Technical Data Sheet

# LOCTITE® 5772™

June 2006

## PRODUCT DESCRIPTION

LOCTITE® 5772™ provides the following product characteristics:

| | |
|---|---|
| **Technology** | Acrylic |
| Chemical Type | Dimethacrylate ester |
| Appearance (uncured) | Yellow liquid[LMS] |
| Fluorescence | Positive under UV light[LMS] |
| Components | One component - requires no mixing |
| Viscosity | Medium, thixotropic |
| **Cure** | Anaerobic |
| Secondary Cure | Activator |
| **Application** | Thread sealing |
| Strength | Medium |

LOCTITE® 5772™ is designed for the locking and sealing of metal threaded pipes and fittings. Particularly suitable for use on stainless steel without the need for surface activation. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. This product has a low halogen and sulphur content and was especially developed for use on sensitive metals, like titanium, used in the nuclear industry. The thixotropic nature of LOCTITE® 5772™ reduces the migration of liquid product after application to the substrate.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

| | |
|---|---|
| Specific Gravity @ 25 °C | 1.09 |
| Flash Point - See SDS | |
| Viscosity @ 25°C, mPa·s (cP): | |
| Haake cone & plate: | |
| PK100, PK1, 2° @ 36 S-1 | 3,000 to 12,000[LMS] |

### Chemical Purity

| | |
|---|---|
| Chlorine & Fluorine Content, ppm | ≤200[LMS] |
| Sulfur Content, ppm | ≤200[LMS] |

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

Cured for 1 hour @ 22 °C

Breakaway Torque, ISO 10964:

| | | |
|---|---|---|
| M10 stainless steel nuts and bolts | N·m (lb.in.) | 1.0 (8.8) |

Prevail Torque, ISO 10964:

| | | |
|---|---|---|
| M10 stainless steel nuts and bolts | N·m (lb.in.) | 0.5 (4.4) |

Cured for 24 hours @ 22 °C

Breakaway Torque, ISO 10964:

| | | |
|---|---|---|
| M10 black oxide steel nuts and bolts | N·m (lb.in.) | 17 (150) |
| M10 stainless steel nuts and bolts | N·m (lb.in.) | 6.4 (56.5) |

Prevail Torque, ISO 10964:

| | | |
|---|---|---|
| M10 black oxide steel nuts and bolts | N·m (lb.in.) | 6 (53) |
| M10 stainless steel nuts and bolts | N·m (lb.in.) | 3.4 (30) |

Compressive Shear Strength, ISO 10123:

| | | |
|---|---|---|
| Steel pins and collars | N/mm² (psi) | ≥1.2[LMS] (≥170) |

## 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 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.
4. Using compliant practices, assemble and wrench tighten fittings in accordance with manufacturers recommendations.

5. 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**

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

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 June 19, 1996. 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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