

Threadlocking Adhesives

How to apply LOCTITE® 222, 243, 248, 270

1. Preparation

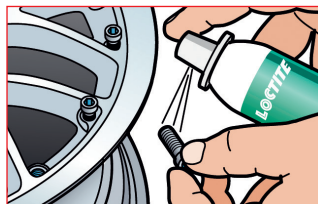
Cleaning

It is recommended to use LOCTITE® 7063 to degrease and clean surfaces prior to applying the adhesive.



Activation

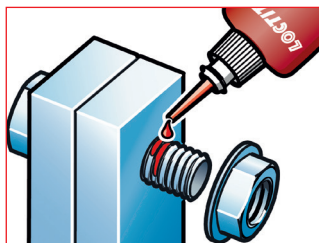
If cure speed is too slow due to passive metals or low temperature (below 5 °C), use activator LOCTITE® 7240 or LOCTITE® 7649 (see cure speed vs. activator graph in the TDS).



2. Application

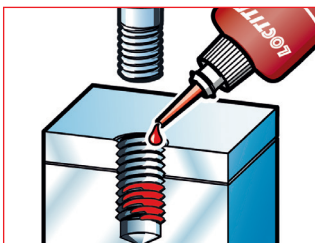
A LOCTITE® 222, 243, 270

Apply liquid threadlocker on the targeted area.



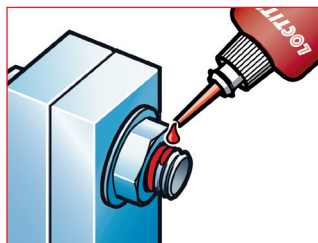
Through hole:

Assemble bolt first and then apply threadlocker.



Blind hole:

Apply into lower third of blind hole.



Post assembly:

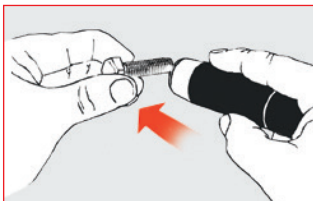
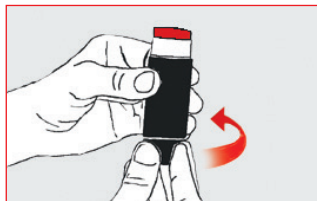
Assemble nut and bolt and dispense product at the edge of nut and bolt.

Equipment

Recommended dispensing equipment: IDH 608966 or IDH 88631 (see chapter **Equipment**).

B LOCTITE® 248

Apply threadlocker on the targeted area.

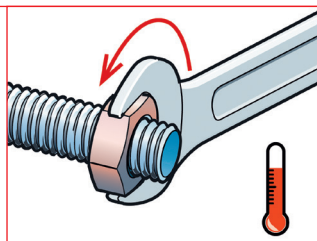
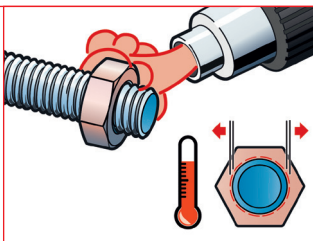
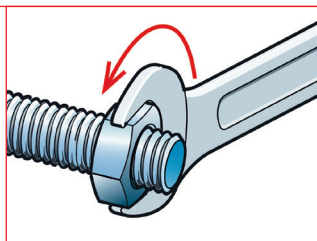


- Twist stick to the amount required
- Apply sufficient product around the thread of the bolt

3. Assembly

- Assemble and tighten
- If several bolts are pre-tightened first, fully tight them within the fixture time of the product or use a slow curing product

4. Disassembly



- Disassemble with standard hand tools
- If not possible, apply localised heat to approximately 250 °C, disassemble while hot
- For corroded or seized parts use LOCTITE® 8040 Freeze & Release

For detailed information please refer to the Technical Datasheet or contact your Henkel Technical Service Team.