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Product Description Sheet

Product 220

Industrial Products, February 2000

PRODUCT DESCRIPTION

LOCTITE® 220 is a low strength anaerobic threadlocking compound designed for pre or post-application to small plated fasteners. It prevents loosening while allowing adjustment or easy removal.

TYPICAL APPLICATIONS

Recommended for metal fasteners 2-56 through 10-32 screw sizes.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Methacrylate ester
Appearance	Blue Fluorescent Liquid
Specific Gravity	1.08
Viscosity, cP or mPa.s @ 77°F (25°C) Cannon Fenske #150	20
Flash Point (TCC), °C (°F)	>200°F (93°C)

TYPICAL CURING PERFORMANCE

Cure speed vs. temperature

The rate of cure will depend on the ambient temperature. **Full cure** is attainable in 24 hours at room temperature, 22°C (72°F), or 1 hour at 93°C (200°F).

PERFORMANCE OF CURED MATERIAL

After 24 hr at 72°F (22°C):

	Typical Value
Breakaway Torque on steel 3/8 x 16 nuts and bolts in accordance with MIL-S-46163 procedures in.lb. (Nm)	85 (10)
Prevail Torque on steel 3/8 x 16 nuts and bolts in accordance with MIL-S-46163 procedures in.lb. (Nm)	170 (20)

Where Breakaway Torque is the force required to initiate the fastener movement and Prevail Torque is the force required to disassemble the fastener once Breakaway Torque has occurred.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

DISCOLORATION OF TREATED MATERIALS

Loctite adhesives/sealants are slightly acidic and may discolor some metals. However, this does not affect the performance of the products or the materials to which they are applied.

PROPER APPLICATION METHOD

Proper application on through-hole assemblies involves filling male, female or both threads with adhesive. For blind-hole (non through-hole) assemblies, adhesive should be applied into the bottom of the hole. Fastener installation will hydraulically force adhesive upward into the threads.

MATERIAL COMPATIBILITY

Loctite anaerobic adhesives/sealants can be used in conjunction with all metals, glass ceramics and many thermoset plastics such as phenolic and polyester. Liquid adhesives will, however, soften and sometimes craze thermoplastics including ABS, polycarbonate, vinyl and methacrylates. They will also soften varnish and lacquer finishes. Most baked enamel finishes are not harmed by initial contact, but should be wiped clean within an hour of application. The cured Loctite 220 adhesive will not affect any of these materials.

DISASSEMBLY AND CLEANUP PROCEDURE

To aid in disassembly, Loctite anaerobic compounds can be weakened by heating to at least 500°F (260°C). Once disassembled, cured adhesive can be removed with Chisel® Gasket Remover 790 by following instructions. A solvent wipe with an organic or petroleum solvent will remove uncured adhesive outside the joint.

Storage

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact your local Technical Service Center.

Note

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