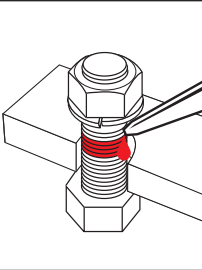
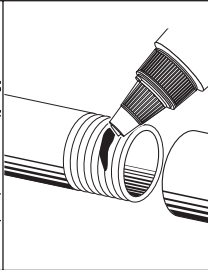
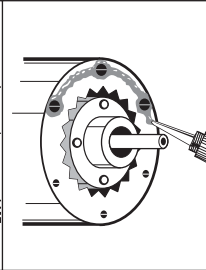
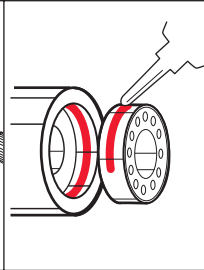


INTRODUCTION

INTRODUCTION TO ANAEROBIC ADHESIVES AND SEALANTS

Anaerobic adhesives and sealants were developed by the founder of Loctite Corporation, now Henkel Corporation, in 1953 and, since then, they have significantly evolved to meet the highest requirements of equipment manufacturers, maintenance and overhaul.

Anaerobic adhesives and sealants are resins that convert from liquid to a tough structural solid in the absence of air and the presence of metal. The primary functions of anaerobic resins are:

Threadlocking	Thread Sealing	Gasketing	Retaining
			

Each one of these functions is based upon control of five major variables: strength, viscosity, adhesion, flexibility, and temperature resistance. These five parameters give anaerobics users considerable latitude in adjusting properties for optimum performance in specific application areas.

Another variable that should be considered is the substrate in which the adhesive will be applied. For certain substrates or other special requirements, the use of primer is recommended.

WHY USE A PRIMER?

1. Primers activate inactive surfaces.
2. Primers speed cure times for faster return to service.
3. Primers speed curing through larger gaps and deep threads.
4. Primers substantially speed cure times on cold parts.
5. Primers act as cleaning agents.

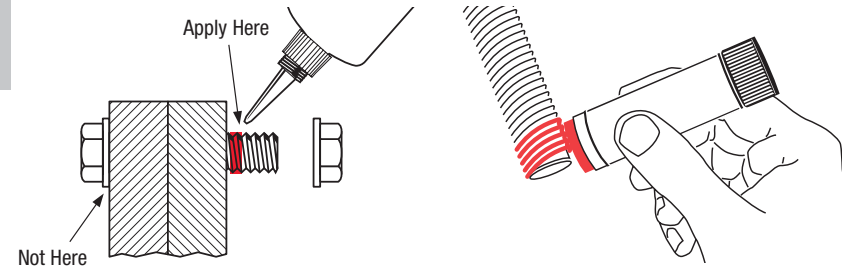
Active surfaces (Primer optional): Brass, copper, bronze, iron, soft steel, nickel.

Inactive surfaces (Primer required): Aluminum, stainless steel, magnesium, zinc, black oxide, cadmium, titanium, others.

THREADLOCKING

THRU HOLES (BOLTS AND NUTS)

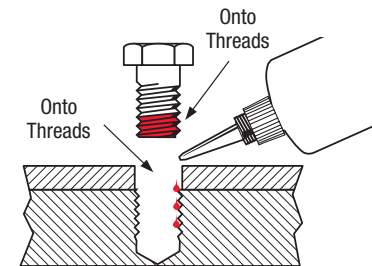
LIQUID AND SEMI-SOLIDS



1. Clean all threads (bolt and nut) with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray all threads with Loctite® 7649™ Primer N™. Allow to dry.
3. Select the proper strength Loctite® threadlocker.
4. Insert bolt into thru hole assembly.
5. Apply several drops of liquid threadlocker onto bolt at targeted tightened nut engagement area or, when using the stick product, completely fill the root of the threads at the area of engagement.
6. Assemble and tighten nut as usual.

BLIND HOLES (CAP SCREWS, ETC.)

LIQUID ONLY



1. Clean all threads (bolt and hole) with Loctite® ODC-Free Cleaner & Degreaser.
2. If necessary, spray (bolt and hole) with Loctite® 7649™ Primer N™. Allow 30 seconds to dry.
3. Select the proper strength Loctite® threadlocker.
4. Squirt several drops down the sides of the female threads.
5. Apply several drops to bolt.
6. Tighten as usual.

Note: Using Loctite® threadlockers will virtually eliminate stripped