Technical Data Sheet

LOCTITE® 294™

December 2008

PRODUCT DESCRIPTION

LOCTITE® 294™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Dimethacrylate ester
Appearance (uncured)	Dark green liquid[LMS]
Fluorescence	Positive under UV light[LMS]
Components	One component - requires no mixing
Viscosity	Low
Cure	Anaerobic
Secondary Cure	Activator
Application	Threadlocking
Strength	Medium to High

LOCTITE® 294™ is designed for the locking and sealing of threaded fasteners. Because of its low viscosity and capillary action, the product wicks between engaged threads and eliminates the need to disassemble prior to application. 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 product also provides good threadlocker performance with oil coated fasteners.

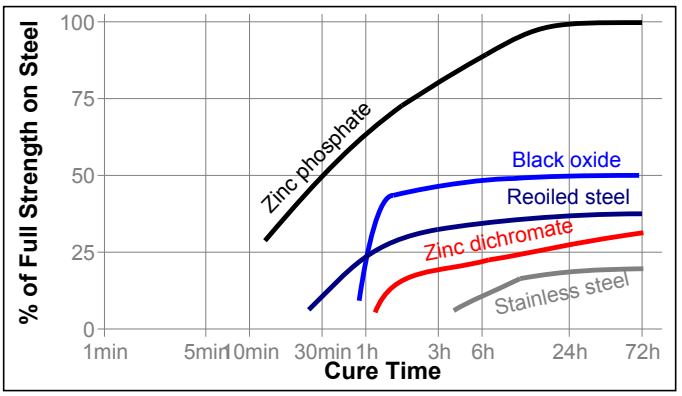
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.13
Flash Point - See SDS	
Viscosity, Brookfield - LVF, 25 °C, mPa·s (cP):	
Spindle 2, speed 50 rpm,	20 to 45[LMS]

TYPICAL CURING PERFORMANCE

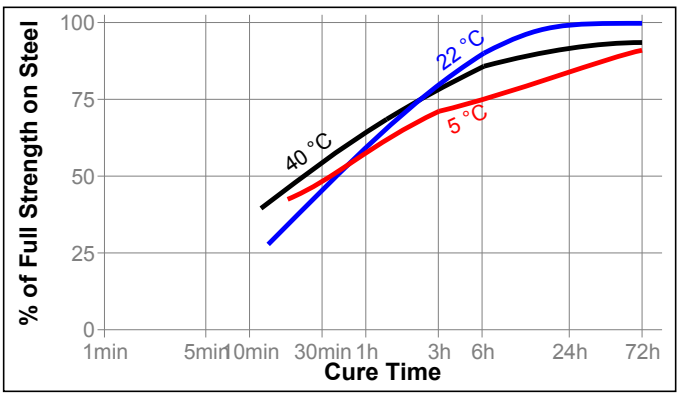
Cure Speed vs. Substrate

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



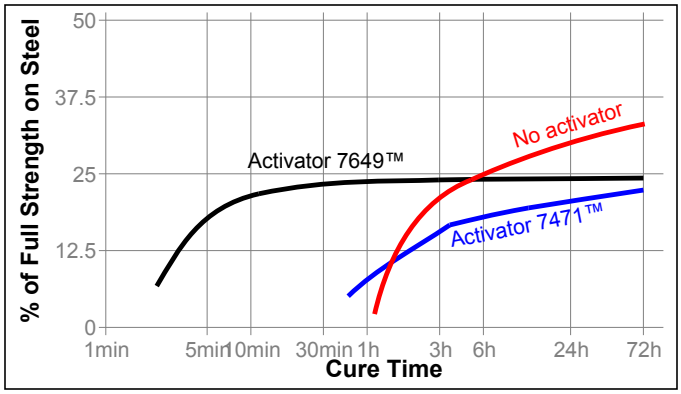
Cure Speed vs. Temperature

The rate of cure will depend on the temperature. The graph below shows the breakaway strength developed with time at different temperatures on M10 zinc phosphate steel nuts & bolts and tested according to ISO 10964.



Cure Speed vs. Activator

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the breakaway strength developed with time on M10 zinc dichromate steel nuts and bolts using Activator 7471™ and 7649™ and tested according to ISO 10964.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.173

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

After 24 hours @ 22 °C

Breakaway Torque, ISO 10964:

M10 zinc nuts and bolts	phosphate steel	N·m (lb.in.)	33 (290)
3/8 x 16 steel nuts (grade 2) and bolts (grade 5)		N·m (lb.in.)	≥13[LMS] (115)

Prevail Torque, ISO 10964:

M10 zinc nuts and bolts	phosphate steel	N·m (lb.in.)	27 (240)
3/8 x 16 steel nuts (grade 2) and bolts (grade 5)		N·m (lb.in.)	≥15[LMS] (130)

Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 zinc nuts and bolts	phosphate steel	N·m (lb.in.)	38 (340)

Max. Prevail Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 zinc nuts and bolts	phosphate steel	N·m (lb.in.)	35 (310)

After 2 hours @ 22 °C

Breakaway Torque, ISO 10964:

3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m (lb.in.)	≥2.5[LMS] (20)

Prevail Torque, ISO 10964:

3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m (lb.in.)	≥1[LMS] (9)

Cured for 24 hours @ 22 °C followed by 72 hours @ 260 °C, tested @ 22 °C

Breakaway Torque, ISO 10964:

3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m (lb.in.)	≥6[LMS] (50)

Prevail Torque, ISO 10964:

3/8 x 16 steel nuts (grade 2) and bolts (grade 5)	N·m (lb.in.)	≥7.5[LMS] (65)

TYPICAL ENVIRONMENTAL RESISTANCE

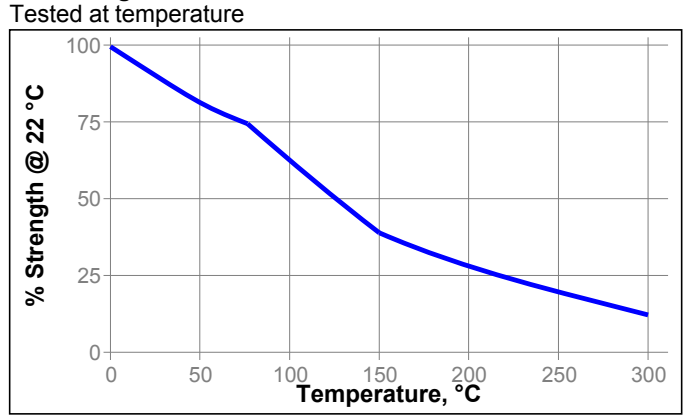
Cured for 72 hours @ 22 °C

Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:

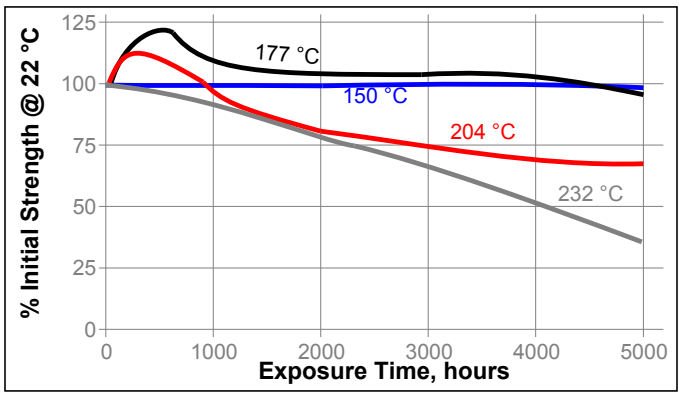
M10 zinc phosphate steel nuts and bolts

Hot Strength

Tested at temperature



Heat Aging
Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance
Aged under conditions indicated and tested @ 22 °C.

		% of initial strength			
Environment	**°C**	**100 h**	**500 h**	**1000 h**	**5000 h**
Motor oil (MIL-L-46152)	125	80	64	63	46
Unleaded gasoline	22	100	100	100	100
Brake fluid	22	100	100	100	96
Water/glycol 50/50	87	80	72	64	56
Acetone	22	98	100	97	93
Ethanol	22	100	100	100	100

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 Pre-assembled Threaded Parts with Thru Holes

1. Prior to assembly, clean all threads (bolt and hole) with a LOCTITE® cleaning solvent and allow to dry.
2. **For Thru Holes**, apply several drops of product at screw and body juncture.
3. Avoid touching the bottle tip to the metal surface.
4. This product is not recommended for pre-assembled threads in a blind hole.

For Porosity Sealing

1. Clean area and apply localized heat to the area to approximately 121°C.
2. Allow to cool to approximately 85°C and apply the product.

For Disassembly

1. Remove with standard hand tools.
2. 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. 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.

Loctite Material Specification[LMS]
LMS dated September 25, 1997. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: 8 °C 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 Corporation 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 Technical Service Center or Customer Service Representative.

Conversions
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Note:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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