.)	18.2 (161)
Prevail Torque, ISO 10964:		
3/8 x 16 steel nuts and bolts (degreased)	N·m (lb.in.)	1.1 (9.7)
Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:		
3/8 x 16 steel nuts and bolts (degreased)	N·m (lb.in.)	27.9 (247)
Prevail Torque, ISO 10964, Pre-torqued to 5 N·m:		
3/8 x 16 nuts and bolts (degreased)	N·m (lb.in.)	0.89 (7.9)
Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:		
3/8 x 16 zinc phosphate & oil nuts and bolts, as received	N·m (lb.in.)	18.5 (164)
Prevail Torque, ISO 10964, Pre-torqued to 5 N·m:		
3/8 x 16 phosphate and oil nuts and bolts, as received	N·m (lb.in.)	2.5 (22)

TYPICAL ENVIRONMENTAL RESISTANCE

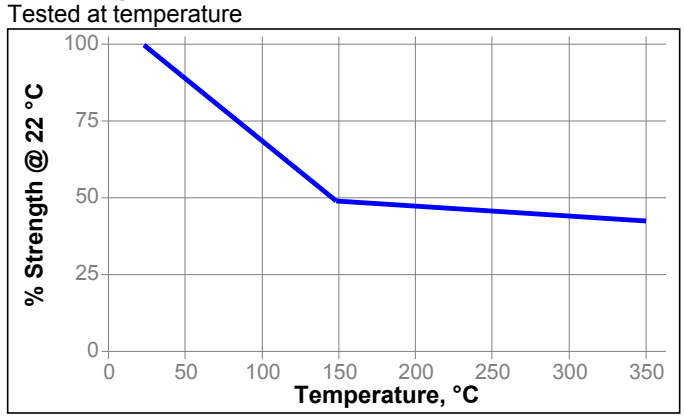
Cured for 1 week @ 22 °C

Breakloose Torque, ISO 10964:

3/8 x 16 phosphate & oil nuts and bolts, as received

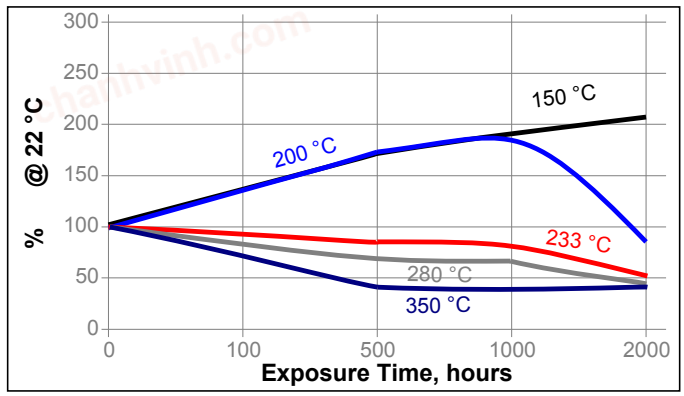
Hot Strength

Tested at temperature



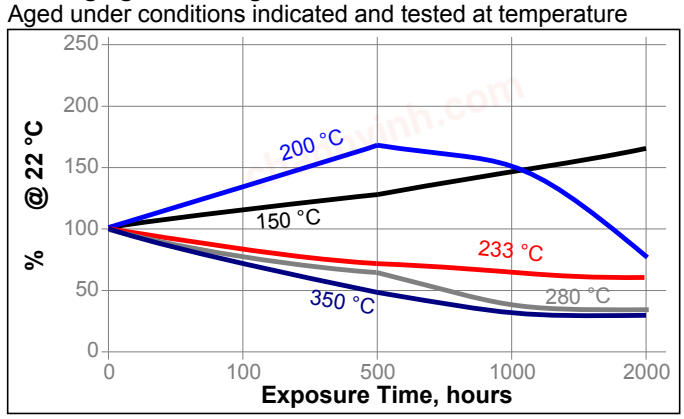
Heat Aging

Aged at temperature indicated and tested @ 22 °C



Heat Aging/Hot Strength

Aged under conditions indicated and tested at temperature



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Chemical/Solvent Resistance
Aged under conditions indicated and tested @ 22 °C.

		% of initial strength		
Environment	**°C**	**500 h**	**1000 h**	**2000 h**
Motor oil	125	134	134	134
ATF	87	100	100	100
Gasoline (unleaded)	22	100	100	100
Brake fluid	22	100	100	100
Water/glycol 50/50	87	111	118	126
Isopropanol	22	100	100	100

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 LOCTITE® SF 7649™ or LOCTITE® SF 7471™ and allow to dry.
3. To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during application.
4. **For Thru Holes**, apply several drops of the product onto the bolt at the nut engagement area.
5. **For Blind Holes**, apply several drops of the product down the internal threads to the bottom of the hole.
6. **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.
7. Assemble and tighten as required.

For Disassembly

1. Remove with standard hand tools.
2. Where hand tools do not work because of excessive engagement length or large diameters (over 1"), apply localized heat to approximately 250 °C (480F). 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 March 17, 2008. 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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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