



LOCTITE® 277

June 2004

PRODUCT DESCRIPTION

LOCTITE® 277 provides the following product characteristics:

Technology	Acrylic
Chemical Type	Dimethacrylate ester
Appearance (uncured)	Red liquid ^{LMS}
Fluorescence	Positive under UV light ^{LMS}
Components	One component - requires no mixing
Viscosity	Medium
Cure	Anaerobic
Secondary Cure	Activator
Application	Threadlocking
Strength	High

LOCTITE® 277 is designed for the permanent 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. Typical applications include the locking and sealing of large bolts and studs (M25 and larger).

Mil-S-46163A

LOCTITE® 277 is tested to the lot requirements of Military Specification Mil-S-46163A.

ASTM D5363

Each lot of adhesive produced in North America is tested to the general requirements defined in paragraphs 5.1.1 and 5.1.2 and to the Detail Requirements defined in section 5.2

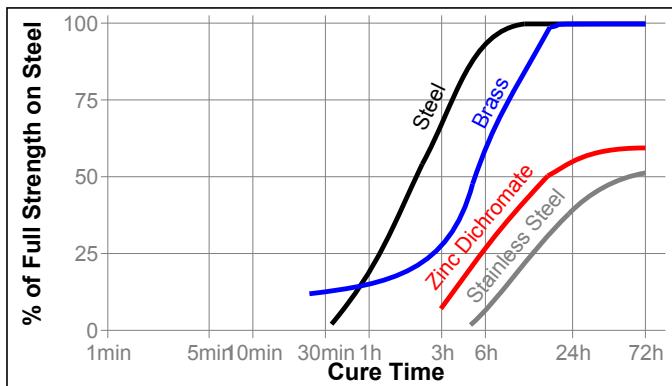
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.12
 Flash Point - See MSDS
 Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):
 Spindle 4, speed 20 rpm 6,000 to 8,000^{LMS}

TYPICAL CURING PERFORMANCE

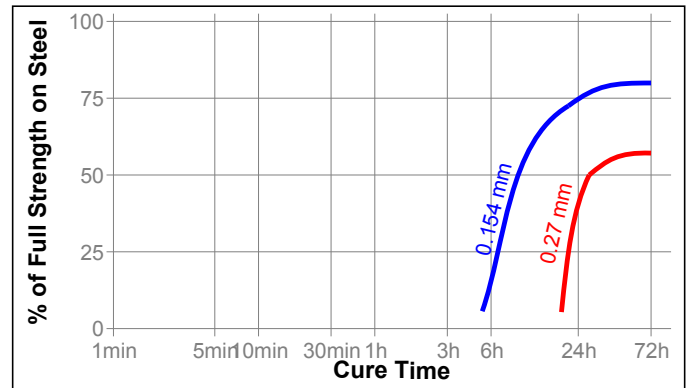
Cure Speed vs. Substrate

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



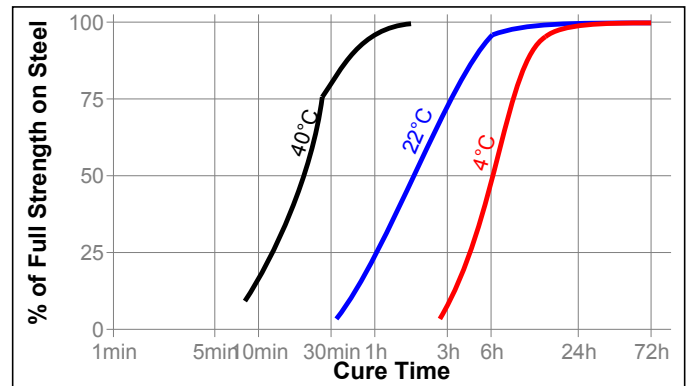
Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. Gaps in threaded fasteners depends on thread type, quality and size. The following graph shows shear strength developed with time on steel pins and collars at different controlled gaps and tested according to ISO 10123.



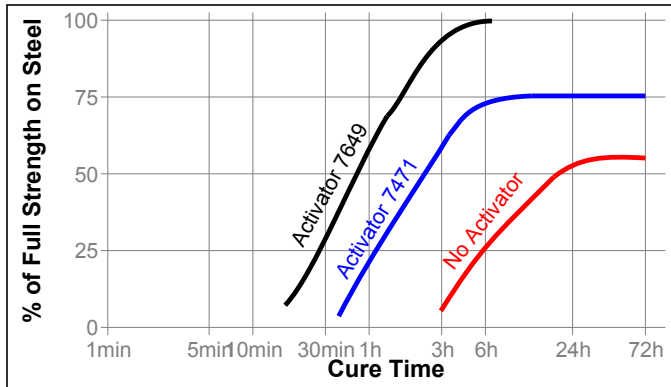
Cure Speed vs. Temperature

The rate of cure will depend on the temperature. The graph below shows the breakaway strength developed with time at different temperatures on M10 steel nuts and 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 breakaway strength developed with time using Activator 7471 and 7649 on M10 zinc dichromate steel nuts and bolts and tested according to ISO 10964.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Coefficient of Thermal Expansion, ASTM D 696, K ⁻¹	80×10 ⁻⁶
Coefficient of Thermal Conductivity, ASTM C 177, W/(m·K)	0.10
Specific Heat, kJ/(kg·K)	0.30

TYPICAL PERFORMANCE OF CURED MATERIAL

After 24 hours @ 22 °C

Breakaway Torque, ISO 10964:

M10 steel nuts and bolts	N·m	32
	(lb.in.)	(280)

Prevail Torque, ISO 10964:

M10 steel nuts and bolts	N·m	32
	(lb.in.)	(280)

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

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

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

M10 steel nuts and bolts	N·m	40
	(lb.in.)	(350)

Compressive Shear Strength, ISO 10123:

Steel pins and collars	N/mm ²	≥9 ^{LMS}
	(psi)	(≥1,300)

TYPICAL ENVIRONMENTAL RESISTANCE

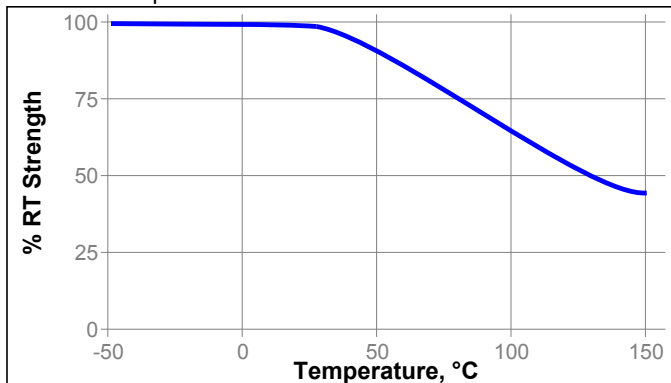
Cured for 1 week @ 22 °C

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

M10 zinc phosphate steel nuts and bolts

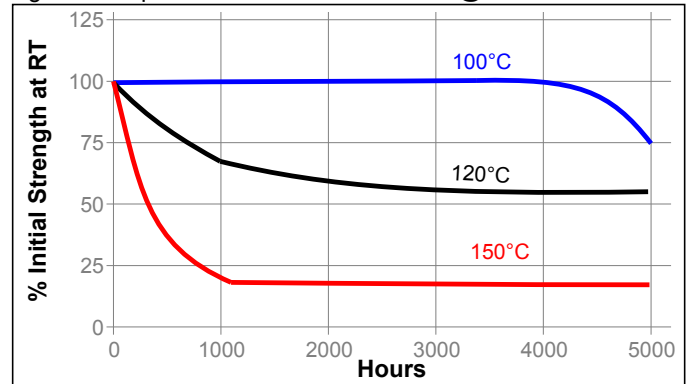
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength		
		100 hr	500 hr	1000 hr
Motor Oil	125	100	100	100
Unleaded Gasoline	22	100	100	100
Brake fluid	22	100	100	100
Water Glycol 50/50	87	90	90	90
Acetone	22	95	95	95
Ethanol	22	95	95	95
Sodium Hydroxide, 10%	40	100	100	70
Hydrochloric Acid, 10%	40	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 Material Safety Data Sheet (MSDS).

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

- For best results, clean all surfaces (external and internal) with a Loctite cleaning solvent and allow to dry.
- If the material is an inactive metal or the cure speed is slow, spray all threads with Activator 7471 or 7649 and allow to dry.
- To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during 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.

6. **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.
7. Assemble and tighten as required.

For Disassembly

1. 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 1, 1995. 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 Loctite 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
 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·mm x 0.142 = oz·in
 mPa·s = cP

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

LOCTITE is a trademark of Henkel Corporation

Reference 1.1