

LOCTITE® 190757

March 2025

PRODUCT DESCRIPTION

LOCTITE® 190757 provides the following product characteristics:

Technology	Acrylic
Chemical type	Anaerobic
Appearance (uncured)	Red
Components	One component - requires no mixing
Viscosity	Medium
Cure	Anaerobic
Application	Retaining
Strength	Medium to high

LOCTITE® 190757 is designed for the bonding of cylindrical metal assemblies, including expansion plugs and locking and sealing of threaded fasteners. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. The thixotropic nature of LOCTITE® 190757 reduces the migration of liquid product after application to the substrate.

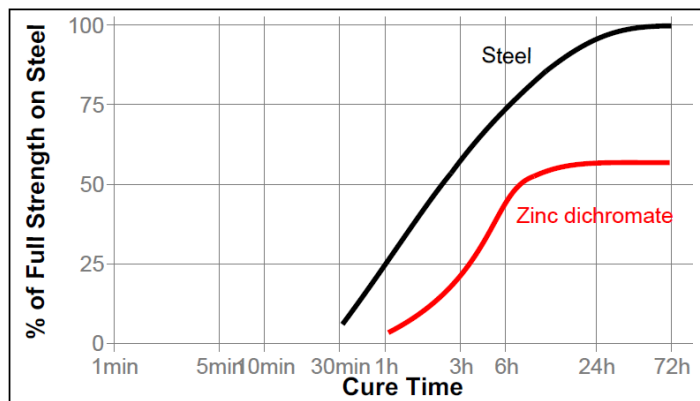
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific gravity @ 25°C	1.1
Viscosity, Brookfield - RVT, 25°C, mPa·s (cP):	
Spindle 3, speed 2.5 rpm	3,000 to 6,000
Spindle 3, speed 20 rpm	1,000 to 2,000
Flash point - see SDS	

TYPICAL CURING PERFORMANCE

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the breakaway strength developed with time on M10 steel nuts and bolts compared to different materials and tested according to ISO 10964.



TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesion properties

After 72 hours @ 22°C

Breakaway torque, ISO 10964:

M10 steel nuts and bolts	N·m	17
	(lb·in)	(150)
M10 zinc dichromate nuts and bolts	N·m	9
	(lb·in)	(80)
M10 black oxide steel nuts and bolts	N·m	21
	(lb·in)	(185)

Compressive shear strength, ISO 10123:

Steel pins and collars	N/mm ²	15
	(psi)	(2,175)

TYPICAL ENVIRONMENTAL RESISTANCE

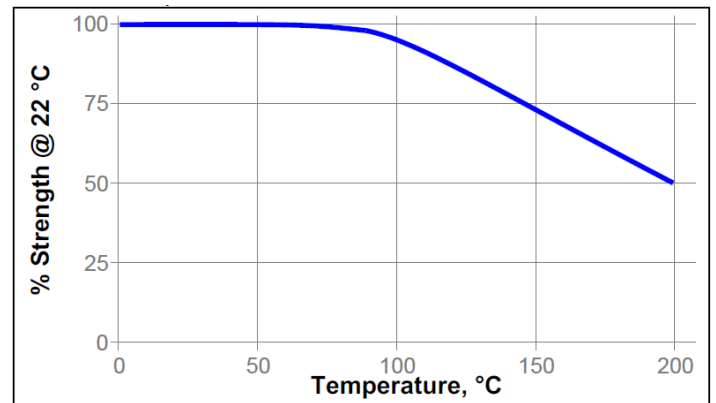
Cured for 72 hours @ 22°C

Breakaway torque, ISO 10964:

M10 steel nuts and bolts (degreased)

Hot strength

Tested at temperature



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22°C.

Environment	°C	% of initial strength	
		40 h	70 h
Motor oil (EO30-CD)	25	NA	95
Distilled water	25	NA	105

GENERAL INFORMATION

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

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

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use**For Assembly**

1. For best results, clean all surfaces (external and internal) with a LOCTITE® cleaning solvent and allow to dry.
2. If the material is an inactive metal or the cure speed is too slow, spray all threads with Activator 7471™ or 7649™ and allow to dry.
3. Shake the product thoroughly before use.
4. To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during application.
5. **For Thru Holes**, apply several drops of the product onto the bolt at the nut engagement area.
6. **For Blind Holes**, apply several drops of the product to the lower third of the internal threads in the blind hole, or the bottom of the blind hole.
7. **For Sealing Applications**, apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free.
8. Assemble and tighten as required.

For disassembly

1. Remove with standard hand tools.
2. Apply localized heat to the assembly to approximately 250°C. Disassemble while hot.
3. Where hand tools do not work because of excessive engagement length or large diameters (over 1"), apply localized heat to approximately 250°C. Disassemble while hot.

For Cleanup

1. Cured product can be removed with a combination of soaking in a LOCTITE® solvent and mechanical abrasion such as a wire brush.

Storage

Store product in an unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal storage: 8 to 21°C. Storage below 8°C or greater than 28°C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel representative.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on the specifications of this product.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

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