

LOCTITE DRI 128324

June 2017

PRODUCT DESCRIPTION

LOCTITE DRI 128324 provides the following product characteristics:

Technology	Polyacrylate
Chemical Type	Polyacrylate aqueous emulsion
Application	Pre-applied (dry film) coating
Components	One-component
Appearance (dry material)	Soft, dry, light blue, pre-applied film

LOCTITE DRI 128324 is pre-applied, aqueous thread sealant with good high temperature, heat ageing and solvent ageing resistance similar to 5061.

The non-curing pre-applied film on a threaded coupling or fitting is dry-to-the-touch and ready for immediate use.

Typical Applications:

Sealing threaded components such as bolts, studs, fillings, etc. against gases, aqueous and non-aqueous fluids up to a temperature of 150°C.

Particularly suitable in situations where threaded parts are required to be ready for immediate use in an adhesive joint in a high volume production environment where it may not be possible to use a liquid product.

LOCTITE DRI 128324 can be used to seal effectively on a wide variety of substrates including metals and plastics.

The sealing of plane faces can also be achieved with this product.

Pressure Retention:

LOCTITE DRI 128324 has excellent pressure retention properties. Tests have shown that joints pressurized up to 150 bar remain sealed.

Test conducted according to DIN 30660, which are applicable to LOCTITE DRI 128324, are outlined below:

	Air Pressure (bar)	Time (min)
½" Zinc coated steel tube	4.4	10
½" Zinc coated steel tube at 100°C cooled and re-tested 6 times	1.1	10
½" Zinc coated steel tube at -10°C	1.1	10
½" Zinc coated steel tube at 130°C	5.0	4320 (72 h)
½" Zinc coated steel tube at 23°C after 130°C for 72h	25.0	10

Torque Tension Ratio- K Value (Lubricity):

The torque tension ratio is a measure of the relationship between the torque input in an assembly and the resulting tension generated in the fastener. It is dependant on the substrates and geometry of the test pieces. The values obtained in any test are very specific and relate only to the conditions at the time of testing. It is therefore a comparative rather than an absolute measure of lubricity.

Substrates: M 10 Stainless Steel Nuts & Bolts
 Input Torque: 40 Nm

	K Value
As received nut and bolt	0.39
Nut and bolt coated with LOCTITE DRI 128324	0.25

Typical Environmental Resistance:

Drying procedure: 30 min at 55 to 70°C

Pressure Retention Against Fluids:

LOCTITE DRI 128324 aged under conditions indicated and tested at 22°C.

Specimens	Temperature (°C)	Fluid	Air Pressure (Bar)	Time (hrs)
M8 ZnBi Nuts & Bolts, Parallel Thread	150	Motor Oil	4	168
M8 ZnBi Nuts & Bolts, Parallel Thread	150	Auto Trans Fluid	4	168
M8 ZnBi Nuts & Bolts, Parallel Thread	150	Gear Oil	4	168
M8 ZnBi Nuts & Bolts, Parallel Thread	120	Water/Glycol	2	168

Chemical / Solvent Resistance of Dried Slabs of Product:

Samples applicable to LOCTITE DRI 128324 aged under conditions indicated and examined at 22°C for any changes in dimensions, weight, appearance or structure.

Solvent	Temperature (°C)	5,000 hrs
Transmission Fluid SAE 80	22	no change
Exxon Paranox 445	22	no change
Brake Fluid ATE	22	no change
Anti-Freeze	22	no change
Water Softening Agent	22	no change
Decalcifier, 10% Formic Acid	22	no change
Antifrogen L	22	no change

Thermal Cycling -40 to 100°C
660 Cycles at 2 hrs per Cycle

Solvent	Temperature (°C)	1,320 hrs
Transmission Fluid SAE 80	-40 to 100	no change
Exxon Paranox 445	-40 to 100	no change
Brake Fluid ATE	-40 to 100	no change
Concentrated Glycol	-40 to 100	no change
Water/Glycol 50:50%	-40 to 100	no change
Antifrogen L	-40 to 100	no change

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

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.

Application:

The product is a one component system consisting of an aqueous based liquid binder applied to fitting/ fasteners and dried at an intermediate convertor company.

From there they are sent to the end user.

Sometimes the convertor and end user are the same company.

Guidelines on recommended mixing and drying conditions are available to convertor companies through the local Technical Service Centre.

The dry coated fitting/ fastener is ready for immediate use and can be assembled to its mating threaded component at any time within its on-part shelf life period.

For best performance the mating surface should be clean and free of grease.

Product is normally pre-applied to the threaded component in sufficient quantity to fill all engaged threads by agreement between the converter and the end user.

This product performs best in thin bond gaps, (0.05 mm).

Very large thread sizes may create large gaps which will affect sealing performance and function should be verified.

STORAGE / HANDLING

Coated fasteners shall be ideally stored in a cool, dry location at a temperature between 10°C-21°C.

The on-part shelf-life period of a coated component is 24 months based upon date of application of coating.

For further specific shelf-life information, contact your local Technical Service Centre.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazards identification

Transport information

Regulatory information

ADDITIONAL INFORMATION

Disclaimer

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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