Buyer's Guide

A Concept That Was Never Known, Cross References

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AirChem Consumables

FISCHER

LPS

Henkel LOCTITE

Chemetall ARDROX

SEALANTS

RPM

Indestructible

HENTZEN

PPG

PPG Aerospace
PRC-DeSoto

HELLING

Nitto

ExxonMobil Aviation

PROGECO
Technologies de lavage integrees

Kimberly-Clark PROFESSIONAL

bic CARPETS

Testori
Fabrics made in Italy
since 1904



Look Who is Coming to ACC



ACC PRODUCTS LIST
CROSS REFERENCE

SURFACE TREATMENT CHEMICALS PRODUCED BY ACC

No.	ACC PRODUCT DESIGNATION	Concentration	ACC PRODUCT GROUP / DESCRIPTION	ACC PRODUCTS CONFORM TO SPECIFICATIONS	ACC PRODUCTS POSSIBLE CROSS REFERENCE TO			PACKAGE
					ARDROX / ANAC PRODUCTS	TURCO/ MAPAERO PRODUCTS	CEE BEE / PPG ZOK / B&B PRODUCTS	
1	ACC 1100	rtu	Neutral Paint Stripper	AMS 1375B	ARDROX 2526	TURCO 5351 THICK	A-234 R-256	25 KG
2	ACC 1110	rtu	Neutral Paint Stripper (Tank Type)	AMS 1378A	ARDROX 266 ARDROX 666/6	THIN TURCO 5351	A-215	25 KG
3	ACC 1111	rtu	Tank Type Paint Stripper Sodium Chromate Free	Boeing D6-17487 Corrosion Requirement of MIL-PRF-83936C	ARDROX 266 ARDROX 666/6	TURCO 5351	A-215	25 KG
4	ACC 1115	c	Diphase Liquid Paint Stripper for Hot Tank	MIL-PRF-83936B	ARDROX 2302	TURCO STRIPPER 668	A-477	25 KG
5	ACC 1120	rtu	Neutral Peroxide Paint Stripper	AMS 1377 Boeing D6-17487 Rev. R	ARDROX 2870 ARDROX 2871	TURCO 6930	E-3000 E-3000M E-2060	25 KG
6	ACC 1140	rtu	Environmentally Advantaged Hydrogen Peroxide Activated Paint Remover	TT-R-2918 TYPE 1	ARDROX 2870 ARDROX 2871	TURCO 6881	E-3000 E-3000M E-2060	25 KG
7	ACC 1150	rtu	Non Phenolic, Non Chromate, Acid Activated Paint Remover	AMS 1376 MIL-R-81903A	ARDROX 2608 ARDROX 2814	TURCO 6017	R-206 E-204B	25 KG
8	ACC 1160	rtu	Non Phenolic, Non Chromate Paint Remover	AMS 1375, DPM-5649	ARDROX 204 ARDROX 2106HV	TURCO 5873 NC	A-292 A-292NC	25 KG
9	ACC 1170	rtu	Acid Activated Paint remover	AMS 1376	ARDROX 2814	TURCO 5065	A-202	25 KG
10	ACC 2200	c	All Purpose Interior And Exterior Aircraft Cleaner	AMS 1550B AMS 1526C	ARDROX 1900B	TURCO 5948 DPM	SUPER BEE 210	25 KG
11	ACC 2201	c	Aircraft Interior Cleaner	AMS 1550B	NONE	TURCO 5567D	NONE	25 KG
12	ACC 2210	c	All Purpose Cleaner	AMS 1550B AMS 1526C	ARDROX 1900B	MAGNUS 149 X-AERO	INTEX 8201	25 KG
13	ACC 2220	c	Heavy Duty Exterior Aircraft Cleaner	MIL-PRF-85570E TYPE II	ARDROX 1900C	TURCO 6871	SUPER CEE BEE CLEANER 280	25 KG
14	ACC 2230	c	Aircraft Wheel Cleaner	AMS 1537B	ARDROX 6333	TURCO LIQUID SPRAYEZE NP-LT	SUPER BEE 300 IF	25 KG
15	ACC 2240	c	Aircraft Carpet Cleaner	AMS 1630C	ARDROX 485R	TURCO RUG SHAMPOO	NONE	25 KG
16	ACC 2250	c	Aircraft Ferrous And Non Ferrous Cleaner And Deoxidizer	AMS 1384	ARDROX 1218	TURCO 4409	CEE BEE C-623	25 KG



SURFACE TREATMENT CHEMICALS PRODUCED BY ACC

No.	ACC PRODUCT DESIGNATION	Concentration	ACC PRODUCT GROUP / DESCRIPTION	ACC PRODUCTS CONFORM TO SPECIFICATIONS	ACC PRODUCTS POSSIBLE CROSS REFERENCE TO			PACKAGE
					ARDROX / ANAC PRODUCTS	TURCO/ MAPAERO PRODUCTS	CEE BEE / PPG ZOK / B&B PRODUCTS	
17	ACC 2300	c	Aircraft Exterior Aluminum Polish	AMS 1650C DPM-5208 CSD No.17	ARDROX 6017	TURCO 1495 LH	INTEX 8046	10 KG
18	ACC 3300	c	Toilet Disinfectant/ Deodorant Liquid Type Concentrated	AMS 1476C	ARDROX 1823	TURCO BIOFRESH	HONEY BEE 60	25 KG
19	ACC 3310 RTU	rtu	Toilet Disinfectant/ Deodorant Ready To Use Liquid	AMS 1476C	ARDROX 1823 ARDROX 666/6	TURCO BIOFRESH RTU	HONEY BEE 60	BOX 4X5 KG
20	ACC 3320	rtu	Aircraft Toilet Descaler	AMS 1640C	NONE	TURCO AA-10	HONEY BEE CLEANER 60	BOX 12 BOTTLE OF 1 KG
21	ACC 3330	c	Toilet Disinfectant/ Deodorant Sachet Type	AMS 1476B	ARDROX 1809	TURCO ATD II	HONEY BEE PAK 44	200 SACHET Each 20 Gr
22	ACC 3340	c	Aircraft Interior All Pupose Hygiene	AMS 1550B Boeing D6-7127	NONE	TURCO AIRCRAFT DISINFECTANT	HONEY BEE CLEANER 90	25 KG
23	ACC 4400	c	Solvent	MIL-PRF-680C TYPE II	ARDROX 5503	TYPE II TURCO PD 680	NONE	19 KG
24	ACC 4410	c	Solvent	AMS 1525D	NONE	TURCO 4460	PPG CN44	20 LIT
25	ACC 4420-4	c	Solvent MEK Replacement	-	-	-	-	25 LIT
26	ACC 4420-100	c	Solvent MEK Replacement	-	-	-	-	25 LIT
27	ACC 5500	c	Compressor Cleaner	MIL-PRF-85704C TYPE I	ARDROX 252L	TURCO 5884	R-674 B&B 3100	25 KG
28	ACC 5510	c	Compressor Cleaner	MIL-PRF-85704C TYPE II	ARDROX 6375 ARDROX 6367	TURCO 6783	ZOK 27 EZE 206MS	25 KG
29	ACC Abrasive Pads	rtu	Abrasive	MIL-A-9962A TYPE I	NONE	NONE	NONE	PACKED PER 60 PADS EACH PAD: 6"X9 "
30	ACC WS-3	c	One Component Aircraft Interior Coating	BMS 10-83 TYPE VI	NONE	NONE	NONE	1 Gallon
31	ACC WP 4004	c	Washprimer	BMS 10-72 TYPE 5 AIMS 04-04-012 (TN 10.113)	METAFLEX FCR PRIMER	NONE	P-99	5 LIT
32	ACC PP 5005	c	High Solid Polyurethane Primer	AMS 3095A	37047 CF PRIMER	9014-B	CA7700	1 LIT 4 LIT
33	ACC UHS-PT 6006	c	High Solid Polyurethane Topcoat	AMS 3095A	AVIOX 77702	A-1000	CA8000,CA8800 CA9000 series	5 LIT 20 LIT

33 high quality surface treatment & Coatings produced by AirChem Consumables (ACC) with incredibly low prices that no MRO, FBO facilities should be without.



Permacel®
A NITTO DENKO COMPANY

P-11 ALUMINUM FOIL TAPE

APPLICATION

A dead soft aluminum foil tape engineered to handle a wide range of industrial and aerospace application.

P-11 offers the ultimate in moisture vapor protection. Highly recommended for waterproof sealing of drums and canisters, edge sealing of double-pane therm windows, and for heat shielding and elimination of "hot spot" in small appliances.

Also used as a mask for paint stripping and electro-plating operations and for sealing duct joint in heating and air-conditioning systems. And, in the refrigeration industry, P-11 is used as a condenser and evaporator fastener.

During aircraft stripping work, P-11 is used as a window mask and protective covering of critical parts against stripping compounds. It's also used to hold protective drapes in place during stripping, and to form a channel for diverting the wash-off of paints and chemicals.

FEATURES AND BENEFITS

- Aggressive, custom-formulated adhesive adheres tightly when smoothed down on work surfaces.
- Permits clean and easy removal with no residue.
- Dead soft aluminum foil backing provides excellent conformability. Easy to handle, easy to apply and readily conforms to irregular surfaces.
- Acrylic adhesive/foil backing construction make for a vapor-tight seal that effectively combats moisture, contamination and corrosion.
- Aging is practically non-existent because of the inherent stability of aluminium, foil.



TECHNICAL DATA

Backing material	Dead soft aluminum foil
Adhesive	acrylic
Foil thickness	3.0 mils/0.076 mm
Total tape thickness	5.0 mils/0.127 mm
Adhesion to steel	60 oz per in./670 gm per cm
Tensile strength	29 lbs. per in./5.18 kg per cm
Elongation	5.5%
Gov't specification	L-T-80B, MIL-T-23397B



Aircraft De-Painting
A Complete Package

Air Chem Consumables

ACC 1100 Chemically Neutral Paint Remover

Product Group	**Paint remover**
Description	ACC 1100 removes cured two component epoxy and polyurethane coatings from metal substrates.
Characteristics	Ready to use, chemically neutral.
	Applied by non- atomizing spray, brush.
	Can be applied on high strength steel.
	Can be removed with cold water.
	Not to be applied on substrates sensitive to chlorinated hydrocarbons.
	Nonflammable
	Use at room temperature.
Specification	AMS 1375B
Application	Apply a thick layer with ACC paint stripper pump, specially manufactured for this purpose.
	Leave the remover enough time to attack the coating.
	Re activate with stiff brushes.
	Clean mixture of ACC 1100 and coating with high pressure water.
Toxicity and Hazards	Before use always refer to MATERIAL SAFETY DATA SHEET for precautionary, handling and first aid information.
	Protective clothing, made from solvent resistant materials, must be worn when working with this paint remover.
	May cause eye and skin irritation.
	Avoid exposure to high concentrations of vapor.
	Use with adequate ventilation.
	Do not use where ignition sparks may occur because of hazardous gasses.
	Be careful when opening containers to avoid spurting of contents.
	Dispose of ACC 1100 mix with paint residues per applicable regulations. Refer to MATERIAL SAFETY DATA SHEET for additional disposal information.
Storage	Store in closed container at temperatures between 5- 35°C.
Shelf life/Packing	12 Months/ 25 KG Pail



ACC 1120 Peroxide Activated Paint Remover

Product Group	**Paint remover**
Description	ACC 1120 removes cured two component epoxy and polyurethane coatings.
Characteristics	Activated by hydrogen peroxide.
	Can be used on most metal parts.
	Can be used on titanium and high strength steel.
	Do not use on magnesium and cadmium parts.
	Low waste disposal costs.
	Works well on vertical and overhead areas.
Specification	AMS 1377, Boeing D6-17487 Rev. R
Application	Wash the aircraft using ACC 2200 or ACC 2220 in order to get clean, dirt and grease free surface.
	Apply ACC 1120 by ACC ASP pump and leave a layer with 5 mm thickness. The layer should be homogeneous and evenly dispersed all over the surface.
	Allow the paint remover to react with paint for 2-10 hours /In case of old painting system,let paint stripper lay on surface for longer period of time.
	Clean with high pressure cold water. Repeat the same steps for spots removing.
	Use a soft bristle or a scraper to remove the loosen paint from surface.
Toxicity and Hazards	Before use always refer to MATERIAL SAFETY DATA SHEET for precautionary, handling and first aid information.
	Protective clothing, made from solvent resistant materials, must be worn when working with this paint remover.
	May cause eye and skin irritation.
	Avoid exposure to high concentrations of vapor.
	Use with adequate ventilation.
	Be careful when opening containers to avoid spurting of contents.
	Dispose of ACC 1120 mix with paint residues per applicable regulations. Refer to MATERIAL SAFETY DATA SHEET for additional disposal information.
Storage	Store containers at a temperature between 5– 35°C.
Shelf life/Packing	9 Months / 25 KG Pail





EMPLOYING NEW GENERATION ENVIRONMENTALLY-ADVANTAGED PAINT REMOVERS

EXTERIOR CLEANING ▸ COVERING ▸ PAINT STRIPPING ▸ PARTIAL PAINT-REMOVAL ▸ AFTER-STRIP CLEANING

1 EXTERIOR CLEANING

Cleaning the aircraft prior to paint-removal generally yields the most effective and consistent results, and is thus considered an indispensable preliminary step.

Though the use of any appropriate aircraft exterior cleaner may be possible, on top of all we recommend the **ACC 2200** at 10-25% by volume of water.

The prepared solution is then to be applied by spray, mop or brush and then followed by a thorough warm to hot water rinse, in order to prepare the surface for stripping.

At this stage the aircraft surface will have become free of all kinds of physical soil and once totally dry, it is ready for taping and masking.

2 COVERING

Regardless of the type of paint-remover utilized, the sections that require covering should ideally be taped using appropriate non-flying tapes such as the **Permacel P-11** and **P-11 L**.

Some of the importantly sensitive sections to cover in your aircraft include:

- Windows
- Composite structures
- Pitot tube
- Steel clamps
- Doors and access ports
- Wheel well areas
- Landing gear and struts

However it is vital that any other part of the aircraft providing routes to the interior and particularly that to the engine, be properly covered and protected prior to the Paint-removal process.









3 PAINT STRIPPING

Using a stainless steel/TEFLON lined paint stripper transfer pump fitted with a stainless steel airless spray wand, and a 6510 or 9520 non atomizing tip, apply the first layer of the appropriate paint-stripper (the mist coat) to the aircraft.The appropriate type is to be selected through consulting the manual of the respective aircraft. Recommended approved types, suiting various aircraft requirement include:

- **ACC 1100**
- **ACC 1120**

Having applied the mist coat, allow a dwelling time of 30-60 minutes for an initial softening and swelling effect to the paint (signified by bubbles formed on the fuselage), and for facilitating the application of further stripper layers. Afterwards, apply the next full uniform layer of 100-200 microns thickness and allow sufficient time for the remover to work. About an hour before the end of the dwell time, the aircraft surface should be totally agitated with stiff bristly brushes to provide mechanical acceleration and increased efficiency to the process.

The pressure at the nozzle tip of the paint-stripper spraying machine must be approximately 1.5-2 Bars. For paint stripping, start the process from the bottom part of the aircraft and lowest section relative to the horizontal axis of the aircraft, towards both directions, nose and tail. For removal of paint on the surfaces below the wings, apply the stripper on surfaces of the aircraft fuselage at which the wings are attached, as well as to the wingtips.

The last region to undergo the paint-stripping process is the rear section (empennage) of the aircraft, containing the fixed vertical and horizontal stabilizers. Having allowed the stripper on the aircraft fuselage for the required amount of time, ideally the aircraft paint is now essentially chipped and using a squeegee, should be let to descend on the ground. However, if by this stage, the paint removal process is incomplete and unsatisfactory; all the steps mentioned above, with the exception of (mist coat application) have to be repeated until the aircraft paint removal has been effectively accomplished.

EMPLOYING NEW GENERATION ENVIRONMENTALLY-ADVANTAGED PAINT REMOVERS

EXTERIOR CLEANING ▶ COVERING ▶ PAINT STRIPPING ▶ PARTIAL PAINT-REMOVAL ▶ AFTER-STRIP CLEANING

4 PARTIAL PAINT REMOVAL

Once the aircraft's surface has been predominantly stripped of paint, the partial paint-removal stage is undertaken.

In this stage, any type of residual paint spot is eliminated. Surfaces covered with **Permacel** tapes that need to be stripped of paint are removed. This is mainly done by hand (usually through brush application), and then followed by scrubbing and scraping with

ACC ABRASIVE PAD.

Once stripping is complete, squeegee the stripper residues and paint chips. These are to be pushed on the floor and gathered up in open-top sealable drums for disposal as hazardous waste. For spot paint stripping you may use **ACC 1100**.



5 AFTER-STRIP CLEANING

Finally the aircraft is to be washed again with ACC 2200 and allowed to dry, if it is not intended for conversion coating and/or corrosion removing.

For this stage, it is first necessary to divide the aircraft into equal and consecutive sections, each of typically 6 meters length (considering available manpower and equipment).

A very crucial and delicate point to consider in this stage is that the cleaning solution must never be let to dry up on the surface!

Apply the cleaning solution relative to the aircraft's horizontal axis, in the direction of the "Crown" and towards the two ends of the aircraft. After the application of cleaning solution, scrape the intended surface thoroughly using heavy duty

ACC ABRASIVE PAD

After scraping, carefully rinse the surface to be cleaned using a high pressure stream of warm water in large quantity.

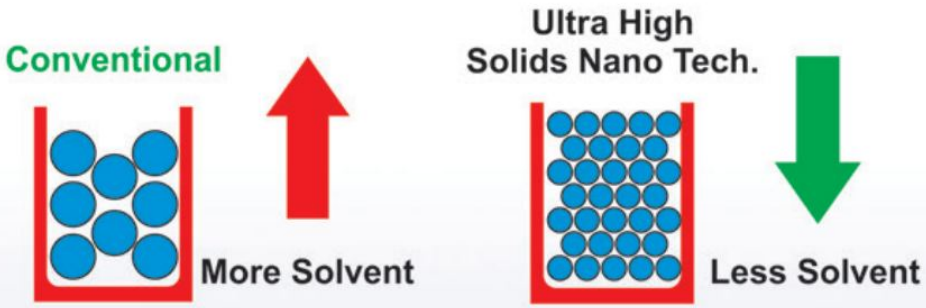
Continue the cleaning process from up to down & vice-versa.

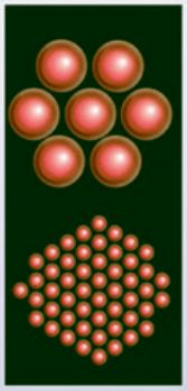


CUT YOUR PAINT STRIPPING JOB IN HALF WITH ACC PAINT STRIPPING PRODUCTS

Ultra High Solids Nano Technology Chrome Free Exterior Paint System VS Conventional Coatings

Resin molecular size and bonds.





Resin molecular size

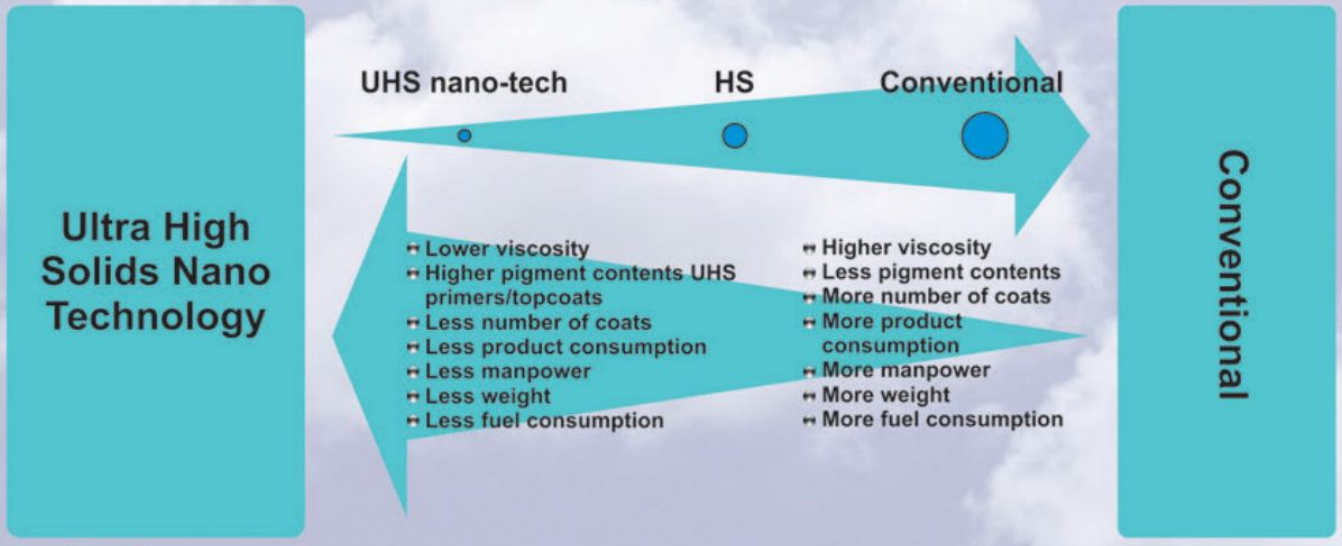
Conventional

- Less molecular net bonds
- Less hiding power
- Less filiform corrosion protection

Ultra High Solids Nano technology

- More molecular net bonds
- More hiding power
- Better filiform corrosion protection

Ultra High Solids Nano Technology



Ultra High Solids Chrome Free Nano Technology Paint System Features:

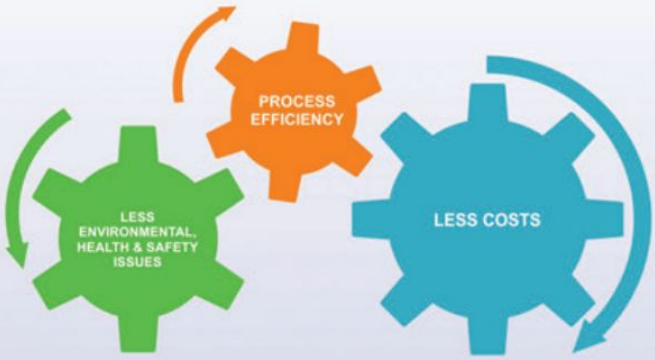
- Highest quality of corrosion protection
- Environmental sustainability
- Cost effectiveness
- Less residual disposal costs than chrome containing materials



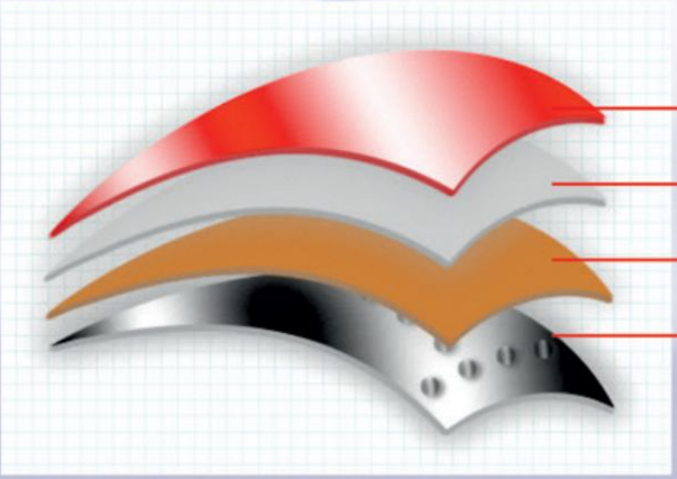


- Non corrosive, Non toxic

- 50% VOC reduction obtained in average compared to conventional chrome containing products.
- Full REACH compliance.
- Less Health and Safety hazards during sanding application due to Chrome Free formulation.



UHS Chrome Free Paint Scheme AMS 3095A



- Direct Gloss Topcoat ACC-UHS-PT-6006
- Chrome Free High Solids Primer ACC-PP-5005
- Wash Primer ACC-WP-4004
- 2024 clad abraded Substrate

UHS Chrome Free Paint Scheme Application

ACC-WP-4004 (switch-off electrostatic) — 07 -10 µm 1 coat

↓

ACC-PP-5005

↓

3h for sanding,
1h over-coating time
wet-on-wet 22°C / 60% RH. — 25-35 µm ,1 cross coat

↓

ACC-UHS-PT-6006 High Gloss Topcoat

NO INDUCTION TIME REQUIRED — 50-60µm in 2 coats
1h between coats

ACC-UHS PT 6006 Fully Conforms to AMS 3095A

New UHS Chrome Free Paint Scheme AMS 3095A requirements

Substrate	implement Test	Conditions	AMS 3095A requirement	Results
2024 clad abraded	Adhesion ISO2409	-	G=0	G=0 PASS
2024 clad abraded	Water resistance ISO2812-2	14 days @ 23°C	G=1 max	G=0-1 PASS
2024 clad abraded	Skydrol resistance ISO1518	30 days @ 23°C	1500g min	> 2000 g PASS
2024 clad abraded	Filiform corrosion EN3665	1000h	3mm max filament from scribe	2- 2,6 mm PASS
2024 clad abraded	Neutral Salt Spray ISO7253	3000h	3mm max creep from scribe	1- 2,5 mm PASS

Technical Data Sheets

ACC WP 4004
Wash Primer

Product Group: Washprimer

Description: **ACC WP 4004** washprimer is designed for use on aircraft aluminium substrates and other equipment in combination with the additional primer **ACC PP 5005** to obtain optimal filiform corrosion resistance.

Characteristics: Application of **ACC WP 4004** replaces the use of Alodine or Alochrome

Appearance	Semigloss, brown/yellow
Theoretical Coverage	At 7-10 microns 8 sqm p/L base
Viscosity mixed RT and RH 30-70%	16-18 seconds AFNOR cup 4 13-16 seconds DIN cup 4 15-17 seconds FORD cup 4
Pot life when mixed RT and RH 30-70%	8 hours
Drying times RT and RH 30-70%	Dust free: 15-20 minutes Dry for next coat: 1.5-2.0 hours Dry to tape: 2-24 hours
Mixing ratio Volume	1:1 with Activator(Hardener) ACC ACT 1004 Stir ACC WP 4004 till uniform liquid. Add Activator (Hardener) ACC ACT 1004 and stir till homogeneous.

Specification: AIMS 04-04-012 (TN 10.113)
BMS 10-72 type V

Surface preparation & application:
- Clean the area to be painted with ACC 2220 to remove all contamination.
- Scuff sand with ACC Abrasive pads
- Clean again with ACC 2220.
- Apply a wet coat of mixed ACC WP 4004 resulting in a dry thickness of 7-10 micron.

Application Equipment:

Conventional Air Spray
Atomizing Air pressure: 43,50 to 72.50 psi
Pot pressure (if applicable): 21 to 29 psi
Tip Size: 1.2 to 1.5 mm (0.046 to 0.059 inch)

Air Assist Airless, Switch off electrostatic.
Fluid pressure: 1400 to 1850 psi
Atomizing Air pressure: 43.50 to 72.50 psi
Tip Size: 0.23 to 0.28. mm (0.009 to 0.011 inch)

HVLP
Input Air pressure: 21 to 29 psi
Fluid/Pot pressure: 21 to 29 psi
Tip Size: 1.5 to 1.8 mm (0.059 To 0.071 inch)

Airless
Fluid pressure: 870 psi to 1450 psi
Tip size: 0.22 to 0.28mm (0.009 to 0.011 inch)

Cleaning of equipment: Use Thinner ACC DIL 5011 or ACC 4400

Shelf life and Packaging:
- 24 months from date of manufacturing.
- After opening the tins, it should be used within 2 months.
- ACC WP 4004 is delivered in 5 L cans.

Health, safety, environment:
- Use with adequate ventilation and proper respiratory protection.
- See MSDS for complete details of composition and precautions.

HS/GN code: 3208 10 90

HS/GN code for Thinner ACC DIL 5011 = 3814 0090

ACC PP 5005
Polyurethane Primer

Product Group: Polyurethane Primer

Description: **ACC PP 5005** chromate free polyurethane primer is a high solids, very flexible, easy to sand, anticorrosion primer with high chemical resistance.

Characteristics: On aluminum substrates **ACC PP 5005** should be applied on top of **ACC WP 4004**, but it can also be sprayed directly on composite materials as a spray filler.

Appearance	Standard grey, colors on request
Theoretical Coverage	At 25 -30 microns: 20-22 sqm p/L base.
Viscosity mixed RT and RH 30-70%	As anti corrosion primer: / As spray filler 17-23 seconds AFNOR cup 4 / 84-100 seconds AFNOR cup 4 15-19 seconds DIN cup 4 / 65-72 seconds DIN cup 4 15-21 seconds FORD cup 4 / 78-88 seconds FORD cup 4
Pot life when mixed RT and RH 30-70%	2 hours
Drying times RT and RH 30-70%	As anti corrosion primer: Dust free: 20 minutes; Dry for next coat: 1hour; Dry to tape: 3 hours As spray filler: Dust free: 20 minutes; Dry for next coat: 1hour; Dry to sand: 3-4 hours; Dry to tape: 3 hours
Mixing ratio Volume	As anti corrosion primer: Mix 4 parts of ACC PP 5005 with 1 part of Activator (Hardener) ACC ACT 1001, stir well and add 1 part Thinner ACC DIL 5020 Stir till homogeneous. As spray filler: Mix 4 parts of ACC PP 5005 with 1 part of Activator (Hardener) ACC ACT 1001, stir well till homogeneous

Specification: AMS 3095A

Surface preparation & application:
As anticorrosion primer
Apply one even wet cross coat of ACC PP 5005 directly on ACC WP 4004 within 8 hours.
As spray filler
Apply ACC PP 5005 in 1-2 uniform coats directly on top of cleaned and sanded composites using ACC 2220 and ACC Abrasive pads.

Application Equipment:

Conventional Air Spray
Atomizing Air pressure: 44 to 72 psi
Pot pressure (if applicable): 22 to 36 psi
Tip Size: 1.2 to 1.6 mm (0.046 to 0.063 inch)

Air Assist Airless, Electrostatic
Fluid pressure: 725 to 870 psi
Atomizing Air pressure: 44 to 50 psi
Tip Size: 0.22 to 0.27 mm (0.011 to 0.013 inch)

HVLP
Input Air pressure : 21 to 29 psi
Fluid/Pot pressure: 21 to 29 psi
Tip Size: 1.5 to 1.8 mm (0.059 To 0.071 inch)

Airless
Fluid pressure: 870 psi to 1450 psi
Tip size: 0.22 to 0.28mm (0.009 to 0.011 inch)

Cleaning of equipment: Use Thinner ACC DIL 5020 or ACC 4400

Shelf life and Packaging:
- 24 months from date of manufacturing.
- After opening the tins, it should be used within 2 months.
- ACC PP 5005 is delivered in 4 L cans.

Health, safety, environment:
- Use with adequate ventilation and proper respiratory protection.
- See MSDS for complete details of composition and precautions.

HS/GN code: 3208 10 90

HS/GN code for Thinner ACC DIL 5020 = 3814 0090

ACC UHS PT 6006

Product Group
Ultra High Solids Polyurethane Topcoat

Description
ACC UHS PT 6006 is designed for the protection and decoration of the aircraft exterior.
ACC UHS PT 6006 is easy to apply, has excellent UV and abrasive resistance and may be polished if needed after full cure.

Characteristics

Appearance	High gloss, semigloss and matt in any color of international standard.
Theoretical coverage	At 25-35 microns: 20 m/L BASE.
Viscosity mixed RT and RH 30-70%	17-31 seconds AFNOR cup 4 17-27 seconds DIN cup 4 15-25 seconds FORD cup 4
Pot life when mixed RT and RH 30-70%	2 hours
Drying Times RT and RH 30-70%	Dust free 15-25 minutes Dry for next coat 15-45 minutes Dry to tape 3 - 4 hours Dry to fly 48 hours Full cure 7 days
Mixing Ratio Volume	Mix 4 parts of ACC UHS PT 6006 with 2 part of Activator(Hardener) ACC ACT 1003,stir and add 1 part of Thinner ACC DIL-5020 till homogeneous.

Note: Depending on the mode of application and environmental conditions select correct hardener Activator (Hardener) ACC ACT 1002_Fast; Activator (Hardener) ACC ACT 1003_Standard; Activator(Hardener) ACC ACT 1005_Slow.

Specification
AMS 3095

Surface preparation and application
Apply two even wet coats on top of the cured ACC PP 5005 that may need a slight treatment with ACC Abrasive pads if drying time has exceeded 8 hours.
As it concerns a high solid topcoat the film build up is different from standard topcoats. Attention is required not to apply too much coating to avoid sags and runs.

Application Equipment

Conventional Air Spray
Atomizing Air pressure: 45 to 60 psi
Pot pressure (if applicable): 10 to 25 psi
Tip Size: 1.2 to 1.6 mm (0.046 to 0.063 inch)

Air Assist Airless, Electrostatic
Fluid pressure: 750 to 1250 psi
Atomizing Air pressure: 40 to 60 psi
Tip Size: 0.22 to 0.27 mm (0.011 to 0.013 inch)

HVLP
Input Air pressure: 10 to 20 Psi
Fluid/Pot pressure: 10 to 25 psi,
Tip Size: 1,0 to 1,4 mm (0.039 To 0.055 inch)

Airless
Fluid pressure: 870 psi to 1450 psi
Tip size: 0.22 to 0.28mm (0.009 to 0.011 inch)

Cleaning of equipment
Use Thinner ACC DIL-5020 or ACC 4400

Shelf life and Packaging (RT)
24 months from date of manufacturing.
After opening the tins, it should be used within 2 months.
ACC UHS PT 6006 is delivered in 4 L Cans.

Health, safety, environment
Use with adequate ventilation and proper respiratory protection.
See MSDS for complete details of composition and precautions.

HS/GN code:3208 10 90

HS/GN code for Thinner ACC DIL 5020 = 3814 0090

Notice

Because we cannot anticipate or control the many different conditions which this information and our products may be used, we do not guarantee the applicability and accuracy of this information or the suitability of our products in any given situation. Users of our products should make their own tests to determine the suitability of each product for their particular purposes.

ACC WS-3
ONE/TWO COMPONENT INTERIOR COATINGS

Advantages of ACC WS-3

- Excellent Adhesion
- Very good scratch and solvent resistance
- Stain resistance and easy to clean
- Semigloss, available in any color
- BMS 10-83, TYPE VI – DPM 5948

Benefits of using ACC WS-3 as one component interior coatings

Non hazardous shipment →	Less shipment charges
No mixing is required. →	Easy to apply
Water soluble →	No thinner for cleaning equipment
Safe to apply →	No flammable hardener needed
Less expensive	

ACC WS-3 as two component Interior Coatings

ACC AX-42 may be added to enhance chemical and scratch resistance for areas exposed to damage like cargo bays and galleys. Mixing Ratio: 8:1 (4 liter ACC WS-3 with 0.5 liter hardener AX-42)

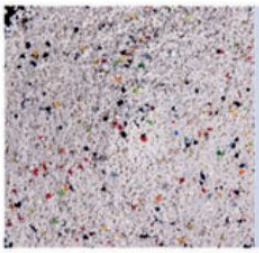
Technical Data Sheets

ACC WS-3
One Component
Aircraft Interior Coating

Product Group	**Polyurethane waterborne topcoat**
Description	ACC WS-3 is designed for application on different substrates of the aircraft interior. ACC WS-3 is easy to apply, has excellent adhesion, very good scratch and solvent resistance, good stain resistance and is easy to clean. For most areas this product is well suited, if improved performance is required, ACC Hardener AX-42 may be added.
Characteristics	
Appearance	Semigloss, in any color of international standard.
Theoretical coverage	18 sqm/L base at thickness of 25 microns.
Viscosity RT and RH at 30-70%	40-65 seconds ISO cup 6
Pot life when mixed RT and RH at 30-70%	4 hours
Drying Times RT and RH 30-70%	Dry to touch 30-60 minutes Tack free 1- 2 hours Dry hard 8 hours
Mixing Ratio Volume if required	Mix 1 part of ACC Hardener AX-42 to 8 parts of ACC WS-3 by volume, by stirring. Do not use a shaker.
Specification	BMS 10-83 type VI DPM 5948
Application Equipment	Any standard suction, pressure pot, HVLP or airless spray. Note: ACC WS-3 can be rolled with a foam roller which makes it easy to achieve a textured finish.
Cleaning of equipment	Immediately after use clean with water, in a later stage acetone may be used to dissolve residues.
Shelf life and Packaging (RT)	ACC WS-3 is delivered in 1 quart and 1 gallon kits.
Health, safety, environment	Use with adequate ventilation and proper respiratory protection. See MSDS for complete details of composition and precautions.

Notice
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Type II is made of fully (100 %) hardened UREA moulding parts. In further workflows it will filtered according to American standard mesh-sizes and moistened with a special anti-static agent



Type III is made of fully (100 %) hardened MELAMIN moulding parts. In further workflows it will filtered according to American standard mesh-sizes and moistened with a special anti-static agent. Due to the higher hardness compared to Type II it can achieve a higher blast media efficiency. The abrasive consumption is approx. 20 % less compared to the Type II.



Type V is made of fully (100 %) hardened ACRYLIC parts. In further workflows it will filtered according to American standard mesh-sizes and moistened with a special anti-static agent. It's suitable for the shot blasting of soft/thin nonferrous metals and composite parts. The Type V doesn't produce any harshness on soft metals and galvanic coatings with an approx. 10 % higher stripping rate compared to the Type II. The consumption of blasting media is approx. 50 % less than Type II.

Type II, Type III and Type V have been certified by the U.S. Air Force according to MIL-P-85891 and can be used for cleaning and paint stripping of surfaces in the aircraft industry and the military sector.

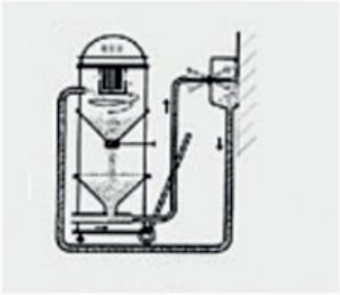
Many other approvals on request.



Blast systems

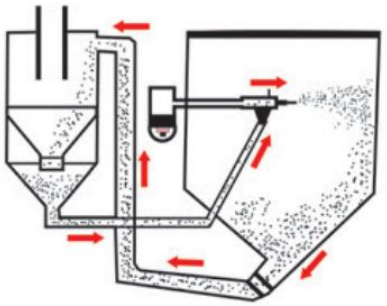
VACUUM BLAST SYSTEM

6 mm nozzle at 47 l/sec. air pressure
Exit velocity: 80 m/sec
Blast media throughput: 25 kg/h
Blast media consumption: 0,4 kg/h
Air consumption (compressed air): 8 m3/min
Electric consumption: 4,2 kWh
Performance factor: 1 (corr. to blast media throughput)



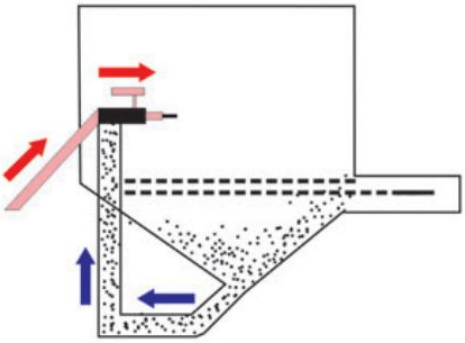
INJECTION BLAST SYSTEM

8 mm nozzle at 4 bar air pressure
Exit velocity: 60-100 m/sec
Blast media throughput: 50 kg/h
Blast media consumption: 0,7 kg/h
Air consumption (compressed air): 0,5 m3/min
Electric consumption: 5,3 kWh
Performance factor: 2 (corr. to blast media throughput)



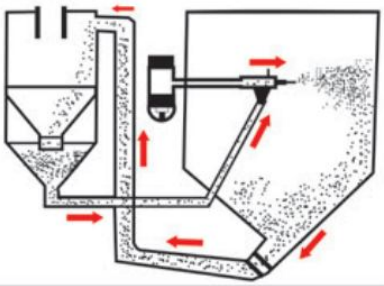
WATER BLAST SYSTEM

8 mm nozzle at 4 bar air pressure
Exit velocity: 60-200 m/sec
Blast media throughput: 200 kg/h
Blast media consumption: 1-4 kg/h
Air consumption (compressed air): 2-5 m3/min
Electric consumption: 5-10 kWh
Performance factor: 8 (corr. to blast media throughput)



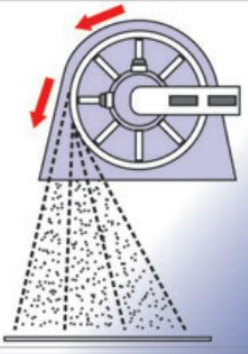
PRESSURE BLAST SYSTEM

8 mm nozzle at 4 bar air pressure
Exit velocity: 150-250 m/sec
Blast media throughput: 250 kg/h
Blast media consumption: 4 kg/h
Air consumption (compressed air): 2,8 m3/min
Electric consumption: 11,4 kWh
Performance factor: 10 (corr. to blast media throughput)



BLAST WHEEL SYSTEM

300 mm Ø
Exit velocity: 80 m/sec
Blast media throughput: 3600 kg/h
Blast media consumption: 30 kg/h
Air consumption (compressed air): – m3/min
Electric consumption: 7,5 kWh
Performance factor: 144 (corr. to blast media throughput)





PRODUCT OVERVIEW FISCHER GmbH knusts toff-Strahlmittel - Plastic Blast Media	TYPE II (UREA + antistatic) Certified by the U.S. Air Force By MIL-P-85891	TYPE III (MELAMINE + antistatic) Certified by the U.S. Air Force By MIL-P-85891	TYPE V (ACRYLIC + antistatic) Certified by the U.S. Air Force By MIL-P-85891
Colour			
	white / multicolour	white / multicolour	light
Physikal Properties			
hardness Mohs / HRR	3,5 Mohs	4,0 Mohs	3,5 Mohs
Spec. weight (gr./cm3)	1,45 – 1,52	1,45 – 1,52	1,10 – 1,20
bulk density (gr./ltr.)	700 - 800	700 - 800	550 - 650
ignition temperature	> 500 °C	> 500 °C	> 100 °C
Delivery Details			
properties	ripple granules	ripple granules	ripple granules
packed in PE-bags	25 kg / bag	25 kg / bag	20 kg / bag
packed in Fibre-Drums	50 kg or 125 kg / Drum	50 kg or 125 kg / Drum	40 kg or 100 kg / Drum
max. weight per palette	1.000 kg	1.000 kg	1.000 kg
Standard-Sizes			
60 – 80 mesh 0,18-0,25 mm	X	X	
40 – 60 mesh 0,25-0,40 mm	X	X	X
30 – 40 mesh 0,40-0,60 mm	X	X	X
20 – 40 mesh 0,40-0,80 mm	X	X	X
20 – 30 mesh 0,60-0,80 mm	X	X	X
16 – 20 mesh 0,80-1,20 mm	X	X	X
12 – 20 mesh 0,80-1,70 mm	X	X	
12 – 16 mesh 1,20-1,70 mm	X	X	
Special-Sizes			
	on request	on request	on request

LUBRICANTS

DRY FILM LUBRICANT



LPS 1®
GREASELESS LUBRICANT

NEW LOOK

- Provides a dry, thin, lubricating film
- Resists oil, dust, and dirt build-up
- Fast acting penetration
- Loosens rusted or frozen parts
- Provides a short term, light, corrosion resistant barrier
- Ideal for delicate mechanisms
- Safe on paint and most plastics
- Nonfood Compounds Program Listed Category Code: H2 Registration #059847 (Aerosol); #129040 (Bulk)
- Acceptable for use in Canadian Food Processing Establishments

NET CONTENTS	LPS #
144 single towels per case	00144
11 wt. oz./312 g/379 mL	00116
20 fl. oz. (591 mL) Trigger	00122
1 gal. (3.78 L)	01128
5 gal. (18.93 L)	00105
55 gal. (208 L)	00155

WET FILM LUBRICANT



LPS 2®
HEAVY-DUTY LUBRICANT

NEW LOOK

- Strong, multi-purpose lubricant, and penetrant with added corrosion protection
- Provides a non-drying, light, oily fi lm for use on indoor/outdoor equipment
- Reduces wear caused by friction and corrosion
- Loosens rusted or frozen parts
- Provides up to one year of protection
- Nonfood Compounds Program Listed Category Code: H2 Registration #129026 (Aerosol); #059848 (Bulk)
- Acceptable for use in Canadian Food Processing Establishments

NET CONTENTS	LPS #
11 wt. oz./312 g/379 mL	00216
20 fl. oz. (591 mL) Trigger	00222
1 gal. (3.78 L)	02128
5 gal. (18.93 L)	00205
55 gal. (208 L)	00255

WAX AND RESIN-BASED, CORROSION INHIBITORS



- Nobody hates rust more than I do. Thats why I use LPS 3 and LPS Cold Galvanize.



LPS 3®
PREMIER RUST INHIBITOR

NEW LOOK

- Protects for up to 2 years indoors
- Prevents rust and corrosion
- Provides non-sling lubrication
- Self-healing, soft, waxy film
- Safe to use on most surfaces
- Nonfood Compounds Program Listed Category Code: H2 Registration #129027 (Aerosol); #059849 (Bulk)
- Acceptable for use in Canadian Food Processing Establishments

NET CONTENTS	LPS #
11 wt. oz./312 g/380 mL	00316
28 fl. oz. (828 mL) Trigger	00322
1 gal. (3.78 L)	03128
5 gal. (18.93 L)	00305
55 gal. (208 L)	00355



PROCYON
CORROSION INHIBITOR

NEW AEROSOL LOOK ARRIVING 2015

- Protects aluminum from salt fog for more than 2,500 hours
- Multi-year protection of metal
- Durable, hard, transparent film
- Resistant to saltwater, salt spray, moisture, acid, alkali fumes and other corrosive elements
- Wide operating temperature range
- Resists dripping and puddling during spray application
- Ready-to-use and can be applied with conventional airless or air-operated spray equipment
- Safe to use on most surfaces

NET CONTENTS	LPS #
10 wt. oz./284 g/394 mL	04216
1 gal. (3.78 L)	04228
5 gal. (18.93 L)	04205
55 gal. (208 L)	04255



HARDCOAT
CORROSION INHIBITOR

NEW AEROSOL LOOK ARRIVING 2015

- 1,500+ hours salt spray resistance on aluminum
- Commonly used on sides and tops of aircraft fuselages
- Resists dripping and puddling during spray application
- Durable, hard, transparent film
- Ready-to-use and can be applied with conventional airless or air-operated spray equipment
- Safe to use on most surfaces

NET CONTENTS	LPS #
10 wt. oz./284 g/396 mL	03316
1 gal. (3.78 L)	03328
5 gal. (18.93 L)	03305
55 gal. (208 L)	03355

ZINC_BASED CORROSION INHIBITOR



NEW AEROSOL LOOK ARRIVING 2015

BRIGHTCOAT COLD GALVANIZE
CORROSION INHIBITOR

NO CHLOR SOLV · HI TEMP

- Shiny zinc coating
- Prevents rust and corrosion on all metals
- Restores hot dip galvanizing
- Dries to touch in 15 to 30 minutes
- Repairs rusted, galvanized, and welded surfaces
- Electrochemically protects bare metal
- Heat resistant, flexible coating
- Will not yellow, chalk, crack, or peel

NET CONTENTS	LPS #
13 wt. oz./369 g/459 mL	05916



NEW AEROSOL LOOK ARRIVING 2015

COLD GALVANIZE
CORROSION INHIBITOR

CARB ✓ · OTC ✓ · HI TEMP

- Zinc-rich galvanized coating - Zinc Purity: 99+%
- Works like a hot-dip on ferrous metals indoors and out
- Withstands water temperature up to 212°F (100°C) and continuous dry heat up to 750°F (400°C)
- Commonly used as a fl ash rust preventive on welded areas
- Inhibits rust on steel under aggressive conditions
- Flexible coating will not yellow, chalk, crack,or peel
- Electrochemically protects bare metal
- Dries in 3-5 minutes
- Acceptable for use in Canadian Food Processing Establishments

NET CONTENTS	LPS #
14 wt. oz./397 g/389 mL	00516
1 gal. (3.78 L)	05128

ELECTRO CONTACT CLEANERS
SAFE ON CIRCIUT BOARDS AND ELECTRONIC COMPONENTS



NEW LOOK

CFC FREE
ELECTRO CONTACT CLEANER

NSF · K2 · NO CHLOR SOLV · PLASTIC SAFE · FAST · NO RES · LO ODOR

- Ideal for electronic and fine parts
- Cleans and degreases delicate precision mechanisms
- Penetrating action removes oil, grease, dirt, flux, and other contaminants
- Nonfood Compounds Program Listed Category Code: K2 Registration #059813 (Aerosol); #059814 (Bulk)

NET CONTENTS	LPS #
11 wt. oz./312 g/465 mL	03116
1 gal. (3.78 L)	03101*
5 gal. (18.93 L)	03105*
55 gal. (208 L)	03155*

*Known as CFC Free Premium Solvent

VALUE PERFORMANCE ALTERNATIVE



NEW LOOK

MICRO-X
FAST EVAPORATING CONTACT CLEANER

NSF · K2 · NO CHLOR SOLV · PLASTIC SAFE · FAST · NO RES · LO ODOR

- Quick penetration
- Does not contain HCFCs
- No rinsing
- Nonfood Compounds Program Listed Category Code: K2 Registration #059853 (Aerosol); #059852 (Bulk)

NET CONTENTS	LPS #
11 wt. oz./312 g/466 mL	04516
55 gal. (208 L)	04555*

VOC COMPLIANT



NEW LOOK

CFC FREE NU
CONTACT CLEANER

NSF · K2 · CARB ✓ · OTC ✓ · NO CHLOR SOLV · PLASTIC SAFE · FAST · NO RES · LO ODOR

- Ideal for electronic and fine parts
- Cleans delicate precision mechanism
- Penetrating action removes dirt, fl ux, moisture, dust, oxides, and other contaminants
- Nonfood Compounds Program Listed Category Code: K2 Registration #142024 (Aerosol)

NET CONTENTS	LPS #
11 wt. oz./312 g/416 mL	05416

VALUE PERFORMANCE ALTERNATIVE

VOC COMPLIANT



NEW LOOK

MICRO-X NU
FAST EVAPORATING CONTACT CLEANER

NSF · K2 · CARB ✓ · OTC ✓ · NO CHLOR SOLV · PLASTIC SAFE · FAST · NO RES · LO ODOR

- Reduced VOCs (Volatile Organic Compounds)
- Quick penetration
- Ideal for electronic and fine parts
- Removes dirt, dust, flux and other contaminants
- Nonfood Compounds Program Listed Category Code: K2 Registration #142149 (Aerosol)

NET CONTENTS	LPS #
11 wt. oz./312 g/417 mL	06616

Next Page 19

ELECTRO CONTACT CLEANER

Continue



LPS has all the electrical cleaners I need... Theyre safe, dry quickly, and nothing works better!



NEW AEROSOL LOOK ARRIVING 2015

ELECTRO 140°
CONTACT CLEANER

- Flash point above 140°F (60°C)
- Superior wetting and penetrating action
- Controlled evaporation
- Safe to use on most surfaces
- Ideal for part washers, dip tanks, and ultrasonic cleaning tanks

NET CONTENTS	LPS #
11 wt. oz./312 g/389 mL	00916

From Page 18

NON-FLAMMABLE & VOC COMPLIANT

ELECTRA-X CONTACT CLEANER



NEW LOOK

- Quick penetration
- Does not contain HCFCs
- Ideal for electronic and fine parts
- Removes light greases, oils, dirt, and organic soils

NET CONTENTS	LPS #
12 wt. oz./340g/266mL	00816*



NEW AEROSOL LOOK ARRIVING 2015

REVO 66
CONTACT CLEANER

- Unique alternative to HCFC cleaners
- Does not contain brominated solvents
- Ideal for removing dirt, moisture, flux, or oxides from the internal components of electronic equipment
- Quick penetration
- Safe to use on most surfaces
- Nonfood Compounds Program Listed Category Code: K2 Registration #140245 (Aerosol)
- Acceptable for use in Canadian Food Processing Establishments

NET CONTENTS	LPS #
12 wt. oz./340 g/279 mL	04416

ANTI-SEIZES



NEW LOOK ARRIVING 2015

COPPER ANTI-SEIZE

HI TEMP EP

- Prevents seizure up to 1800°F (982°C)
- Lead free
- Protects against seizure, heat-freeze, galling, rust and corrosion
- Brushes easily
- Highly adhesive on both wet and dry surfaces
- Will not run, drip, or settle out
- Copper color

NET CONTENTS	LPS #
12 wt. oz./340 g/406 mL	02916
1/2 lb. (227 g)	02908
1 lb. (454 g)	02910



NEW LOOK ARRIVING 2015

ALL-PURPOSE ANTI-SEIZE

HI TEMP EP

- Prevents seizure up to 1800°F (982°C)
- Moly fortified
- Lead free
- Protects against seizure, heat-freeze, galling, rust, and corrosion
- Lowers friction; reduces wrench torque
- Reduces maintenance costs
- Not affected by contraction, expansion, or vibration
- Will not run, drip, or settle out
- Charcoal grey color

NET CONTENTS	LPS #
	04108
	04110



NEW LOOK ARRIVING 2015

NICKEL ANTI-SEIZE

HI TEMP EP

- Prevents seizure up to 2600°F (1427°C)
- Does not contain lead, copper, or graphite
- Protects against seizure, rust, and corrosion
- Chemically inert
- Can be used with ammonia, acetylene, and vinyl monomers which are unstable in the presence of copper
- Strong resistance to water wash off
- Brushable to -18°F (-27°C)
- Will not run, drip, or settle out
- Ideal for use on stainless steel and for joining dissimilar metals
- Silver color
- Acid resistant

NET CONTENTS	LPS #
1/2 lb. (227 g)	03908
1 lb. (454 g)	03910

Threadlocking Adhesives
Product Table

Bonding

Are the metal parts already assembled?

	Yes	No				
	Wicking grade	What strength do you require?				
	Medium / High	Low	Medium		High	
	Liquid	Liquid	Liquid	Liquid	Liquid	Liquid
Solution	LOCTITE 290	LOCTITE 222	LOCTITE 243	LOCTITE 2400	LOCTITE 270	LOCTITE 2700
Functional strength after	3 hr	6 hr	2 hr	2 hr	3 hr	3 hr
Breakaway torque M10 bolts	10 Nm	6 Nm	26 Nm	20 Nm	33 Nm	20 Nm
Service temperature range	-55°C to +150°C	-55°C to +150°C	-55°C to +180°C	-55°C to +150°C	-55°C to +180°C	-55°C to +150°C
Pack sizes	10ml, 50ml, 250ml, 2 ltr	10ml, 50ml, 250ml	10ml, 50ml, 250ml, 2 ltr	5ml, 50ml, 250ml	10ml, 50ml, 250ml	5ml, 50ml, 250ml
Equipment	97001, 98414	97001, 98414	97001, 98414	97001, 98414	97001, 98414	97001, 98414

LOCTITE 290
- Ideal for locking preassembled fasteners, e.g. instrumentation screws, electrical connectors and set screws

LOCTITE 222
- Ideal for low-strength threadlocking of adjusting screws, countersunk head screws and set screws
- Good on low-strength metals which could break during disassembly, e.g. aluminium or brass

P1 NSF Reg. No.: 123002

LOCTITE 243
- Works on all metals, including passive substrates (e.g. stainless steel, aluminium, plated surfaces)
- Tolerates slight contamination of industrial oils, e.g. engine oils, corrosion prevention oils and cutting fluids
- Prevents loosening on vibrating parts, e.g. pumps, gear boxes or presses
- Permits disassembly with hand tools for servicing

P1 NSF Reg. No.: 123000

LOCTITE 2400
- Leading in health and safety
- +No hazard symbols, risk or safety phrases
- "White" Material Safety Data Sheet – no entries in sections 2, 3, 15 and 16 of MSDS acc. to (EC) No. 1907/2006 – ISO 11014-1
- Excellent chemical and thermal resistance of cured product
- To be used where regular disassembly with hand tools for servicing is required

WRAS Approval (BS 6920): 1104507

LOCTITE 270
- Suitable for all metal fasteners, including stainless steel, aluminium, plated surfaces and chrome-free coatings
- Tolerates slight contaminations of industrial oils, e.g. engine oils, corrosion prevention oils, cutting fluids
- Ideal for permanently locking studs on engine blocks and pump housings
- To be used if regular removal for maintenance is not required

P1 NSF Reg. No.: 123006

LOCTITE 2700
- Leading in health and safety
- No hazard symbols, risk or safety phrases.
- "White" Material Safety Data Sheet – no entries in sections 2, 3, 15 and 16 of MSDS acc. to (EC) No. 1907/2006 – ISO 11014-1
- Excellent chemical and thermal resistance of cured product
- For applications where disassembly is not required

WRAS Approval (BS 6920): 1104508

Threadlocking Adhesives

Product List



Product	Chemical basis	Colour	Fluorescence	Max. thread size	Service temperature range	Strength	Breakaway torque	Thixotropy
LOCTITE 221	Methacrylate	Purple	Yes	M12	-55°C to +150°C	Low	8.5 Nm	No
LOCTITE 222	Methacrylate	Purple	Yes	M36	-55°C to +150°C	Low	6 Nm	Yes
LOCTITE 241	Methacrylate	Blue opaque	Yes	M12	-55°C to +150°C	Medium	11.5 Nm	No
LOCTITE 242	Methacrylate	Blue	Yes	M36	-55°C to +150°C	Medium	11.5 Nm	Yes
LOCTITE 243	Methacrylate	Blue	Yes	M36	-55°C to +180°C	Medium	26 Nm	Yes
LOCTITE 245	Methacrylate	Blue	Yes	M80	-55°C to +150°C	Medium	13 Nm	Yes
LOCTITE 248 Stick	Methacrylate	Blue	Yes	M50	-55°C to +150°C	Medium	17 Nm	–
LOCTITE 262	Methacrylate	Red	Yes	M36	-55°C to +150°C	Medium/high	22 Nm	Yes
LOCTITE 268 Stick	Methacrylate	Red	Yes	M50	-55°C to +150°C	High	17 Nm	–
LOCTITE 270	Methacrylate	Green	Yes	M20	-55°C to +180°C	High	33 Nm	No
LOCTITE 271	Methacrylate	Red	Yes	M20	-55°C to +150°C	High	26 Nm	No
LOCTITE 272	Methacrylate	Red-orange	No	M36	-55°C to +200°C	High	23 Nm	Yes
LOCTITE 275	Methacrylate	Green	Yes	M80	-55°C to +150°C	High	25 Nm	Yes
LOCTITE 276	Methacrylate	Green	Yes	M20	-55°C to +150°C	High	60 Nm	No
LOCTITE 277	Methacrylate	Red	Yes	M36	-55°C to +150°C	High	32 Nm	Yes
LOCTITE 278	Methacrylate	Green	No	M36	-55°C to +200°C	High	42 Nm	No
LOCTITE 290	Methacrylate	Green	Yes	M6	-55°C to +150°C	Medium/high	10 Nm	No
LOCTITE 2400	Methacrylate	Blue	Yes	M36	-55°C to +150°C	Medium	20 Nm	Yes
LOCTITE 2700	Methacrylate	Green	Yes	M20	-55°C to +150°C	High	20 Nm	No
LOCTITE 2701	Methacrylate	Green	Yes	M20	-55°C to +150°C	High	38 Nm	No

Product	Viscosity	Fixture time steel	Fixture time brass	Fixture time stainless steel	Pack sizes	Comments
LOCTITE 221	100 – 150 mPa·s	25 min.	20 min.	210 min.	250ml	Low strength, low viscosity, small threads
LOCTITE 222	900 – 1,500 mPa·s	15 min.	8 min.	360 min.	10ml, 50ml,250ml	Low strength, general purpose
LOCTITE 241	100 – 150 mPa·s	35 min.	12 min.	240 min.	250ml	Medium strength, low viscosity, small threads
LOCTITE 242	800 – 1,600 mPa·s	5 min.	15 min.	20 min.	250ml	Medium strength, medium viscosity, general purpose
LOCTITE 243	1,300 – 3,000 mPa·s	10 min.	5 min.	10 min.	10ml, 50ml,250ml, 2 ltr	Medium strength, general purpose
LOCTITE 245	5,600 – 10,000 mPa·s	20 min.	12 min.	240 min.	50ml, 250ml	Medium strength, medium viscosity, large threads
LOCTITE 248 Stick	Semi-solid	5 min.	–	20 min.	19g	Medium strength, positioning; maintenance, repair and overhaul
LOCTITE 262	1,200 – 2,400 mPa·s	15 min.	8 min.	180 min.	250ml	Medium/high strength, general purpose
LOCTITE 268 Stick	Semi-solid	5 min.	–	5 min.	9g, 19g	High strength, positioning; maintenance, repair and overhaul
LOCTITE 270	400 – 600 mPa·s	10 min.	10 min.	150 min.	10ml, 50ml,250ml	High strength, general purpose
LOCTITE 271	400 – 600 mPa·s	10 min.	5 min.	15 min.	Not available in the U.K.	High strength, low viscosity
LOCTITE 272	4,000 – 15,000 mPa·s	40 min.	–	–	50ml, 250ml	High strength, high temperature resistant
LOCTITE 275	5,000 – 10,000 mPa·s	15 min.	7 min.	180 min.	50ml, 250ml,2 ltr	High viscosity, high strength, large threads
LOCTITE 276	380 – 620 mPa·s	3 min.	3 min.	5 min.	50ml	High strength, especially for nickel surfaces
LOCTITE 277	6,000 – 8,000 mPa·s	30 min.	25 min.	270 min.	50ml	High viscosity, high strength, large threads
LOCTITE 278	2,400 – 3,600 mPa·s	20 min.	20 min.	60 min.	50ml, 250ml	High strength, high temperature resistant
LOCTITE 290	20 – 55 mPa·s	20 min.	20 min.	60 min.	10ml, 50ml, 250ml, 2 ltr	Medium/high strength, wicking grade
LOCTITE 2400	225 – 475 mPa·s	10 min.	8 min.	10 min.	5ml, 50ml,250ml	Medium strength, no labelling, white MSDS
LOCTITE 2700	350 – 550 mPa·s	5 min.	4 min.	5 min.	5ml, 50ml,250ml	High strength, no labelling, white MSDS
LOCTITE 2701	500 – 900 mPa·s	10 min.	4 min.	25 min.	10ml, 50ml, 250ml, 1 ltr, 2 ltr	High strength, especially for chromated surfaces

Sealing

Are the parts metal or plastic?

- **Metal, plastic or a combination of both**
  - **Do you need to make post assembly adjustments?**
    - **Yes** → **Cord** → **LOCTITE 55**
    - **No** → **Gel** → **LOCTITE SI 5331**
- **Metal**
  - **Are the threads fine or coarse?**
    - **Fine** → **Liquid** → **LOCTITE 542**
    - **Medium** → **Gel** → **LOCTITE 586**
    - **Coarse** → **Gel** → **LOCTITE 577**
    - **Coarse** → **Gel** → **LOCTITE 5776**
    - **Coarse** → **Gel** → **LOCTITE 5400**

Solution









Substrate to be sealed	Metal, plastic or both	Metal, plastic or both	Metal	Metal	Metal	Metal	Metal
Maximum pipe size	Tested to 4"	3"	3/4"	2"	3"	3"	3"
Disassembly strength	Low	Low	Medium	High	Medium	Medium	Medium
Instant low pressure seal	es (full pressure)	Yes	No	No	Yes	Yes	Yes
Service tempe-rature range	-55°C to +130°C	-50°C to +150°C	-55°C to +150°C	-55°C to +150°C	-55°C to +150°C	-55°C to +150°C	-55°C to +150°C
Pack sizes	50m, 150m cord	100ml	10ml, 50ml, 250ml	Not available in the U.K.	50ml, 250ml, 2 ltr	50ml, 250ml	50ml, 250ml
Equipment	–	–	97001, 98414	97001, 98414	97002	97002	97002

LOCTITE 55
- General purpose, threaded pipe and fitting sealant
+ Non-curing, immediate, full pressure seal
- For a quick, easy and reliable seal

WRAS listed, meets BS 6920 for potable water: 0808533
DVGW/KTW approval for gas and potable water Tested in accordance with EN 751-2 Class ARp and DIN 30660 Certified to NSF/ANSI, Standard 61

LOCTITE SI 5331
- Ideal for use on threaded plastic or plastic/metal fittings carrying hot or cold water e.g. industrial and agricultural plastic water pipe systems or drainage systems

WRAS listed, meets BS 6920 for potable water: 0706521
DVGW approval, tested in accordance with EN 751-1 P1 NSF Reg. No.: 123620

LOCTITE 542
- Ideal for fine threads as used in hydraulic, pneumatic & general fittings

DVGW approval (EN 751-1): NG-5146AR0855

LOCTITE 586
- Slow curing, high strength sealant
- Especially suitable for copper and brass fittings

LOCTITE 577
- General purpose sealant for all coarse metal threads
- Suitable where a fast cure is required or at low temperatures, e.g. outdoor plant maintenance.

P1 NSF Reg. No.:123001
DVGW Approval (EN 751-1): NG-5146AR0621
WRAS Approval (BS 6920): 0711506

LOCTITE 5776
- General purpose sealant for all coarse metal threads
- Suitable where a fast cure is required or at low temperatures, e.g. outdoor plant maintenance.
- Ideal for drinking water applications up to 60 °C

DVGW Approval (EN 751-1): NG-5146BU0527
WRAS Approval (BS 6920-1-2000) Reg. No.: 1208532
NSF/ANSI Standard 61

LOCTITE 5400
- Leading in health and safety
+ No hazard symbols, risk or safety phrases.
- "White" Material Safety Data Sheet - no entries in sections 2, 3, 15 and 16 of MSDS acc.to (EC) No. 1907/2006 – ISO 11014-1
- Slow curing, medium strength thread sealant
- Excellent chemical and thermal resistance of cured product

Thread Sealants

Product List



Product	Chemical basis	Colour	Fluores-cence	Max. thread size	Service temperature range	Disassembly strength	Breakaway torque
LOCTITE 55	PA Multifilament	White	No	R4"	-55°C to +130°C	–	–
LOCTITE 511	Methacrylate	White to off-white	No	M80/R3"	-55°C to +150°C	Low	6 Nm
LOCTITE 542	Methacrylate	Brown	No	M26/R3/4"	-55°C to +150°C	Medium	15 Nm
LOCTITE 549	Methacrylate	Orange	No	M80/R3"	-55°C to +150°C	High	20 Nm
LOCTITE5 61 Stick	Methacrylate	Orange	No	M80/R3"	-55°C to +150°C	Low	2 Nm
LOCTITE 567	Methacrylate	Off-white	No	M80/R3"	-55°C to +150°C	Low	1.7 Nm
LOCTITE 570	Methacrylate	Opaque silverbrown	No	M80/R3"	-55°C to +150°C	Low	5.5 Nm
LOCTITE 572	Methacrylate	White to off-white	No	M80/R3"	-55°C to +150°C	Medium	7 Nm
LOCTITE 577	Methacrylate	Yellow	Yes	M80/R3"	-55°C to +150°C	Medium	11 Nm
LOCTITE 582	Methacrylate	Blue	Yes	M56/R2"	-55°C to +150°C	Medium	8.5 Nm
LOCTITE 586	Methacrylate	Red	Yes	M56/R2"	-55°C to +150°C	High	15 Nm
LOCTITE 5400	Methacrylate	Yellow	Yes	M80/R3"	-55°C to +150°C	Medium	19 Nm
LOCTITE 5772	Methacrylate	Yellow	Yes	M80/R3"	-55°C to +150°C	Medium	11 Nm
LOCTITE 5776	Methacrylate	Yellow	Yes	M80/R3"	-55°C to +150°C	Medium	9 Nm
LOCTITE SI 5331	Silicone	White	No	M80/R3"	-55°C to +150°C	Low	1.5 Nm

Product	Viscosity	Thixotropy	Approval	Pack sizes	Comments
LOCTITE 55	Cord	–	DVGW, KTW, NSF	50m, 150m cord	For plastic and metal, especially, gas and water pipes, non-curing
LOCTITE 511	9,000 – 22,000 mPa·s	Yes	DVGW	50ml, 250ml	For metal, low strength, general purpose
LOCTITE 542	400 – 800 mPa·s	No	DVGW, WRAS	10ml, 50ml, 250ml	For metal, especially hydraulic pipes
LOCTITE 549	20,000 mPa·s	Yes	–	250ml	For metal, high strength, slow curing
LOCTITE 561 Stick	Semi-solid	NSF	–	19g	Stick, for metal threads; maintenance, repair and overhaul
LOCTITE 567	280,000 – 800,000 mPa·s	Yes	UL	50ml, 250ml, 2 ltr	For metal, low strength, coarse threads
LOCTITE 570	16,000 – 24,000 mPa·s	Yes	–	Not available in the U.K.	For metal, low strength, very slow curing
LOCTITE 572	14,400 – 28,600 mPa·s	Yes	–	50ml, 250ml	For metal, slow curing
LOCTITE 577	16,000 – 33,000 mPa·s	Yes	DVGW, NSF, BAM	50ml, 250ml, 2 ltr	For metal, general purpose
LOCTITE 582	4,500 – 5,500 mPa·s	No	–	Not available in the U.K.	For metal, medium strength, fast curing
LOCTITE 586	4,000 – 6,000 mPa·s	Yes	BAM	Not available in the U.K.	For metal, high strength, excellent on brass
LOCTITE 5400	5,000 – 20,000 mPa·s	Yes	–	50ml, 250ml	For metal, no labelling, white MSDS
LOCTITE 5772	16,000 – 33,000 mPa·s	Yes	PMUC	50ml	For metal, especially for nuclear power plants
LOCTITE 5776	1,000 – 6,000 mPa·s	Yes	DVGW	50ml, 250ml	For metal, especially gas and water pipes, fast curing
LOCTITE SI 5331	50,000 mPa·s	Yes	DVGW, WRAS, NSF	100ml	For plastic and metal

Which gap must the sealant fill?

- Up to 0.25 mm
  - Metals
    - Paste
    - Gel
    - Paste
    - Gel
    - Paste
  - Plastic, metals or combination of both
    - Paste
    - Paste
    - Paste

Solution	LOCTITE 574	LOCTITE 518	LOCTITE 5188	LOCTITE 5800	LOCTITE 510	LOCTITE SI 5926	LOCTITE SI 5699	LOCTITE SI 5970
								
Flange type	Rigid	Rigid	Rigid	Rigid	Rigid	Flexible	Flexible	Flexible
Cure method	Anaerobic	Anaerobic	Anaerobic	Anaerobic	Anaerobic	Moisture	Moisture	Moisture
Oil resistance	Excellent	Excellent	Excellent	Excellent	Excellent	Good	Good	Excellent
Water/Glycol resistance	Excellent	Excellent	Excellent	Excellent	Excellent	Good	Excellent	Good
Service temperature range	-55°C to +150°C	-55°C to +150°C	-55°C to +150°C	-55°C to +180°C	-55°C to +200°C	-55°C to +200°C	-55°C to +200°C	-50°C to +200°C
Pack size	50ml, 160ml cartridge, 250ml, 2 ltr	50ml, 65ml, 300ml, 850ml, 2 ltr	50ml, 300ml cartridge, 850ml, 2 ltr	50ml, 300ml cartridge	50ml, 160ml, 250ml	40ml tube, 310ml	300ml cartridge, 20 ltr	300ml cartridge, 20 ltr
Equipment	97002, 91124	142240, 97002	142240, 97002	142240, 97002	142240, 97002	–	142240, 97002	142240, 97002

LOCTITE 574
- Ideal for use on rigid metal parts, e.g. cast iron components and pump housin

LOCTITE 518
- Ideal for use on rigid iron, steel and aluminium flanges P1 NSF Reg. No.: 123758

LOCTITE 5188
- Ideal for sealing all kinds of rigid metal flanges, especially aluminium flanges
- Excellent in demanding applications
- Excellent chemical resistance, highly flexible
- Superior adhesion, can tolerate slight oil contamination on the flange surface

LOCTITE 5800
- Leading in health and safety: No hazard symbols, risk or safety phrases
- "White" Material Safety Data Sheet – no entries in sections 2, 3, 15 and 16 of MSDS
- Excellent chemical and thermal resistance of cured product

LOCTITE 510
- Ideal for use on rigid flanges where high temperature and chemical resistance are necessary

P1 NSF Reg. No.:123007

LOCTITE SI 5926
- Multi-purpose flexible silicone sealant. Can be used on metal, plastic and painted parts
- Resists vibration, thermal expansion and contraction

LOCTITE SI 5699
- Ideal for sealing all types of flanges including stamped sheet metal where water glycol resistance is required
- Tack-free after 10 min.

P1 NSF Reg. No.:122998

LOCTITE SI 5970
- Replacement for cork and paper cut gaskets on flanges and stamped sheet metal covers
- Ideal for use where high vibration or flexing occurs
- Can be used with plastic and painted parts9
- Tack-free after 25 min.

Gasketing Products

Product Table



Product	Chemical basis	Colour	Fluores-cence	Service temperature range	Strength	Viscosity	Extrusion rate	Tensile shear strength
LOCTITE 510	Methacrylate	Pink	No	-55°C to +200°C	Medium	40,000 – 140,000 mPa·s	-	5 N/mm
LOCTITE 515	Methacrylate	Dark purple	Yes	-55°C to +150°C	Medium	150,000 – 375,000 mPa·s	-	6 N/mm
LOCTITE 518	Methacrylate	Red	Yes	-55°C to +150°C	Medium	500,000 - 1,000,000 mPa·s	-	7.5 N/mm
LOCTITE 573	Methacrylate	Green	Yes	-55°C to +150°C	Low	13,500 – 33,000 mPa·s	-	1.3 N/mm
LOCTITE 574	Methacrylate	Orange	Yes	-55°C to +150°C	Medium	23,000 – 35,000 mPa·s	-	8.5 N/mm
LOCTITE 5188	Methacrylate	Red	Yes	-55°C to +150°C	Medium	11,000 – 32,000 mPa·s	-	7 N/mm
LOCTITE 5203	Methacrylate	Red	Yes	-55°C to +150°C	Very low	50,000 - 100,000 mPa·s	-	1 N/mm
LOCTITE 5205	Methacrylate	Red	Yes	-55°C to +150°C	Medium	30,000 – 75,000 mPa·s	-	3 N/mm
LOCTITE 5208	Methacrylate	Red	Yes	-55°C to +150°C	Medium	12,000 – 27,000 mPa·s	-	6 N/mm
LOCTITE 5800	Methacrylate	Red	Yes	-55°C to +180°C	Medium	11,000 – 32,000 mPa·s	-	5 N/mm
LOCTITE 128068	Methacrylate	Dark purple	Yes	-55°C to +150°C	Medium	300,000 - 1,000,000 mPa·s	-	6 N/mm
LOCTITE SI 5699	Silicone	Grey	No	-55°C to +200°C	Low	-	200 g/min	1.7 N/mm
LOCTITE SI 5900	Silicone	Black	No	-55°C to +200°C	Low	-	20 – 50 g/min	1.2 N/mm
LOCTITE SI 5910	Silicone	Black	No	-55°C to +200°C	Low	-	300 g/min	1.2 N/mm
LOCTITE SI 5920	Silicone	Copper	No	-55°C to +350°C	Low	-	275 g/min	1.4 N/mm
LOCTITE SI 5926	Silicone	Blue	No	-55°C to +200°C	Low	-	550 g/min	–
LOCTITE SI 5970	Silicone	Black	No	-50°C to +200°C	Low	-	40 – 80 g/min	1.5 N/mm
LOCTITE SI 5980	Silicone	Black	No	-55°C to +200°C	Low	-	120 – 325 g/min	1.5 N/mm

Product	Max. gap	Fixture time steel	Skin-over time	Fixture time aluminium	Cure through volume in 24 hr	Pack sizes	Comments
LOCTITE 510	0.25 mm	25 min.	-	45 min.	-	50ml, 160ml, 250ml	For machined, rigid metal flanges – high temperature resistance
LOCTITE 515	0.25 mm	30 min.	-	30 min.	-	50ml, 300ml	For machined, rigid metal flanges – medium cure speed
LOCTITE 518	0.3 mm	25 min.	-	20 min.	-	50ml, 65ml, 300ml cartridge, 850ml, 2 ltr	For machined, rigid metal flanges – semi-flexible
LOCTITE 573	0.1 mm	9 hr	-	12 hr	-	250ml	For machined, rigid metal flanges – slow curing
LOCTITE 574	0.25 mm	15 min.	-	45 min.	-	50ml, 160ml cartridge, 250ml, 2 ltr	For machined, rigid metal flanges – general purpose
LOCTITE 5188	0.25 mm	25 min.	-	10 min.	-	50ml, 300ml, 850ml, 2 ltr	For machined, rigid metal flanges – highly flexible
LOCTITE 5203	0.125 mm	10 min.	-	20 min.	-	300ml	For machined, rigid metal flanges – easy disassembly
LOCTITE 5205	0.25 mm	25 min.	-	25 min.	-	50ml, 300ml, 850ml	For machined, rigid metal flanges – semi-flexible
LOCTITE 5208	0.125 mm	12 min.	-	30 min.	-	250ml	For machined, rigid metal flanges – semi-flexible
LOCTITE 5800	0.25 mm	25 min.	-	20 min.	-	50ml, 300ml cartridge	For machined, rigid metal flanges – no labelling, white MSDS
LOCTITE 128068	0.1 mm	1 hr	-	3 hr	-	300ml, 850ml, 2kg	For machined, rigid metal flanges – semi-flexible, very slow curing
LOCTITE SI 5699	1 mm	-	30 min.	-	2.5 mm	300ml, 20 ltr	For flexible flanges, machined or cast surfaces, metal or plastic, excellent in water/glycol
LOCTITE SI 5900	1 mm	-	15 min.	-	2.5 mm	50ml, 300ml, 20 ltr	Thixotropic paste, black, excellent in engine oils
LOCTITE SI 5910	1 mm	-	40 min.	-	2.75 mm	300ml cartridge, 20 ltr, 200 ltr	For flexible flanges, machined or cast surfaces, metal or plastic
LOCTITE SI 5920	1 mm	-	40 min.	-	2.5 mm	80ml tube, 300ml cartridge	For flexible flanges, machined or cast resistant surfaces, high temperature
LOCTITE SI 5926	1 mm	-	60 min.	-	2.5 mm	40ml tube, 310ml	For flexible flanges, machined or cast surfaces, metal or plastic
LOCTITE SI 5970	1 mm	-	25 min.	-	2.5 mm	300ml cartridge, 20 ltr	For flexible flanges, machined or cast surfaces, metal or plastic
LOCTITE SI 5980	1 mm	-	30 min.	-	1 mm	40ml, 100ml, 300ml 200ml rocep can	Flange sealant, black, big gaps, label-free

Bonding

Is assembly badly worn?

- **Yes** (Gaps < 0.5 mm)
- **No** (Gaps < 0.25 mm)
  - **Is disassembly required?**
    - **Yes**
    - **No**
      - **What service temperature is required?**
        - **Up to 230°C**
        - **Up to 180°C**
          - **Gaps < 0.25 mm**
          - **Gaps < 0.15 mm**

Solution

	LOCTITE 660 (with activator LOCTITE SF 7240 or LOCTITE SF 7649)	LOCTITE 641	LOCTITE 620	LOCTITE 638	LOCTITE 6300	LOCTITE 648
Diametrical clearance	Up to 0.5 mm	Up to 0.1 mm	Up to 0.2 mm	Up to 0.25 mm	Up to 0.15 mm	Up to 0.15 mm
Strength required	High	Medium	High	High	High	High
Handling strength after [1]	15 min.	25 min.	80 min.	4 min.	10 min.	3 min.
Service temperature range	-55°C to +150°C	-55°C to +150°C	-55°C to +230°C *	-55°C to +180°C	-55°C to +180°C	-55°C to +200°C
Pack size	50ml	10ml, 50ml, 250ml	250ml	10ml, 50ml, 250ml, 1 ltr, 2 ltr	50ml, 250ml	10ml, 50ml, 250ml, 1 ltr, 2 ltr
Equipment	142240	97001, 98414	97001, 98414	97001, 97121, 97201, 98414	97001, 98414	97001, 97009, 97121, 97201, 98414

LOCTITE 660
- Ideal for repairing worn coaxial parts without remachining
- Enables re-use of worn bearing seats, keys, splines or tapers
- Suitable for retaining shims

P1 NSF Reg. No.: 123704

LOCTITE 641
- Ideal for parts that need subsequent dismantling, e.g. retention of bearings onto shafts and into housinings

LOCTITE 620
- High temperature resistance
- Ideal for retaining pins in high temperature assemblies, sleeves in pump housings and bearings in auto transmissions

DVGW approval (EN 751-1): NG-5146AR0622

LOCTITE 638
- High temperature resistance
- Bonds through contamination including industrial oils
- High strength on all metals, including passive substrates (e.g. stainless steel)
- Ideal for shafts, gears, pulleys and similar cylindrical parts

Approvals: P1 NSF Reg. No.123010, DVGW (EN 751-1): NG 5146AR0619, WRAS (BS 6920): 0511518

LOCTITE 6300
- Leading in health and safety
- No hazard symbols, risk or safety phrases
- "White" Material Safety Data Sheet (no entries in sections 2, 3, 15 and 16 of MSDS)
- +Good thermal resistance

LOCTITE 648
- High temperature resistance
- Bonds through contamination including industrial oils
- High strength on all metals, including passive substrates (e.g. stainless steel)
- Ideal for retaining of parts with a clearance or interference fit

Approvals: P1 NSF Reg. No.: 148350, DVGW (EN 751-1): NG 5146C00236, WRAS (BS 6920): 0808532

1 At room temperature on steel joints.
* After heat cure +180°C for 30 min.

Retaining Compounds

Product Table



Product	Chemical basis	Colour	Fluorescence	Service temperature range	Tensile shear strength	Thixotropy	Viscosity
LOCTITE 601	Methacrylate	Green	Yes	-55°C to +150°C	> 15 N/mm²	No	100 – 150 mPa·s
LOCTITE 603	Methacrylate	Green	Yes	-55°C to +150°C	> 22.5 N/mm²	No	100 – 150 mPa·s
LOCTITE 620	Methacrylate	Green	No	-55°C to +230°C**	> 24.1 N/mm²	Yes	5,000 – 12,000 mPa·s
LOCTITE 638 NEW	Methacrylate	Green	Yes	-55°C to +180°C	> 25 N/mm²	No	2,000 – 3,000 mPa·s
LOCTITE 640	Methacrylate	Green	Yes	-55°C to +175°C	22 N/mm²	No	450 – 750 mPa·s
LOCTITE 641	Methacrylate	Yellow	No	-55°C to +150°C	> 6.5 N/mm²	No	400 – 800 mPa·s
LOCTITE 648 NEW	Methacrylate	Green	Yes	-55°C to +180°C	> 25 N/mm²	No	400 – 600 mPa·s
LOCTITE 649	Methacrylate	Green	Yes	-55°C to +175°C	> 15 N/mm²	No	550 – 950 mPa·s
LOCTITE 660	Methacrylate	Silver	No	-55°C to +150°C	> 17.2 N/mm²	Yes	150,000 – 350,000 mPa·s
LOCTITE 661	Methacrylate	Amber	No	-55°C to +175°C	> 15 N/mm²	No	400 – 600 mPa·s
LOCTITE 662	Methacrylate	Amber	No	-55°C to +150°C	> 25 N/mm²	No	1,750 – 3,250 mPa·s
LOCTITE 675	Methacrylate	Green	No	-55°C to +150°C	20 N/mm²	No	100 – 150 mPa·s
LOCTITE 6300	Methacrylate	Green	Yes	-55°C to +180°C	> 15 N/mm²	No	250 – 550 mPa·s
LOCTITE 121078	Methacrylate	Green	Yes	-55°C to +175°C	> 20 N/mm²	Yes	3,000 – 5,000 mPa·s

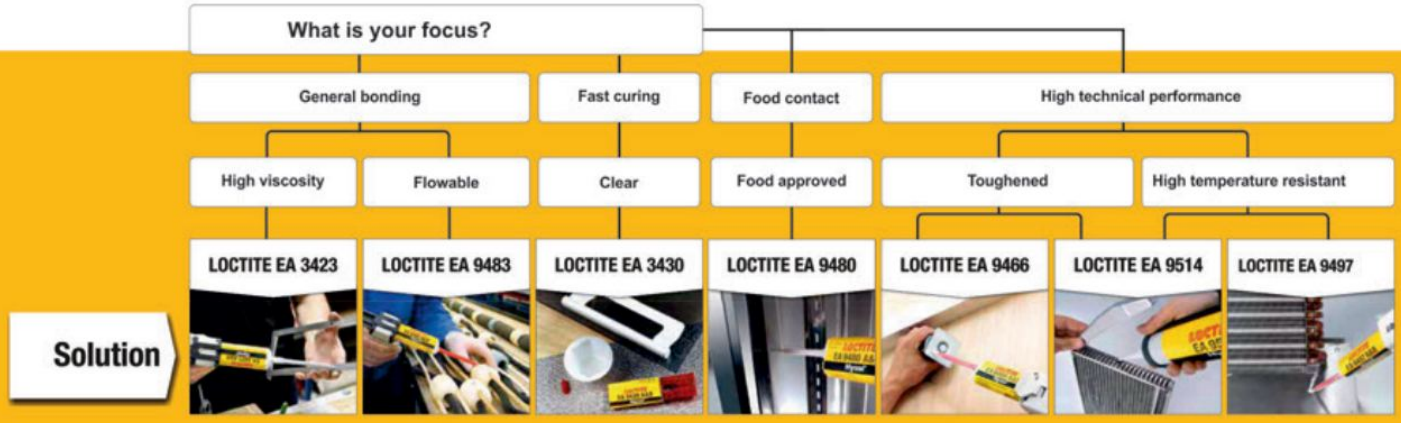
Product	Fixture time on steel	Maximum diametrical clearance	Pack sizes	Comments
LOCTITE 601	25 min.	0.1 mm	250ml	High strength, low viscosity, small gaps
LOCTITE 603	8 min.	0.1 mm	10ml, 50ml, 250ml, 1 ltr	High strength, oil tolerant
LOCTITE 620	80 min.	0.2 mm	250ml	High strength, high temperature resistance
LOCTITE 638	4 min.	0.25 mm	10ml, 50ml, 250ml, 1 ltr, 2 ltr	High strength, high temperature resistance, oil tolerant
LOCTITE 640	2 hr	0.1 mm	250ml	High strength, good temperature resistance, slow curing
LOCTITE 641	25 min.	0.1 mm	10ml, 50ml, 250ml	Medium strength, if disassembly is required
LOCTITE 648	3 min.	0.15 mm	10ml, 50ml, 250ml, 1 ltr, 2 ltr	High strength, high temperature resistance, oil tolerant
LOCTITE 649	10 min.	0.1 mm	250ml	High strength, no acrylic acid
LOCTITE 660	15 min.	0.5 mm*	50ml	High strength, gap fill for repair
LOCTITE 661	4 min.	0.15 mm	250ml	High strength, low viscosity, also UV-curing
LOCTITE 662	7 min.	0.25 mm	Not available in the U.K.	High strength, medium viscosity, also UV-curing
LOCTITE 675	45 min.	0.1 mm	250ml	High strength, slow curing
LOCTITE 6300	10 min.	0.15 mm	50ml, 250ml	High strength, white MSDS, good temperature resistance
LOCTITE 121078	3 min.	0.25 mm	250ml, 1 ltr, 2 ltr	High strength, good temperature resistance, high viscosity

* In combination with activator
** After heat cure +180 °C for 30 min.

Structural Bonding – Epoxies

Product List

Bonding



	LOCTITE EA 3423	LOCTITE EA 9483	LOCTITE EA 3430	LOCTITE EA 9480	LOCTITE EA 9466	LOCTITE EA 9514	LOCTITE EA 9497
Description	2K Epoxy	2K Epoxy	2K Epoxy	2K Epoxy	2K Epoxy	1K Epoxy	2K Epoxy
Mix ratio by volume (A:B)	1:1	2:1	1:1	2:1	2:1	–	2:1
Mix ratio by weight (A:B)	100:70	100:46	1:1	100:46.5	100:50	–	100:50
Working life	45 min.	30 min.	7 min.	110 min.	60 min.	5 min.*	3 hr
Fixture time	180 min.	210 min.	15 min.	270 min.	180 min.	30 min.**	8 hr
Colour	Grey	Ultra clear	Ultra clear	Off-white	Yellowish	Grey	Grey
Viscosity	300 Pa·s	7 Pa·s	23 Pa·s	8.7 Pa·s	35 Pa·s	45 Pa·s	12 Pa·s
Shear strength (GBMS)	17 N/mm²	23 N/mm²	22 N/mm²	24 N/mm²	37 N/mm²	46 N/mm²	20 N/mm²
Peel strength (GBMS)	2.7 N/mm	1.5 N/mm	3 N/mm	0.4 N/mm	8 N/mm	9.5 N/mm	–
Service temperature range	-55°C to +120°C	-55°C to +150°C	-55°C to +100°C	-55°C to +120°C	-55°C to +120°C	-55°C to +200°C	-55°C to +180°C

LOCTITE EA 3423
- Non-sag paste
- Medium working life
- Excellent chemical resistance

LOCTITE EA 3423 is a general purpose 2K epoxy adhesive, suitable for gap filling and vertical applications. Ideal for bonding metal components.

LOCTITE EA 9483
- Flowable
- Ultra-clear
- Low moisture absorption

LOCTITE EA 9483 is a general purpose 2K epoxy adhesive, suitable for bonding and potting where optical clarity and high strength are required. Ideal for bonding decorative panels and displays.

LOCTITE EA 3430
- Medium viscosity
- Ultra-clear
- Toughened
- Water resistant

LOCTITE EA 3430 is a five minute 2K epoxy adhesive suitable for applications requiring an optically clear bond line. Ideal for bonding glass, decorative panels and displays, and general repair.

LOCTITE EA 9480
- Good chemical resistance
- Toughened
- Good adhesion on stainless steel

LOCTITE EA 9480 is a food approved 2K epoxy adhesive suitable for bonding metals and most plastic parts in and around food processing areas. **KTW approval for potable water, Fraunhofer approval for incidental food contact**

LOCTITE EA 9466
- Medium viscosity
- Low density–SG=1
- High strength

LOCTITE EA 9466 is a toughened 2K epoxy adhesive suitable for multi-purpose applications requiring a long open time and high bonding strength. Ideal for a wide variety of substrates such as metals, ceramics and most plastics.

LOCTITE EA 9514
- Suitable for induction curing
- High shear and peel strength
- Excellent chemical resistance
- High temperature resistance (+200°C)

LOCTITE EA 9514 is a toughened 1K epoxy adhesive suitable for gap filling and resistant to high operating temperatures. Ideal for applications requiring toughness such as filter and magnet bonding.

LOCTITE EA 9497
- Medium viscosity
- High thermal conductivity
- High compressive strength
- High temperature resistance (+180°C)

LOCTITE EA 9497 is a thermally conductive 2K epoxy adhesive for high temperature filling and bonding applications. Ideal for heat dissipation.

* Gel time at +120°C
** Cure time at +120°C or higher:

Structural Bonding – Epoxies Product List

Product	Technology	Colour mix	Mixed viscosity	Mix ratio by volume	Working life	Fixture time	Service temperature range
LOCTITE EA Double Bubble	2K Epoxy	Clear	35 Pa·s	1:1	3 min.	5 min.	-55°C to +100°C
LOCTITE EA 3032	2K Epoxy	Grey	80 Pa·s	1:1	120 min.	480 min.	-55°C to +80°C
LOCTITE EA 3421	2K Epoxy	Clear amber	37 Pa·s	1:1	30 – 150 min.	240 min.	-55°C to +120°C
LOCTITE EA 3423	2K Epoxy	Grey	300 Pa·s	1:1	30 – 60 min.	180 min.	-55°C to +120°C
LOCTITE EA 3425	2K Epoxy	Yellow/white	1350 Pa·s	1:1	55 – 105 min.	240 min.	-55°C to +120°C
LOCTITE EA 3430	2K Epoxy	Ultra-clear	23 Pa·s	1:1	5 – 10 min.	15 min.	-55°C to +100°C
LOCTITE EA 3450	2K Epoxy	Grey	35 Pa·s	1:1	4 – 6 min.	15 min.	-55°C to +100°C
LOCTITE EA 3455	2K Epoxy	Grey	Pasty	1:1	40 min.	120 min.	-55°C to +100°C
LOCTITE EA 4108	1K Epoxy	Silver	170 Pa·s	–	–	Heat curing	-55°C to +180°C
LOCTITE EA 9250	2K Epoxy	White	45 Pa·s	3:1	9 min.	12 min.	-55°C to +150°C
LOCTITE EA 9450	2K Epoxy	Translucent	200 Pa·s	1:1	2 – 7 min.	13 min.	-55°C to +100°C
LOCTITE EA 9461	2K Epoxy	Grey	72 Pa·s	1:1	40 min.	240 min.	-55°C to +120°C
LOCTITE EA 9464	2K Epoxy	Grey	96 Pa·s	1:1	10 – 20 min.	180 min.	-55°C to +120°C
LOCTITE EA 9466	2K Epoxy	Yellowish	35 Pa·s	2:1	60 min.	180 min.	-55°C to +120°C
LOCTITE EA 9480	2K Epoxy	Off-white	8.7 Pa·s	2:1	110 – 190 min.	270 min.	-55°C to +120°C
LOCTITE EA 9483	2K Epoxy	Ultra-clear	7 Pa·s	2:1	25 – 60 min.	210 min.	-55°C to +150°C
LOCTITE EA 9489	2K Epoxy	Grey	45 Pa·s	1:1	60 – 120 min.	300 min.	-55°C to +120°C
LOCTITE EA 9492	2K Epoxy	White	30 Pa·s	2:1	15 min.	75 min.	-55°C to +180°C
LOCTITE EA 9497	2K Epoxy	Grey	12 Pa·s	2:1	165 – 255 min.	480 min.	-55°C to +180°C
LOCTITE EA 9514	1K Epoxy	Grey	45 Pa·s	–	–	Heat curing	-55°C to +200°C
TEROSON EP 5055	2K Epoxy	Grey	A: 145 Pa·s; B: 75 Pa·s	1:1	75 min.	270 min.	-55°C to +100°C

Product	Tensile strength	Peel strength	Pack sizes	Comments
LOCTITE EAD ouble Bubble	–	–	3g	For small and quick repairs, fast curing
LOCTITE EA 3032	–	–	Not available in the U.K.	Multiple purpose bonder, suitable for contact with potable water (approved to the Waters Byelaws Scheme)
LOCTITE EA 3421	28 N/mm²	2 – 3 N/mm	50ml, 200ml, 1kg	Structural adhesive, general purpose, long open time
LOCTITE EA 3423	24 N/mm²	2 – 3 N/mm	50ml, 1kg	Multiple purpose bonder, excellent for metals, good humidity resistance
LOCTITE EA 3425	27 N/mm²	1.5 – 2.5N/mm	50ml, 200ml	Multiple purpose bonder, excellent for metals, for large surfaces, thixotropic
LOCTITE EA 3430	36 N/mm²	3 N/mm	24ml, 50ml, 200ml	Multiple purpose bonder, fast cure, ultra-clear
LOCTITE EA 3450	–	–	25ml	Structural adhesive, fast cure, ideal for metal repair
LOCTITE EA 3455	–	–	Not available in the U.K.	Structural adhesive, fast cure, high viscosity
LOCTITE EA 4108	–	–	Not available in the U.K.	Free flowing, high chemical resistance, looks like silver solder
LOCTITE EA 9250	–	–	Not available in the U.K.	Thixotropic, high temperature resistance, good chemical resistance, cream coloured, fast set
LOCTITE EA 9450	17 N/mm²	0.6 N/mm	50ml, 200ml, 1kg	Multiple purpose bonder, fast cure (5 min.), gap filling, translucent
LOCTITE EA 9461	30 N/mm²	10 N/mm	50ml, 400ml, 20kg	Structural adhesive, toughened, gap filling
LOCTITE EA 9464	–	7 – 10 N/mm	50ml, 400ml	Structural adhesive, toughened, gap filling, fast cure
LOCTITE EA 9466	32 N/mm²	8 N/mm	50ml, 400ml, 1kg	Toughened multiple purpose bonder, high bond strength for all substrates
LOCTITE EA 9480	47 N/mm²	0.4 N/mm	50ml, 400ml	Multiple purpose bonder, approved for incidental food contact and potable water
LOCTITE EA 9483	47 N/mm²	1.5 N/mm	50ml, 400ml, 1kg	Multiple purpose bonder, ultra-clear, excellent for panels and displays
LOCTITE EA 9489	14 N/mm²	2.2 N/mm	50ml	Structural adhesive, general purpose, extended working life
LOCTITE EA 9492	31 N/mm²	1.6 N/mm	50ml, 400ml	High temperature resistance, high chemical resistance
LOCTITE EA 9497	52.6 N/mm²	–	50ml, 400ml	High temperature resistance, thermally conductive, excellent for bonding metal components (thixotropic)
LOCTITE EA 9514	44 N/mm²	9.5 N/mm	300ml, 1kg	High temperature resistance, heat resistant bonding, toughened, high mechanical resistance
TEROSON EP 5055	23 N/mm²	4 N/mm	250ml	Crash resistant structural bonder for car panels

Instant Adhesives

Product Table

What type of materials are you bonding?

- "Difficult-to-bond" rubbers or plastics, e.g. PE, PP, PTFE, silicones?
- All other materials (except glass)
  - Defined small gaps < 0.15mm
  - Gaps up to 5mm

	Defined small gaps < 0.15mm	Universal	Impact resistant		Bendable joints	Gel / Non-drip	Low bloom, low odour	Gap filling	Structural applications / Impact resistant
Solution	LOCTITE 406 (with primer SF 770)	LOCTITE 401	LOCTITE 435	LOCTITE 480	LOCTITE 4850	LOCTITE 454	LOCTITE 460	LOCTITE 3090	LOCTITE 4090
Fixture time	2 – 10 sec.	3 – 10 sec.	10 – 20 sec.	20 – 50 sec.	3 – 10 sec.	5 – 10 sec.	5 – 20 sec.	90 – 120 sec.	90 –150 sec.
Viscosity	20 mPa·s	100 mPa·s	200 mPa·s	150 mPa·s	400 mPa·s	Gel	40 mPa·s	Gel	High-viscosity /Non-drip
Colour	Colourless	Colourless	Colourless	Black	Colourless	Colourless	Colourless	Colourless	Off-white to light yellow
Service temperature range	-40°C to +120°C	-40°C to +120°C	-40°C to +100°C	-40°C to +100°C	-40°C to +80°C	-40°C to +120°C	-40°C to +80°C	-40°C to +80°C	-40°C to +150°C
Pack sizes	20g, 50g, 500g, 2kg	3g, 20g, 50g, 500g	20g,500g	20g, 500g	20g,500g	10g, 20g, 300g	20g, 50g, 500g	10g	50g

LOCTITE 406
- Rapid bonding of plastics, rubbers, including EPDM, and elastomers
- LOCTITE SF 770 Polyolefin primer improves bonding on difficult-to-bond substrates

LOCTITE 401
- General purpose
- For acidic surfaces such as chromated or galvanised surfaces
- For porous substrates such as wood, paper, leather, cork and fabric

P1 NSF Reg. No.: 123011

LOCTITE 435
- High resistance to impact and shock loads, high peel strength
- Bonding of plastics, rubbers, metals, porous and absorbent substrates and acidic surfaces
- Good resistance in humid environments

LOCTITE 480
- For applications where shock resistance is required or shock or peel loads are present
- Ideal for bonding metal to metal, rubber or magnets
- Good resistance in humid environments

LOCTITE 4850
- For bonding materials subjected to bending or distortion, as well as flexible components
- For porous and absorbent substrates and acidic surfaces

LOCTITE 454
- General-purpose gel
- Ideal use on vertical or overhead surfaces
- Bonding paper, wood, cork, foam, leather, card, metals and plastics

P1 NSF Reg. No.: 123009

LOCTITE 460
- For applications where cosmetic appearance and low bloom are required
- For low odour during use
- For porous substrates such as wood, paper, leather, cork and fabric

LOCTITE 3090
- For applications with gaps up to 5mm
- For applications where cosmetic appearance and low bloom are required
- For porous substrates such as wood, paper, leather, cork and fabric

LOCTITE 4090
- For structural applications where speed, gap filling and high temperature resistance are required
- For outdoor applications and environments where excellent humidity resistance is required
- For bonding materials subjected to impact, vibrations and shock loads

Instant Adhesives

Product Table

Part 1 of Table / Part2 Next Page

Product	Chemical basis	Viscosity	Colour	Fixture time	Substrates		
					Plastics / Polyolefins	Rubbers	Metals
LOCTITE 382	Ethyl	5,000 mPa·s	Colourless transparent	20 – 40 sec.	•/•*	•	•
LOCTITE 401	Ethyl	100 mPa·s	Colourless transparent	3 – 10 sec.	•/•*	•	•
LOCTITE 403	Alkoxy ethyl	1,200 mPa·s	Colourless transparent	5 – 20 sec.	•/•*	•	•
LOCTITE 406	Ethyl	20 mPa·s	Colourless transparent	2 – 10 sec.	••/••*	••	•
LOCTITE 407	Ethyl	30 mPa·s	Colourless transparent	5 – 20 sec.	•/•*	•	••
LOCTITE 408	Alkoxy ethyl	5 mPa·s	Colourless transparent	5 – 10 sec.	•/•*	•	•
LOCTITE 409	Ethyl	Gel	Colourless transparent	20 – 60 sec.	•/•*	•	•
LOCTITE 410	Ethyl	3,000 mPa·s	Black	30 – 60 sec.	•/•*	•	•
LOCTITE 414	Ethyl	90 mPa·s	Colourless transparent	2 – 10 sec.	•/•*	•	•
LOCTITE 415	Methyl	1,200 mPa·s	Colourless transparent	20 – 40 sec.	•/•*	•	••
LOCTITE 416	Ethyl	1,200 mPa·s	Colourless transparent	20 – 40 sec.	•/•*	•	•
LOCTITE 420	Ethyl	2 mPa·s	Colourless transparent	5 – 20 sec.	••/•*	•	•
LOCTITE 422	Ethyl	2,300 mPa·s	Colourless transparent	20 – 40 sec.	•/•*	•	•
LOCTITE 424	Ethyl	100 mPa·s	Colourless transparent	2 – 10 sec.	••/••*	••	•
LOCTITE 431	Ethyl	1,000 mPa·s	Colourless transparent	5 – 10 sec.	•/•*	•	•
LOCTITE 435	Ethyl	200 mPa·s	Colourless transparent	10 – 20 sec.	•/•*	••	••
LOCTITE 438	Ethyl	200 mPa·s	Black	10 – 20 sec.	•/•*	•	••
LOCTITE 454	Ethyl	Gel	Colourless transparent	5 – 10 sec.	•/•*	•	•
LOCTITE 460	Alkoxy ethyl	40 mPa·s	Colourless transparent	5 – 20 sec.	•/•*	•	•
LOCTITE 480	Ethyl	200 mPa·s	Black	20 – 50 sec.	•/•*	••	••
LOCTITE 493	Methyl	3 mPa·s	Colourless transparent	10 – 30 sec.	•/•*	•	••
LOCTITE 495	Ethyl	30 mPa·s	Colourless transparent	5 – 20 sec.	•/•*	•	•
LOCTITE 496	Methyl	125 mPa·s	Colourless transparent	10 – 30 sec.	•/•*	•	••
LOCTITE 3090	Ethyl	Gel	Colourless transparent	90 – 150 sec.	•/•*	••	•
LOCTITE 4090	Cyanoacrylate -epoxy hybrid	High	Off-white to light yellow	180 sec.	••/–	•	••
LOCTITE 4011[Med]	Ethyl	100 mPa·s	Colourless transparent	3 – 10 sec.	•/•*	•	•
LOCTITE 4014[Med]	Ethyl	2 mPa·s	Colourless transparent	10 – 30 sec.	•/••*	•	•
LOCTITE 4031[Med]	Alkoxy ethyl	1,200 mPa·s	Colourless transparent	20 – 60 sec.	•/•*	•	•
LOCTITE 4061[Med]	Ethyl	20 mPa·s	Colourless transparent	2 – 10 sec.	••/••*	••	•
LOCTITE 4062	Ethyl	2 mPa·s	Colourless transparent	2 – 5 sec.	••/••*	••	•
LOCTITE 4204	Ethyl	4,000 mPa·s	Colourless transparent	10 – 30 sec.	•/•*	•	••
LOCTITE 4601[Med]	Alkoxy ethyl	40 mPa·s	Colourless transparent	20 – 60 sec.	•/•*	•	•
LOCTITE 4850	Ethyl	400 mPa·s	Colourless transparent	3 – 10 sec.	••/•*	••	•
LOCTITE 4860	Ethyl	4,000 mPa·s	Colourless transparent	3 – 10 sec.	•/•*	•	•

•• Well suted for • Suited for * In combination with primer LOCTITE SF 770

Instant Adhesives

Product Table

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	Substrates		Properties			
Product	Porous and / or acidic surfaces	Service temperature range	Low odour / cosmetic appearance	Flexible / impact resistance	Pack sizes	Comments
LOCTITE 382		-40°C to +80°C		–/•	20g, 500g	General purpose, gel
LOCTITE 401	••	-40°C to +120°C			3g, 20g, 50g, 500g	Universal, low viscosity
LOCTITE 403	••	-40°C to +80°C	••/••		50g, 500g	Low bloom, low odour, medium viscosity, Health and Safety labelling free
LOCTITE 406		-40°C to +120°C			20g, 50g, 500g, 2kg	Plastics and rubber, low viscosity
LOCTITE 407		-40°C to +100°C			50g	High temperature, low viscosity
LOCTITE 408	••	-40°C to +80°C	••/••		20g, 500g	Low bloom, low odour, capillary, Health and Safety labelling free
LOCTITE 409		-40°C to +80°C			20g	General purpose, gel
LOCTITE 410		-40°C to +80°C		•/••	20g	Toughened, black, high viscosity
LOCTITE 414		-40°C to +80°C			20g	General purpose, high viscosity
LOCTITE 415		-40°C to +80°C			20g, 50g, 500g	Metals, high viscosity
LOCTITE 416		-40°C to +80°C			20g, 50g, 500g	General purpose, high viscosity
LOCTITE 420		-40°C to +80°C			20g, 50g, 2kg	General purpose, capillary
LOCTITE 422		-40°C to +80°C			20g, 50g	General purpose, high viscosity
LOCTITE 424		-40°C to +80°C			20g, 500g	Plastics and rubber, low viscosity
LOCTITE 431	••	-40°C to +80°C			20g, 500g	Universal, medium viscosity
LOCTITE 435	••	-40°C to +100°C		•/••	20g, 500g	Toughened, clear
LOCTITE 438	••	-40°C to +100°C		•/••	20g	Toughened, black, fast
LOCTITE 454	••	-40°C to +120°C			10g, 20g, 300g	Universal, gel
LOCTITE 460	••	-40°C to +80°C	••/••		20g, 50g, 500g	Low bloom, low odour, low viscosity, Health and Safety labelling free
LOCTITE 480		-40°C to +100°C		•/••	20g, 500g	Toughened, black, slow
LOCTITE 493		-40°C to +80°C			50g	Metals, capillary
LOCTITE 495		-40°C to +120°C			20g, 50g, 100g, 500g	General purpose, low viscosity
LOCTITE 496		-40°C to +80°C			20g, 50g, 500g	Metals, low viscosity
LOCTITE 3090	••	-40°C to +80°C	•/••		10g	Gap filling, 2K, low bloom
LOCTITE 4090		-40°C to +150°C	••/•	–/••	50g	Structural applications, high temperature and moisture resistance, gap filling
LOCTITE 4011 Med	••	-40°C to +80°C			20g, 454g	Universal, low viscosity
LOCTITE 4014 Med		-40°C to +80°C			20g, 454g	Plastics and rubber, capillary
LOCTITE 4031 Med		-40°C to +80°C	••/••		454g	Low bloom, low odour, medium viscosity
LOCTITE 4061 Med		-40°C to +80°C			20g, 454g	Plastics and rubber, low viscosity
LOCTITE 4062		-40°C to +80°C			20g, 50g, 500g	Plastics and rubber, capillary
LOCTITE 4204		-40°C to +120°C		•/••	20g	High temperature, good impact resistance
LOCTITE 4601 Med		-40°C to +80°C	••/••		454g	Low bloom, low odour, low viscosity
LOCTITE 4850	••	-40°C to +80°C		••/–	20g, 500g	Flexible, bendable, low viscosity
LOCTITE 4860	••	-40°C to +80°C		••/–	20g, 500g	Flexible, bendable, high viscosity

Anti-Seizes
Product Table

Lubricating

What type of Anti-Seize do you require?

	General purpose		High performance			Speciality	
	Aluminium anti-seize	Copper anti-seize	Heavy duty	Water resistant	High load	High purity	Incidental food contact
Solution	LOCTITE LB 8150/8151	LOCTITE LB 8007/8008	LOCTITE LB 8009	LOCTITE LB 8023	LOCTITE LB 8012	LOCTITE LB 8013	LOCTITE LB 8014
							
Colour	Silver	Copper	Black	Black	Black	Dark grey	White
Solid lubricating agent	Aluminium, graphite, extreme pressure (EP) additives	Copper & graphite	Graphite & calcium fluoride	Graphite, calcium, boron nitride & rust inhibitors	MoS_2 & rust inhibitors	Graphite & calcium oxide	White oil and ex reme pressure (EP) additives
NLGI class	1	0	1	1	2	–	0
Service temperature range	-30°C to +900°C	-30°C to +980°C	-30°C to +1,315°C	-30°C to +1,315°C	-30°C to +400°C	-30°C to +1,315°C	-30°C to +400°C
Pack sizes	LB 8150: 500g, LB 8151: 400ml aerosol	LB 8007: 400ml aerosol LB 8008: 454g brush top	454g brush top	454g brush top	454g brush top	454g brush top	907g can

LOCTITE LB 8150 can
LOCTITE LB 8151 aerosol
- Heavy duty, temperature resistant, petroleum-based lubricant compound fortified with graphite and metallic flake
- Inert and will not evaporate or harden in extreme cold or heat
- For use in assemblies up to 900°C

LOCTITE LB 8007 aerosol
LOCTITE LB 8008 brush top
- Exclusive formula with copper and graphite suspended in a high quality grease
- Protects metal parts from rust, corrosion, galling and seizing at temperatures up to 9

LOCTITE LB 8009 brush top
- Metal-free
- Excellent lubricity
- Provides outstanding lubrication to all metals including stainless steel, aluminium and soft metals up to 1, 315°C

LOCTITE LB 8023 brush top
- Metal-free

Formulated to protect assemblies exposed directly or indirectly to fresh water and salt water, this anti-seize product works especially well in high humidity conditions
- has excellent lubricity, superior water wash-out spray resistance and prevents galvanic corrosion

ABS approved

LOCTITE LB 8012 brush top
- Metal-free
- Formulated to protect assemblies during running-in period
- Resists high static loads and MoS2 paste ensures maximum lubricity

LOCTITE LB 8013 brush top
- Metal-free
- High purity formula with excellent chemical resistance
- For stainless steel
- Ideal for use in the nuclear industry

PMUC approved

LOCTITE LB 8014
- Metal-free
- Prevents seizure, galling and friction in stainless steel and other metal parts up to 400°C

H1 NSF Reg. No.:123004

Dry Films and Oils

Product Table

Lubricating

	Dry film lubricant		Oil						
	General purpose	Non-metal surface	Penetrating oil	Chain lubricant	Silicone oil	Cutting oil	All-round cutting fluid	General purpose	Special purpose
Solution	LOCTITE LB 8191	LOCTITE LB 8192	LOCTITE LB 8001	LOCTITE LB 8011	LOCTITE LB 8021	LOCTITE LB 8030/8031	LOCTITE LB 8035	LOCTITE LB 8201	LOCTITE LB LM416
Appearance	Black	White	Colourless	Yellow	Colourless	Dark yellow	Brownish liquid	Light yellow	Green
Base	MoS_2	PTFE	Mineral oil	Synthetic oil	Silicone oil	Mineral oil	Emulsifier	Mineral oil	Mineral oil
Viscosity	11 s (Cup 4)	11 s (Cup 4)	4 cSt	11.5 cSt	350 mPa·s	170 cSt	Low	17.5 cSt (+50°C)	–
Service temperature range	11 s (Cup 4)	-180°C to +260°C	-20°C to +120°C	-20°C to +250°C	-30°C to +150°C	-20°C to +160°C	–	-20°C to +120°C	-10°C to +60°C
Load test 4 ball N (weld load)	–	–	1,200	2,450	–	8,000	–	–	–
Pack sizes	400ml aerosol	Not available in the U.K.	Not available in the U.K.	Not available in the U.K.	Not available in the U.K.	Not available in the U.K.	5 ltr / 20 ltr bucket	400ml aerosol	400ml aerosol, 4kg pail

LOCTITE LB 8191
- MoS2 anti-friction coating – aerosol
- Quick drying
- Surface protection against corrosion
- Enhances the performance of oils and greases

LOCTITE LB 8192
- PTFE coating
- For non-metal and metal surfaces
- Creates sliding surface for free movement
- Prevents dust/dirt accumulation
- Protection against corrosion
- For conveyor belts, slideways and cams

H2 NSF Reg. No.: 122980

LOCTITE LB 8001
- Penetrating mineral oil spray
- Multi-purpose penetrating oil for micro-mechanisms
- Penetrates inaccessible mechanisms
- Lubricates valve seats, collars, chains, hinges and cutting blades

H1 NSF Reg. No.: 122999

LOCTITE LB 8011
- High-temperature chain oil spray
- Oxidation resistance prolongs lubricant service life
- Lubricates open mechanisms, conveyors and chains at elevated temperatures up to 250°C

H2 NSF Reg. No.: 122978

LOCTITE LB 8035
- Water-miscible and bactericide -free
- With patented emulsifier system
- Very good corrosion protection and high process economy
- For drilling, turning,sawing, milling, threading, grinding
- Suitable for a broad range of materials: steel, high-alloy steel, cast iron and non- ferrous metals, including brass and aluminium alloys

LOCTITE LB 8021
- Silicone oil
- Lubricates metal and non-metal surfaces
- Suitable as release agent

H1 NSF Reg. No.: 141642

LOCTITE LB 8030 bottle
LOCTITE LB 8031 aerosol
- Cutting oil
- Protects cutting tools in operation
- Improves surface finish
- Increases tool life
- For drilling, sawing or tapping steel, stainless steel and most non-ferrous metals

LOCTITE LB LM 416
- Biodegradable track lubricant
- Superior corrosion protection
- Applicable in any season
- Long intervals between applications
- Mainly used for slide chair lubrication

Approved by Network Rail, UK

LOCTITE LB 8201
- Five-way spray
- Frees assemblies
- Lubricates metal
- Cleans parts
- Displaces moisture
- Prevents corrosion

ARDROX®
anti-corrosion



ARDROX AV 30

Penetrating, water displacing, corrosion inhibiting compound (CIC). Range of Use: Applied as a coating to protect metals commonly used in airframe structures and in aerospace components from corrosion. AV 30 can be used in all areas of the airframe on painted and unpainted surfaces.

AV 30 is a versatile CIC product. It combines good penetration properties with excellent corrosion inhibiting characteristics at low applied film weight. Movable parts should be masked before treatment unless spray application can be controlled to prevent direct contact. If AV 30 spray control or masking of movable components is not possible, then an alternative, soft waxy film CIC, such as AV 25 should be used.



ARDROX AV 8

Super penetrating, water displacing, corrosion inhibiting compound (CIC). Forms a tack-free, firm film.

Range of Use: Applied as a coating to protect metals commonly used in airframe structures and in aerospace components from corrosion.

AV 8 can be used in all areas of the airframe on painted and unpainted surfaces. It combines good penetration properties with excellent corrosion inhibiting characteristics and a low applied film weight. In areas exposed to severe corrosion conditions AV 8 should be overcoated with AV 100D - a heavy duty, waxy, firm film CIC. Movable parts should be masked before treatment unless spray application can be controlled to prevent direct contact. If AV 8 spray control or masking of movable components is not possible, then an alternative, soft waxy film CIC, such as AV 25 should be used.



ARDROX AV 25

Penetrating, water displacing, general purpose, corrosion inhibiting compound (CIC). Forms a soft, waxy film.

Range of Use: Applied as a coating to protect metals commonly used in airframe structures and in aerospace components from corrosion. AV 25 can be used in all areas of the airframe on painted and unpainted surfaces.

It is designed for the treatment of areas where a soft, lubricating film is required, for example pulleys, control cables and other movable components.





Aerospace Sealants Cross Reference

PRC SEALANTS | NAFTOSEAL | ROYAL ADHESIVES & SEALANTS | A·C·TECH Aerospace Sealants of Choice

NO.	PRC SEALANT	Naftoseal	Royal Sealant	AC tech	Specifications	Company	Description
1	PS 890 A	-	WS8020 A-1/2, A2	-	AMS-S-8802	Airbus	Integral Fuel Tank Sealant
2	PS 890 B	-	WS8020 B-1/2, B1, B2, B4	-	AMS-S-8802	Airbus	Integral Fuel Tank Sealant
3	PR 1750 B	-	WS8020 B-1/2, B1, B2, B4	-	AMS3276	Airbus	Integral Fuel Tank Sealant
4	-	-	WS8010 B-1/2, B2	-	AMS3284	Airbus	Access Door Sealant
5	PR 1422 A	MC-236 A-1/2, A-1, A-2	-	-	199-05-004	Agusta Westland	Integral Fuel Tank Sealant
6	PR 1422 B	MC-236 B-1/2, B-1, B-2, B-4	-	-	199-05-004	Agusta Westland	Integral Fuel Tank Sealant
7	-	-	-	AC-350 A-1/2, A2	DGQT 1.7.0.0115	Dassault Aviation	Integral Fuel Tank Sealant
8	-	-	-	AC-350 B-1/2, B2, B4	DGQT 1.7.0.0116	Dassault Aviation	Integral Fuel Tank Sealant
9	-	-	-	AC-240 B	PS-3 TABLE I	DeCrane Aircraft PATS AIRCRAFT, LLC	Integral Fuel Tank Sealant
10	-	-	-	AC-236 A	PS-3 TABLE I	DeCrane Aircraft PATS AIRCRAFT, LLC	Integral Fuel Tank Sealant
11	-	-	-	AC-665 C	PS-3 TABLE I	DeCrane Aircraft PATS AIRCRAFT, LLC	Corrosion Inhibitive Sealant
12	-	-	-	AC-250 B	PS-3 TABLE I	DeCrane Aircraft PATS AIRCRAFT, LLC	Quick Repair Sealant
13	-	-	-	AC-160	PS-3 TABLE I	DeCrane Aircraft PATS AIRCRAFT, LLC	Adhesion Promoter
14	-	-	-	AC-410	PS-3 4.3	DeCrane Aircraft PATS AIRCRAFT, LLC	low Vapor Pressure Purging Thinner
15	-	-	-	AC-665 C-12	PS-3 TABLE II 4.1 A	DeCrane Aircraft PATS AIRCRAFT, LLC	Corrosion Inhibitive Sealant
16	-	-	-	AC-236 A2	PS-3 TABLE II 4.1 AB	DeCrane Aircraft PATS AIRCRAFT, LLC	Integral Fuel Tank
17	-	-	-	AC-240 B2	PS-3 TABLE II 4.1 AB	DeCrane Aircraft PATS AIRCRAFT, LLC	Integral Fuel Tank (Fast Cure)
18	-	-	-	AC-250 B-1/6	PS-3 TABLE II 4.1 C	DeCrane Aircraft PATS AIRCRAFT, LLC	Quick Repair Sealant
19	-	-	-	AC-236 A-1/2	LES 1039 BV	learjet (Bombardier)	Integral Fuel Tank
20	-	-	-	AC-236 A2	LES 1039 BV	learjet (Bombardier)	Integral Fuel Tank
21	-	-	-	AC-236 B-1/2	LES 1039 BV	learjet (Bombardier)	Integral Fuel Tank
22	-	-	-	AC-236 B2	LES 1039 BV	learjet (Bombardier)	Integral Fuel Tank
23	-	-	-	AC-236 B4	LES 1039 BV	learjet (Bombardier)	Integral Fuel Tank

Aerospace Sealants Cross Reference

PRC SEALANTS | NAFTOSEAL | ROYAL ADHESIVES & SEALANTS | A·C·TECH. Aerospace Sealants of Choice

NO.	PRC SEALANT	Naftoseal	Royal Sealant	AC tech	Specifications	Company	Description
24	PR 1436 GB PS 870 B PR 1775 B	-	-	AC-665 B-1/2, B2	EMB 145 (MIL-PRF-81733)	EMBRAER	Corrosion Inhibitive Sealant
25	PR 1422 B PR 1440 B PS 890 B	-	-	AC-240 B-1/2, B2	EMB 145 (MIL-S-8802)	EMBRAER	Integral Fuel Tank (Fast Cure)
26	-	-	-	AC-236 A-1/2, A2	EMB 145 (51-20-01) S.R.M.	EMBRAER	Integral Fuel Tank
27	-	-	-	AC-240 B-1/4, B-1/2, B2	EMB 145 (51-20-01) S.R.M.	EMBRAER	Integral Fuel Tank (Fast Cure)
28	-	-	-	AC-250 A-1/6,	EMB 145 (51-20-01) S.R.M.	EMBRAER	Quick Repair Sealant
29	-	-	-	AC-250 B-1/6,	EMB 145 (51-20-01) S.R.M.	EMBRAER	Quick Repair Sealant
30	-	-	-	AC-665 B-1/2, B2	EMB 145 (51-20-01) S.R.M.	EMBRAER	Corrosion Inhibitive Sealant
31	PR 1771 B PR 1776 B PR 1782 B	MC-780 B-1	-	-	AIMS 04-05-001 -012, -014 & -015	Airbus France	Integral Fuel Tank (Fast Cure)
32	PR 148	MC-110	-	-	-	Airbus Germany	Adhesion Promoter
33	PR 148	MC-115	-	-	-	Airbus Germany	Adhesion Promoter for MC-780
34	PR 1403 G A-2	MC-216 A-2	-	-	DAN 1269	Airbus Germany	Low Adhesion/ Access Door
35	PR 1403 G B-2	MC-216 B-2	-	-	DAN 1270	Airbus Germany	Low Adhesion/ Access Door
36	PR 1422 B-2	MC-238 B-2	-	-	DAN 1186-06 AIMS 04-05-001	Airbus Germany	Integral Fuel Tank & Fuselage
37	-	MC-450 A-1/3	-	-	AIMS 04-31-001	Airbus Germany	Gap Filler for Floor Panels
38	PS 892 C	MC-630 C-2,C-3, C-12,C-48,C-60	-	-	DAN 1184 AIMS 04-05-001	Airbus Germany	General Purpose (Fuselage)
39	PR 1436 G A PR 1776 A	MC-630 A-2 (not grey)	-	-	DAN 1159 AIMS 04-05-001	Airbus Germany	General Purpose (Fuselage)
40	PR 1445 B-1	MC-650 B-1	-	-	DAN 1186-02 AIMS 04-05-001	Airbus Germany	General Purpose (Fuselage)
41	PR 1782 B	MC-770 B-1 B-2, B-2 grey	-	-	AIMS 04-05-001	Airbus Germany	General Purpose (Fuselage)
42	PR 1782 A	MC-780 A-1/2, A-1, A-2	-	-	AIMS 04-05-001 -012,-014 & -015	Airbus Germany	Integral Fuel Tank & Fuselage
43	PR 1782 B	MC-780 B-1/2, B-1, B-2, B-4	-	-	AIMS 04-05-001 -012,-014 & -015	Airbus Germany	Integral Fuel Tank & Fuselage
44	PR 1782 C	MC-780 C-1/3, C-2, C-4, C-12	-	-	AIMS 04-05-001& -012,-014 & -015	Airbus Germany	Integral Fuel Tank & Fuselage



Aerospace Sealants Cross Reference

PRC SEALANTS | NAFTOSEAL | ROYAL ADHESIVES & SEALANTS | A·C·TECH Aerospace Sealants of Choice

NO.	PRC SEALANT	Naftoseal	Royal Sealant	AC tech	Specifications	Company	Description
45	PR 1782 C	MC-780 C-24, C-36, C-48, C-60	-	-	AIMS 04-05-001& -012,-014 & -015	Airbus Germany	Integral Fuel Tank & Fuselage
46	PR 1782 A	MC-780 A-1/2, A-1, A-2	-	-	AIMS 04-05-001& -012,-014 & -015	Airbus Spain	Integral Fuel Tank & Fuselage
47	PR 1782 B	MC-780 B-1/2 B-1, B-2, B-4	-	-	AIMS 04-05-001& -012,-014 & -015	Airbus Spain	Integral Fuel Tank & Fuselage
48	PR 1782 C PS 892 C	MC-780 C-1/3 C-2, C-4, C-12	-	-	AIMS 04-05-001& -012,-014 & -015	Airbus Spain	Integral Fuel Tank & Fuselage
49	PR 1782 C PS 892 C	MC-780 C-24, C-36, C-48, C-60	-	-	AIMS 04-05-001& -012,-014 & -015	Airbus Spain	Integral Fuel Tank & Fuselage
50	PR 184	MC-110	-	-	ABP 4-5141, 4-5142	Airbus UK	Adhesion Promoter
51	PR 184	MC-115	-	-	ABP 4-5141, 4-5142	Airbus UK	Adhesion Promoter
52	PR 1403 B-2 PR 1428 B-2	MC-216 B-2	-	-	ABP 4-5141, 4-5142	Airbus UK	Low Adhesion/ Access Door
53	PR 1422 A PR 1783 A	MC-238 A-1/2, A-2, A-4	-	-	AIMS 04-05-001&002, ABP 4-5141 , 4-5142	Airbus UK	Integral Fuel Tank & Fuselage
54	PR 1422 B	MC-238 B-1/2, B-2, B-4	-	-	AIMS 04-05-001&002, ABP 4-5141 , 4-5142	Airbus UK	Integral Fuel Tank & Fuselage
55	PR 2001 B	MC-770 B-2 grey	-	-	AIMS 04-05-001 ABP 4-5142	Airbus UK	General Purpose (Fuselage)
56	PR 1782 A	MC-780 A-1/2, A-1, A-2	-	-	AIMS 04-05-001 -012,-014,-015, ABP 4-5141, 4-5142	Airbus UK	Integral Fuel Tank & Fuselage
57	PR 1782 B PR 2001 B	MC-780 B-1/2 B-1, B-2, B-4	-	-	AIMS 04-05-001 -012,-014,-015, ABP 4-5141, 4-5142	Airbus UK	Integral Fuel Tank & Fuselage
58	PR 1770 C PR 1782 C	MC-780 C-1/3, C-2, C-4, C-12	-	-	AIMS 04-05-001 -012,-014,-015, ABP 4-5141, 4-5142	Airbus UK	Integral Fuel Tank & Fuselage
59	PR 1770 C PR 1782 C	MC-780 C-24 C-36, C-48, C-60	-	-	AIMS 04-05-001 -012,-014,-015, ABP 4-5141, 4-5142	Airbus UK	Integral Fuel Tank & Fuselage
60	PR 1771 B	MC-780 B-1/2 B-2, B-4	-	-	HMRC 0110	Aircelle, France	Integral Fuel Tank & Fuselage
61	PR 1422 A	MC-238 A-1/2, A-2	-	-	NTA 65361	Alenia. Italy	Integral Fuel Tank & Fuselage
62	PR 1422 B PR 1782 B	MC-238 B-1/2, B-2	-	-	NTA 65361	Alenia. Italy	Integral Fuel Tank & Fuselage
63	PR 1782B	MC-780 B-1/ 2, B-2, B-4	-	-	NTA 65361	Alenia. Italy	Integral Fuel Tank & Fuselage
64	PR 1782 C	MC-780 C-12, C-24, C-48	-	-	NTA 65361	Alenia. Italy	Integral Fuel Tank & Fuselage

Aerospace Sealants Cross Reference

PRC SEALANTS · NAFTOSEAL · ROYAL ADHESIVES & SEALANTS · A·C·TECH Aerospace Sealants of Choice

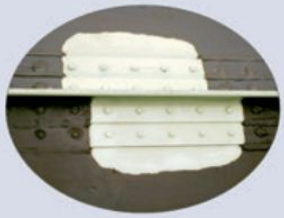
NO.	PRC SEALANT	Naftoseal	Royal Sealant	AC tech	Specifications	Company	Description
65	PR 1422 A PR 1440 A PR 1776 A	MC-238 A-2	-	-	MDL 6057	Alenia Aermacchi, Italy	Integral Fuel Tank & Fuselage
66	PR 1422 B PR 1440 B PR 1776 B	MC-238 B-2	-	-	MDL 6057	Alenia Aermacchi, Italy	Integral Fuel Tank & Fuselage
67	PR 1422 A PR 1440 A PR 1776 A	MC-780 A-2	-	-	MDL 6058	Alenia Aermacchi, Italy	Integral Fuel Tank & Fuselage
68	PR 1422 B PR1440 B PR 1776 B	MC-780 B-2, B-4	-	-	MDL 6058	Alenia Aermacchi, Italy	Integral Fuel Tank & Fuselage
69	PS 892 C	MC-780 C-2, C-4	-	-	MDL 6058	Alenia Aermacchi, Italy	Integral Fuel Tank & Fuselage
70	PS 870 B	MC-780 B-1/2, B-2	-	AC 665 AC 735 B	BAMS 552-008	Bombardier Canada	Fast Cure Fuselage
71	PR 1776 B	MC-780 B-1/2, B-2	-	-	BAMS 552-009	Bombardier Canada	Fast Cure Fuselage
72	PR 1776 B PR 1422 B PR 1440 B PS 870 B PR 2050 B	MC-780 B-1/2, B-2	-	-	MEP 09-084 NE-040-134	Embraer, Brazil	Integral Fuel Tank & Fuselage
73	PS 870 C	MC-780 C-2, C-4 C-12, C-24	-	-	MEP 09-084 NE-040-134	Embraer, Brazil	Integral Fuel Tank & Fuselage
74	PR 1422 A-2	MC-236 A-2	-	-	WL 5.5901.2	Eurocopter Deutschland	Integral Fuel Tank & Fuselage
75	PR 1422 B-2	MC-236 B-2	-	-	WL 5.5901.2	Eurocopter Deutschland	Integral Fuel Tank & Fuselage
76	PR 1771 B	MC-780 B-1	-	-	ECSL 2339	Eurocopter France	Fuselage Sealant
77	PR 1440 A PR 1422 A	MC-238 A	-	-	NP 192 001	Piaggio, Italy	Integral Fuel Tank & Fuselage
78	PR 1440 B PR 1422 B	MC-238 B	-	-	NP 192 001	Piaggio, Italy	Integral Fuel Tank & Fuselage
79	PR 1440 B PR 1422 B	MC-780 B	-	-	NP 192 001	Piaggio, Italy	Integral Fuel Tank & Fuselage
80	PR 1440 A PR 1422 A	MC-780 A	-	-	NP 192 001	Piaggio, Italy	Integral Fuel Tank & Fuselage
81	PS 892 C	MC-780 C-2, C-12, C-24, C-48	-	-	NP 192 001	Piaggio, Italy	Integral Fuel Tank & Fuselage
82	PS 892 C	MC-630 C-2, C-3, C-12, C-48	-	-	NP 192 002	Piaggio, Italy	Integral Fuel Tank & Fuselage
83	PR 147 PR 148 PR 184	MC-110	-	-	NP 192 002	Saab	Adhesion Promoter
84	PR 1422 B PR 1440 B PR 1776 B	MC-238 B-2	-	-	-	Saab	Integral Fuel Tank & Fuselage

It is a product that no MRO, FBO facility should be without.

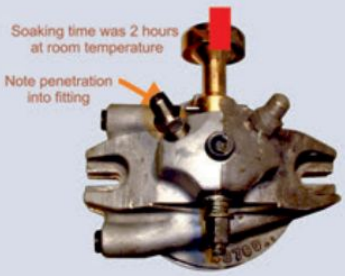
PolyGone 310 - AG

Polysulfide Sealant Removal

Interior of an aircraft fuel tank



Cleaning a Polysulfide Mix Head



Polygone at Work



Some of Airframes Using PolyGone

- B-727
- B-737
- B-757
- DC-10
- MD-11
- Falcon
- A-340
- Fairchild Metro
- C-5 Galaxy
- ATR-42
- CRJ 100/200/700/900
- Challenger
- Lear ...& F-16
- Twin Commander
- Embraer
- Beech
- Grumman
- King Air
- Mooney
- Cessna
- Hawker

PolyWipes AG (Aviation Grade)

Technical Data Sheet

Description

PolyWipes are a unique non-woven fabric impregnated with a non-toxic aqueous solution designed to safely remove uncured or partly cured adhesives, sealants, including polysulfide and silicone, greases, oils, and other contaminates.

PolyWipes proprietary aqueous formulation is designed to reduce surface tension between the material and the substrate. Once reduced, the wipe picks up the material from the substrate for easy disposal. Since PolyWipes are non-toxic they eliminate the need to use hazardous solvents in the workplace.

Advantages

- Non-toxic
- Non-flammable
- Non-hazardous-Not subject to dangerous goods regulations.
- No phosphates, acids or silicones
- Neutral pH of 6-7
- Fresh smell – NOT citrus



Application

PolyWipes are intended for use at room temperature(68°F-80°F). They can be used to clean up after applying sealant to fuel tanks, access doors, windshields or any other location where sealants are used.

Directions for Use

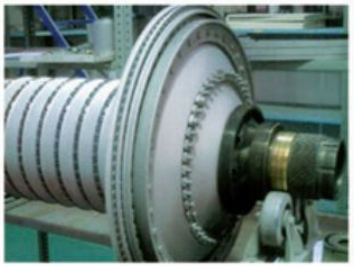
Remove wipe from container and fully open the wipe. Place wipe over sealant to be "picked up". Use one hand and press down on the suface next to the sealant. Rotate hand and flick the material off the surface. Fold the towelette on itself and continue until the sealant is removed. Dispose of towel when finished.

Package Sizes	150-wipe poly containers 4 x 150-wipe poly container cases
Shelf Life	2-years
Storage	Do not store under 35°F/2C and not above 122°F/50C. Do not use below 35°F/2C

Properties

NFPA Hazard Class:	Health 0	VOC: Not tested
	Flammability 0	pH: >6 <7
	Reactivity 0	Flash point: N.A.

High Performance Paints and Coatings for Turbine & Aero Engine Production and Overhaul





Engineered Paints and Surface Coatings

IP1041 Aluminium Silicon Diffusion Coating for High Temperature Protection against Sulphidation.

MSRR 1041,OMat 7/129A

It is used as an alternative to Sermalloy J.

IP9253-R2 High Heat Chrome Free Organic Sacrificial Aluminium Coating.

MSRR 9253, OMat 7/126B , COMAT 07-104 (Alt to PL 219 - 3863 - A 6000)

Used on aero engine and other components as an organic sacrificial coating up to 600° C.

IP9138R1 High Heat Resistant Air Drying Aluminium Coating

MSRR 9040 (All to PL 82 - E 3592) OMat 7/22B MTU - Mt 1254 , WHPS402

Air drying,organic coating with resistance to heat, corrosion, and aircraft fluids. For use on steel, aluminum,and other metal parts.

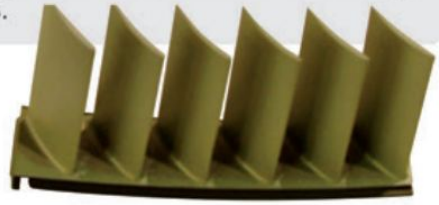
IP9138R1 / Aerosol

MSRR 9040, OMat 7/22B

Aerosol version suitable for both cosmetic touch and as a high temperature coating. Supplied in 400ml Cans.

IP9188-R2 Erosion and Heat Resisting Coating

Applied to engine parts of steel and aluminum, it is best recognized in the air intake of many Rolls engines.



PL177 Touch-up Coating

MSRR 9141; OMat 7/47

Corrosion resistant coating designed for use as a touch up for 560°C processed Ipcote, on ferritic stainless steel aeroengine and turbine components operating to 600°C, and corrodible steel components to 500°C.

PL270 Touch-up Coating for Ipseal Khaki

MSRR 9394; OMat 7/169A

Inorganic airdrying brushing touch-up coating for Ipseal Khaki.

PL150-R1 Touch-up Coating for Ipseal Green

MSRR 9041; OMat 7/169B, Number 7/110B, SMM 916

Inorganic airdrying brushing touch-up coating for Ipseal Green.

PL163 Clear High Heat Polyimide Aero Engine Coating

MSRR 9142, OMat 7/134; AFS 1566; NSN 8010 99 05 16491; (IP 9144)

Clear stoving coating for use on aero engines. It also confers erosion and corrosion resistance. Used on engines such ad the RB211.

IP9134R1 Aluminium Polymide Engine Coating

MSRR 9134. NSN 99 1925127 (Alt to PL 165) OMat 7/136B

Aluminum filled stoving coating for spray application to aeroengine components.

Metal Protective Varnishes (Stoving Versions) (Aerolac Alternatives)

MTU - MTS 1026A
IP9140 Clear Comply with the requirements of withdraw specifications MSRR 9051 OMat 712A and OMat 710
IP9149 Aluminium Comply with the requirements of withdrawn specifications MSRR 9051 and OMat 729B
IP9155 , Comply with the requirements of withdrawn specifications MSRR 9051 and OMat 701A

Stoving, anti-corrosive coatings especially suitable for a wide range of metals including light alloys of magnesium and aluminium.

Metal Protective Varnishes (Air Drying versions)

Comply with requirements of withdrawn specification MSSR 9037
IP9169 OMat 7/24A Air Drying Metal Touch Up Clear (Alternative to 1721-C-8187-CO 5187, CV114)
IP9170 OMat 7/35A Air Drying Metal Touch Up Grey 693 (Alternative to 1721-D-6930-CO 5153/693)
IP9173 OMat 709 Air Drying Metal Touch Up Black (Alternative to 1721-X-9520-CO 5152)

These materials are used for overspraying and touching unprotected parts on engines, and damaged areas on cadmium plated parts.

IP1043, Compressor Blade Sealing Compound - High Temperature

MSRR 1043, OMat 844A

Water based green ceramic coating for aero engines and compressors. Spray applied, it is effective to 850°C. Used on nickle based alloys to prevent against " Green rot" oxidation.

PL95 Mica Impregnated Insulating Coating

MSRR 9054, OMat 773

An excellent insulating coating for spray application to aero engine components.

PL134 R2 Ceramic Blade Coating to 850°C

MSRR 9176, OMat 7/75

Water based green ceramic coating for aero engines and compressors. Spray applied, it is effective to 850°C. Used on nickel based alloys to prevent against "Green rot" oxidation.

IP9181 A+B Air Drying Intumescent

BSX38; MSRR 1055 , OMat 7/28B

Formuated to run at 180°C and be air curable, replacement for PL161.

IP1897 A and B Air Drying Intumescent; Low Temperature Capability

BSX37; Goodrich 1897

Modified garde of IP9189, formulated to remain flexible at -40°C, for use on fuel pumps manufactured by Goodrich.

IP1265 Thermal Ceramic Barrier

Is in use on the latest Aquada Sports car, and being appraised by aerospace companies including GKN for use on de-iceing equipment.

Two Pack Epoxy Air Drying Coatings

IP3 range; ultra low VOC; xylene/toluene free (<200gm/litre)
IP9064 series; standard VOC
BSX 33, Def-Stan 80-161 (DTD 5555);
MSRR 9064 and several manufacturer specs.
(Alternative to SL 5459, 9110-X-0000, CSH 5538 etc)

IP6 Two Pack Low VOC Polyurethane Air Drying Coatings

BS2X34 A/B; MSRR 1006,PRO 599, PCS 2530, HCP 355 plus several manufacturer specifications

Low VOC <420gm/liter, 2 pack polyurethane finishes with good erosion, UV and Chemical resistance. Normal top coat for air frames.

IP714 and IP715 Low VOC Chromate Free Engine Coating System

PWA 36568; CPW 714 (IP714 primer) and PWA 36569. CPW 715 (IP715 Finish)

Low VOC; chromate free anti-corrosive primer and topcaot system; xylene and toluene free. For use on steel, aluminum, sealed magnesium and most composites.

PL146-PL168-R1 High Heat Resistant Paints

MSRR 9041 ,SMM 916 , OMat 7/110A

Spraying, (brushable on small areas), inorganic paint used for example on the hot end of BAe tornado.

Dry Film Lubricants

PL237-R2 Molybdenum Based Dry Film Lubricant

MSRR 9274, RAE (F) LV/486/265, RPS 242. OMat 4/43
NSN:91-5099-430-9538

Molybdenum disulphide pigmented spraying product for operating in adverse conditions to 300 °C with resistance to lubricants, skydrol, and corrosive engine by products.

IP9136-R1 / R3 / R4 Graphite Based Dry Film Lubricant

CPW 27, MSRR 9276, RPS 242. OMat 4/44C ;
Comat 10-002 (Alt to PL 239, 3862-X-9010)

Spraying graphite lubricant resistant to skydrol lubricants, and corrosion to 400°C.

PL181 High Temperature Inorganic Boron Nitride Dry Film Lubricant

MSRR 9200, Def 91-19, OMat 4/36

Speciality dry film lubricant designed to operate at temperatures up to 700°C.

PL470 Rapid DFL Repair Kit

OMat 4/70

Newly developed rapid repair MoS2, dry film lubricant touch up kit developed in conjunction with Rolls Royce.

IP3016 Tungsten Disulphide High Temperature DFL

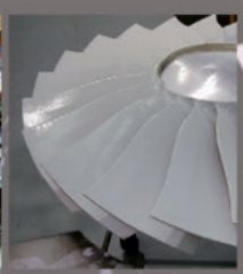
MSRR 3016, OMat 4/80

Developed for high heat applications, in excess of 400°C. Excellent resistance to fretting or galling.

IP9286 Range of PTFE filled Polymide Coatings

MSRR 9286, OMat 7/95A

Used as an erosion resistant material, or for lubrication, for example in hinge pins and under carriage assembly.


Attrition Coatings

NML 46 Thick Film Attrition Coating: Pre-Mixed 2 Component Product, Supplied as a Stable Frozen Stick

MSRR 9012, RPS 340 (I9100), OMat 7/78

Used on the interior of engine compressor components, aluminium, steel, and titanium it is resistance to oils, fuels, and abrasion.

NML 52 Primer Adhesive for Attrition Coatings

MSRR 9072 (IP9100), OMat 7/82

A clear adhesive for use with the thick film attrition coating NML 46.

NML 40 Cold Curing Attrition Coating

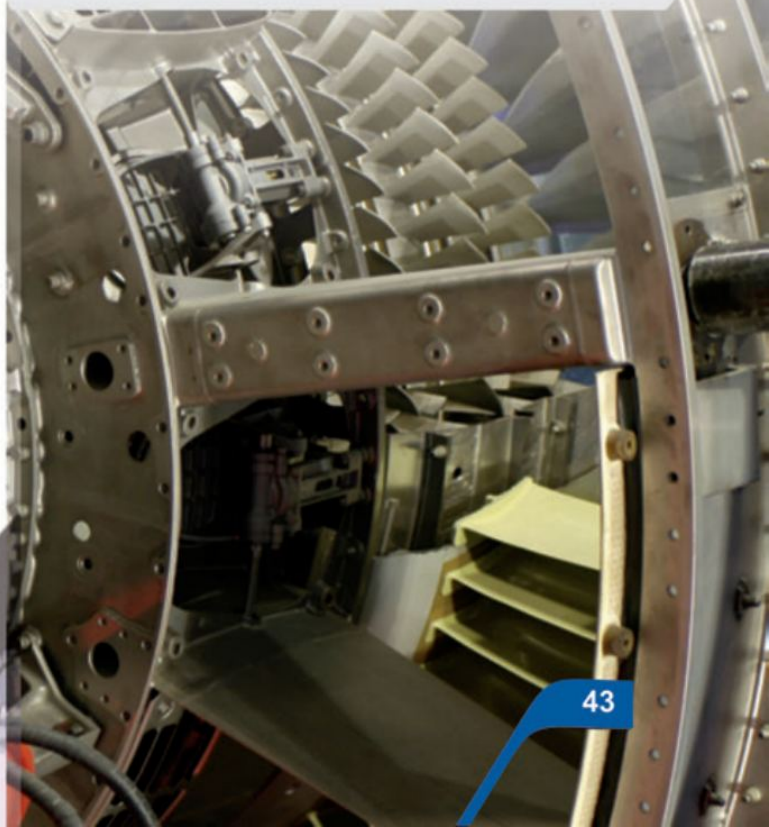
OMat 863

A two part cold curing attrition compound developed for local repair and field use where stoving facilities are not available.

NML 58 Extended Shelf Life Two Part Attrition Coating

RPS 340 (IP9103) ,OMat 7/77

Two pack system developed as a long shelf life field overseas replacement for NML40. Used on engine compressor components.



The Ipcote Range of Sacrifical Aluminium Coatings

Basecoats

Ipcote IP9183-R1

MSRR 9140; OMat 7/46B; PCS2550; LB598; ITP SMM-903 , Nato:8030-99-406-7055

The original sacrificial basecoat.
Used as a replacement / alternative to Sermetal W/WFX

Smoothcote IP9442

LB598; CPW88

A smooth surface alternative to IP9183-R1, manufactured using smaller particle size aluminium powder. Gives a denser, more erosion resistant product, with similar corrosion protection to IP9183-R1.

Ipthin IP9356

MSRR 9356; ITP SMM-919
OMat 7/167A and Nato: 8030-99-864-6844

Thin film version of Ipcote, to allow easy application of film thickness of 12-25 microns. This is of use in areas where tolerances are critical, including interference fit joints, flanges, bolts, engine mounts, fasteners and dovetails.

Chrome Free Systems

IP9253-R2 OMat 7/126B and COMAT 07-104
MSRR 9253

Stoving, spray applied high heat resisting aluminium filled coating, for use on engine components operating at up to 600°C (1115°F) on 12% Chromium Steel or 500°C (930°F) on low alloy steels which are subjected to harsh media such as phosphate ester based hydraulic fluids.



Sealcoats

Ipseal IP9184 Green and Khaki

MSRR 9140; OMat7/168B; LB598; ITPSMM-903; PCS 2550

High temperature sealing compound used over Ipcote, Ipthin. For use at temperatures in excess of 600°C. Can also been used as a stand alone product. Used as alternatives to Sermetal 570A.

Smoothseal IP 9444

MSRR 3010, OMat 7/262

Very smooth, thin seal coat, used over either Smoothcote or Ipcote as an alternative to Sermetal 5380/5380DP.

Organic Seal coat Blue IP1949

PWA 595

Chrome free, heat and corrosion resistant sealcoat developed specifically for Standard Aero to give a very fine surface finish.
Will also pass to CPW 563.

Organic Sealcoat J900

CPW 563

Developed for use as a chrome free alternative sealcoat for use on Pratt & Whitney Canada range as an alternative to the 5380 range.

