TECHNICAL DATA SHEET

LOCTITE® THREADLOCKER BLUE 242

Item #	Package	Size
209728	Carded Tube	0.20 fl. oz. (6 ml)

DESCRIPTION:

Loctite® Threadlocker Blue 242® is designed for the locking and sealing of threaded fasteners which require normal disassembly with standard hand tools. The product cures anaerobically, when there is an absence of air between close fitting metal surfaces. It protects threads from rust and corrosion and prevents loosening from shock and vibration. Loctite® Threadlocker Blue 242® is particularly suited for applications on less active substrates such as stainless steel and plated surfaces, where disassembly is required for servicing.

RECOMMENDED FOR:

Use on metal fasteners 1/4" (6 mm) to 3/4" (19 mm) in diameter in a wide variety of applications including:

Automotive – Valve covers, water pumps, alternators, oil pans
Maintenance – Light machinery, light conveyors, door hardware, tow motors
Home – Lawn mowers, grills, locksets, bicycles

LIMITATIONS:

- Not for use on plastic parts, particularly thermoplastic materials where stress cracking of the plastic could result
- Not 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
- If two inactive metals are used, use of a primer is required
- Not for use in applications requiring "food safe" locking and sealing of fasteners

FEATURES & BENEFITS:

Feature	Benefits
Protects threads	Prevents rusting of threads
Medium strength	Can be removed with hand tools
Locks threads	Prevents loosening of metal fasteners caused by vibrations

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Typical Uncured Physical Properties

Color:	Blue
Appearance:	Liquid
Base:	Dimethylacrylate ester
Specific Gravity:	1.1
VOC Content	6.17 g/l, SCAQMD Method 316B
Flashpoint:	>199.9°F (93°C)
Shelf Life:	24 months from date of manufacture (unopened)

Typical Application Properties

Application Temperature:	Apply above 50°F (10°C)
Odor:	Minimal
Set Time:	10 minutes on active metals (steel). Longer for less active metals.
Cure Time:	24* hours *Cure time is dependent on temperature, and type of metal being bonded
Viscosity:	900 – 1,400 cP
Lot Code Explanation:	**7G**AA2230 **Y=** Last digit of year of manufacture (7= 2017) **G=** Month of Year (1=Jan., B= Feb., C= March, etc.) Example: 7G = July 2017

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Typical Cured Performance Properties			
Color:	Blue	Cured form:	Non-flammable, hard solid.
Service Temperature:	-65°F (-54°C) to 300°F (149°C)	Moisture Resistant:	Yes

Clean-Up:

Uncured: Wipe with damp cloth.
Cured: Remove with a combination of soaking in methylene chloride and mechanical abrasion such as a wire brush.

For disassembly: Shear with hand tools and remove with methylene chloride. In rare instances where hand tools do not work because of excessive engagement length, apply localized heat to nut or bolt to approximately 250°C and dissemble while hot.

Adhesive Properties:	
After 1 hour@ 72°C (22°C)	
Breakaway Torque (ISO 10964): 3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	50 to 150 lb.in. (5.6 to 17 N.m)
Prevail Torque (ISO 10964): 3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	15 to 60 lb.in. (1.7 to 6.8 N.m)
After 1 hour@ 72°C (22°C)	
Breakaway Torque (ISO 10964): 3/8 X 16 steel nuts (grade 2) and bolts (grade 5) 3/8 x 16 cadmium nuts and bolts 3/8 x 16 zinc nuts and bolts M10 black oxide steel nuts and bolts	 70 to 150 lb·in (7.9 to 17 N·m) 10 to 60 lb·in (1.1 to 6.8 N·m) 20 to 60 lb·in (2.3 to 6.8 N·m) 71 to 168 lb·in (8 to 19 N·m)
Prevail Torque (ISO 10964): 3/8 x 16 steel nuts (grade 2) and bolts (grade 5) 3/8 x 16 cadmium nuts and bolts 3/8 x 16 zinc nuts and bolts	 25 to 60 lb·in (2.8 to 6.8 N·m) 4 to 40 lb.in (0.5 to 4.5 N.m) 10 to 40 lb.in (1.1 to 4.5 N.m)
Applicable Specifications: Tested to the requirements of:	▪ Military Specification Mil-S-46163A ▪ ASTM D 5363

Chemical/Solvent Resistance, aged under conditions indicated and tested @ 22ºC

	Temperature	% of initial strength
Environment	**ºF**	**1000 h**
Motor Oil (MIL-L-46152)	257	100
Unleaded gasoline	72	95
Leaded gasoline I	72	100
Brake fluid	72	100
Ethanol	72	95
Acetone	72	85
1,1,1 Trichloroethane	72	90
Water/glycol 50/50	189	70

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DIRECTIONS

Tools Typically Required:
Utility knife, damp cloth.

Safety Precautions:
Keep out of reach of children.

Preparation:
Protect work area. Parts to be sealed must be clean and dry. Shake the product thoroughly before use.
Note: To prevent the product from clogging in the nozzle, avoid touching the bottle tip to the metal surface.

Application:

For Thru Holes:
Apply several drops of the product onto the bolt at the nut engagement area.

For Blind Holes:
Apply several drops of the product down the internal threads to the bottom of the hole.

For Sealing Applications:
Apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free. Force the material into the threads to thoroughly fill the voids. For bigger threads and voids, adjust product amount accordingly and apply a 360° bead of product on the female threads also.

Assemble parts and tighten as required. Sets in approximately 10 minutes and fully cures in 24 hours.

Clean-up
Clean adhesive residue immediately with a damp cloth. Cured product can be removed with a combination of soaking in methylene chloride and mechanical abrasion such as a wire brush.

For disassembly, shear with standard hand tools and remove with methylene chloride. In rare instances where hand tools do not work because of excessive engagement length, apply localized heat to nut or bolt to approximately 482°F (250°C). Disassemble while hot.

STORAGE AND DISPOSAL

Not damaged by freezing. Close the tube tightly after each use. Store product in the unopened container in a dry location. Optimal storage is between 46°F (8°C) to 70°F (21°C).

LABEL PRECAUTIONS

WARNING: Contains methacrylate ester. May cause allergic skin reaction and eye irritation. Avoid eye and skin contact. Avoid breathing vapors. Use only with adequate ventilation.
FIRST AID: For eye contact, flush with water for 15 minutes; call a physician. For skin contact, wash thoroughly with soap and water. If inhaled, move to fresh air. If swallowed, do not induce vomiting. Obtain medical attention. **KEEP OUT OF REACH OF CHILDREN.**

WARNING: Cancer – www.P65Warnings.ca.gov

Refer to the Safety Data Sheet (SDS) for further information

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Henkel recommends purchasers/users should test the products to determine acceptable quality and suitability for the intended use. All adhesive/sealant applications should be tested under simulated or actual end use conditions to ensure the adhesive/sealant meets or exceeds all required project specifications. Since assembly conditions may be critical to adhesive/sealant performance, it is also recommended that testing be performed on specimens assembled under simulated or actual production conditions. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.