

LOCTITE® 5770™

April 2012

PRODUCT DESCRIPTION

LOCTITE® 5770™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Dimethacrylate ester
Appearance (uncured)	Off-white to purplish gray paste ^{LMS}
Components	One component - requires no mixing
Viscosity	High, thixotropic
Cure	Anaerobic
Secondary Cure	Activator
Application	Thread sealing
Strength	Medium

LOCTITE® 5770™ is designed for the locking and sealing of metal threaded pipes and fittings, for industrial applications. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. LOCTITE® 5770™ is particularly suitable for sealing applications of steel metal joints where high temperature and high pressure resistance is required.

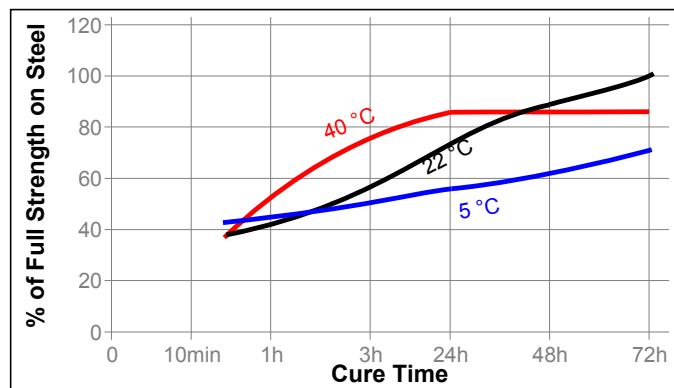
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.27
Flash Point - See SDS	
Viscosity, Cone & Plate, 25 °C, mPa·s (cP):	
Physica, 50mm Parallel plates at 0.5mm gap @ 50 s ⁻¹ , 25°C	30,000 to 90,000 ^{LMS}

TYPICAL CURING PERFORMANCE

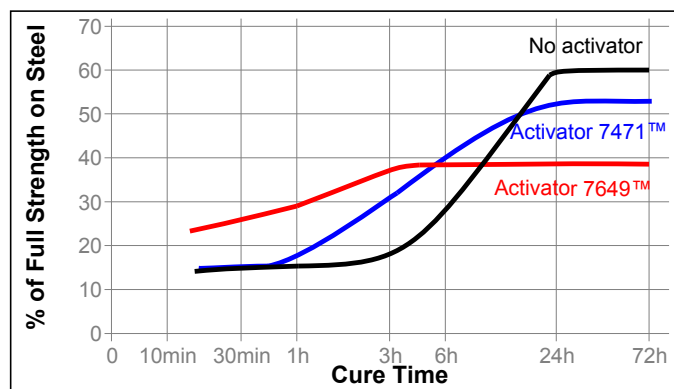
Cure Speed vs. Temperature

The rate of cure will depend on the temperature. The graph below shows the removal torque strength developed with time at different temperatures on 3/8 NPT malleable iron pipe tees and steel plugs and tested according to ASTM D6396. All samples pre-torqued to 27 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 7649™ on 3/8 x 16 zinc dichromate steel nuts and bolts and tested according to ISO 10964, pretorqued to 5 N·m.



TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

After 24 hours @ 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	9.0 to 28.4 ^{LMS}
	(lb.in.)	(79.6 to 251)

After 72 hours @ 22 °C

Removal Torque, ASTM D 6396, Pre-torqued to 27 N·m:

3/8 malleable iron pipe tees and steel pipe plugs, as received N·m 74
(lb.in.) (654)

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

3/8 x 16 phosphate and oil nuts and bolts, as received N·m 28
(lb.in.) (248)

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

3/8 x 16 steel nuts and bolts (degreased) N·m 27
(lb.in.) (239)

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

3/8 x 16 phosphate and oil nuts and bolts, as received N·m 5
(lb.in.) (44)

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

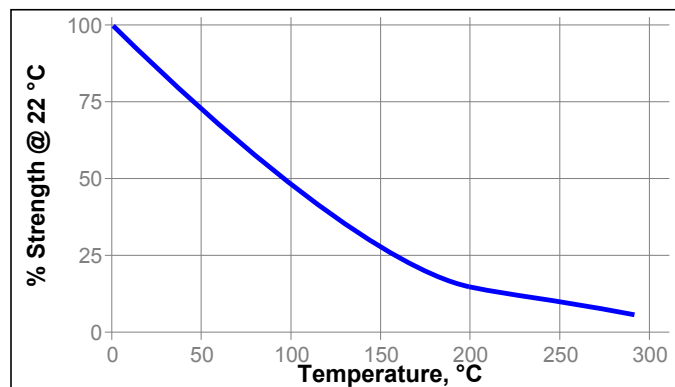
3/8 x 16 steel nuts and bolts (degreased) N·m 4
(lb.in.) (35)

TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 3 days @ 22 °C

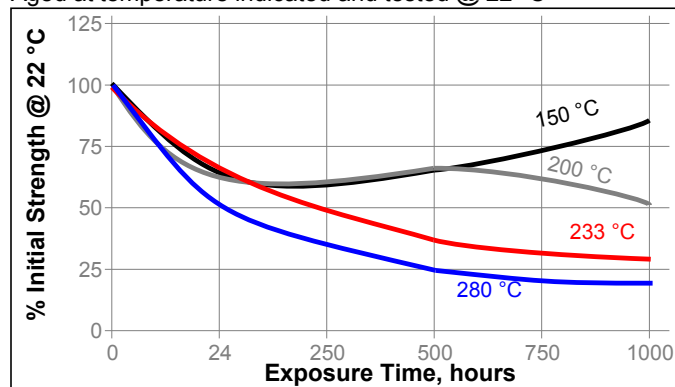
Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:
3/8 x 16 phosphate & oil nuts and bolts

Hot Strength



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Cured for 3 days @ 22 °C

Removal Torque, ASTM D 6396, Pre-torqued to 27 N·m:
3/8 malleable iron tees and steel plugs, as received

Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength	
		500 h	1000 h
Motor oil	125	124	124
ATF	87	133	133
Gasoline	22	93	93
Brake fluid	22	104	104
Water/ethylene glycol 50/50	87	113	113
Isopropanol	22	100	100
E85 Ethanol fuel	22	70	100
B100 Bio-Diesel	22	90	115
DEF (AdBlue®)	22	120	120

Pressure Resistance

LOCTITE® 5770™ was successfully tested for sealability at 100 psi air pressure. NPT 3/8 malleable iron tees and steel plugs, pretorqued to 27 N·m were assembled and allowed to cure at 22°C for 5 minutes prior to testing according to ASTM 6396.

Steam Resistance:

Test Procedure:

Steam weight loss, based on ASTM D6396:

Substrate:

Steam bombs assembled from NPT extra-thick, schedule 160, class 3000, forged steel pipe nipples and forged steel caps, size 1/2 X 2 1/2, as received.:

Cure Procedure:

24 hours at 22°C and 2 hours at 150°C:

Aged under conditions indicated and tested at 22°C

Steam Temperature °C	Steam Pressure MPa	Steam Pressure: PSI	Time	% Steam Weight Loss
232	2.9	420	48 Hours	0
232	2.9	420	7 Days	0
232	2.9	420	21 Days	3
Steam Temperature °C	Steam Pressure MPa	Steam Pressure: PSI	Time	% Steam Weight Loss
250	4.0	575	48 Hours	0
250	4.0	575	7 Days	0
250	4.0	575	21 Days	2
Steam Temperature °C	Steam Pressure MPa	Steam Pressure: PSI	Time	% Steam Weight Loss
280	6.4	930	48 Hours	4
280	6.4	930	7 Days	4
280	6.4	920	21 Days	9

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 with Activator 7471™ or 7649™ and allow to dry.
3. 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 thoroughly fill the voids. For bigger threads and voids, adjust product amount accordingly and apply a 360° bead of product on the female threads also.
4. Using compliant practices, assemble and wrench tighten fittings in accordance with manufacturers recommendations.
5. Properly tightened fittings will seal instantly to moderate pressures. For maximum pressure resistance and solvent resistance allow the product to cure a minimum of 24 hours.

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. 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 July 16, 2001. 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

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{kV/mm} \times 25.4 = \text{V/mil}$$

$$\text{mm} / 25.4 = \text{inches}$$

$$\mu\text{m} / 25.4 = \text{mil}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$$

$$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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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Reference 0.2