



# LOCTITE® 571™

January 2007

## PRODUCT DESCRIPTION

LOCTITE® 571™ provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Methacrylate ester
<b>Appearance (uncured)</b>	Brown liquid <sup>LMS</sup>
<b>Fluorescence</b>	Positive under UV light <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Viscosity</b>	Medium
<b>Cure</b>	Anaerobic
<b>Secondary Cure</b>	Activator
<b>Application</b>	Thread sealing
<b>Strength</b>	Medium

LOCTITE® 571™ is designed for the locking and sealing of metal tapered threads and fittings. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration.

### Mil-S-22473E

LOCTITE® 571™ is tested to the lot requirements of Military Specification Mil-S-22473E.

### 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	1.1
Flash Point - See MSDS	
Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):	
Spindle 3, speed 20 rpm	1,000 to 10,000 <sup>LMS</sup>

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K 0.1	
-1	
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Specific Heat, kJ/(kg·K)	0.3

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

After 24 hours @ 22 °C

Prevail Torque, ISO 10964:

3/8 x 24 steel nuts (grade 2) and bolts (grade 2)	N·m (lb.in.)	1.1 to 2.8 <sup>LMS</sup> (9.7 to 24.8)
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After 6 hours @ 22 °C

Prevail Torque, ISO 10964:

3/8 x 24 steel nuts (grade 2) and bolts (grade 2)	N·m (lb.in.)	0.6 to 2.8 <sup>LMS</sup> (5.3 to 24.8)
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## TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 24 hours @ 22 °C

Breakaway Torque, ISO 10964:

3/8 x 24 steel nuts (grade 2) and bolts (grade 2) (degreased)

## Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength 720 h
Motor oil (MIL-L-46152)	87	100
Unleaded gasoline	87	100
Phosphate ester	87	100
<b>Processing Temperature</b>	87	100
Air reference	87	100
Acetone	87	100
Distilled water	87	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

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 with Activator 7471™ or 7649™ and allow to dry.
3. 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.

- Using accepted trade practices, assemble and wrench tighten fittings until proper alignment is obtained.
- Properly tightened fittings will seal instantly to moderate pressures. For maximum pressure resistance and solvent resistance allow the product to cure a minimum of 24 hours.

#### For Disassembly

- Remove with standard hand tools.
- 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

- 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<sup>LMS</sup>

LMS dated August 23, 1999. 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

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

#### Note

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