



# TECHNICAL DATA SHEET



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## 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 when confined in the 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 such as bolts on small engines, swing sets and furniture.

## NOT RECOMMENDED FOR:

- Use on plastic parts, particularly thermoplastic materials where stress cracking of the plastic could result.
- Use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

## 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

Item #	Package	Size
209728	Carded Tube	0.20 fl. oz.

## 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**

Contains methacrylate ester. Avoid eye and skin contact. For eye contact, flush with water for 15 minutes; call a physician. For skin contact, wash thoroughly with soap and water. If swallowed, do not induce vomiting. Obtain medical attention. **KEEP OUT OF THE REACH OF CHILDREN.**

**Refer to the Material Safety Data Sheet (MSDS) 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. Purchasers should test the products to determine acceptable quality and suitability for their own intended use. 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.

**TECHNICAL DATA**

Typical Uncured Physical Properties		Typical Application Properties	
<u>Color:</u>	Blue	<u>Application Temperature:</u>	Apply above 50°F (10°C)
<u>Appearance:</u>	Liquid	<u>Odor:</u>	Minimal
<u>Base:</u>	Methacrylate ester	<u>Set Time:</u>	10 minutes
<u>Specific Gravity:</u>	1.1	<u>Cure Time:</u>	24 hours
<u>Viscosity:</u>	1200 cps @ 20 rpm		
<u>Flashpoint:</u>	> 200°F (93°C)		

Shelf Life: 24 months from date of manufacture  
(unopened)

VOC Content: < 50 g/L (4.48% by weight)

Lot Code Explanation: For example:

**7GAC98873**

(Lot code stamped on crimped end of tube)  
7 = Last Digit in the Year of Manufacture  
7 = 2007  
(i.e. 7 = 2007, 8 = 2008, 9 = 2009, etc)

G = Month within Year of Manufacture  
G = 7<sup>th</sup> Letter of the Alphabet  
G = July  
(i.e. A = Jan, B = Feb, C = March, etc)

### Typical Cured Performance Properties

Color: Blue

Service Temperature: -65°F (-54°C) to 300°F (149°C)

Cured form: Non-flammable, hard solid

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.

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 24 hours @ 72°C (22°C):

Breakaway Torque (ISO 10964):  
3/8 X 16 steel nuts (grade 2) and bolts (grade 5) 70 to 150 lb-in (7.9 to 17 N-m)  
3/8 x 16 cadmium nuts and bolts 10 to 60 lb-in (1.1 to 6.8 N-m)  
3/8 x 16 zinc nuts and bolts 20 to 60 lb-in (2.3 to 6.8 N-m)  
M10 black oxide steel nuts and bolts 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) 25 to 60 lb-in (2.8 to 6.8 N-m)  
3/8 x 16 cadmium nuts and bolts 4 to 40 lb.in (0.5 to 4.5 N.m)  
3/8 x 16 zinc nuts and bolts 10 to 40 lb.in (1.1 to 4.5 N.m)

Specifications:

Tested to the requirements of:

- Military Specification Mil-S-46163A
- ASTM D 5363