



LOCTITE[®] 5400[™]

September 2011

PRODUCT DESCRIPTION

LOCTITE[®] 5400[™] provides the following product characteristics:

Technology	Acrylic
Chemical Type	Dimethacrylate ester
Appearance (uncured)	Yellow to dark orange paste ^{LMS}
Fluorescence	Positive under UV light ^{LMS}
Components	One component - requires no mixing
Viscosity	High, thixotropic
Cure	Anaerobic
Secondary Cure	Activator
Application	Thread sealing
Strength	Medium

LOCTITE[®] 5400[™] is designed for the locking and sealing of metal threaded pipes 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. The thixotropic nature of LOCTITE[®] 5400[™] reduces the migration of liquid product after application to the substrate.

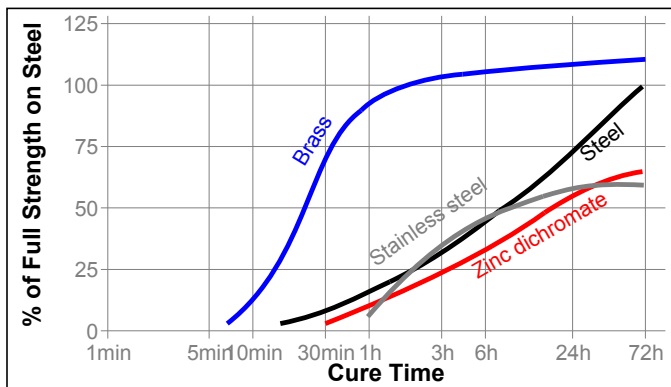
TYPICAL PROPERTIES OF UNCURED MATERIAL

- Specific Gravity @ 25 °C: 1.1
- Flash Point - See MSDS
- Viscosity, Cone & Plate, , mPa·s (cP):
Cone 35/2°Ti @ shear rate 20 s⁻¹: 5,000 to 20,000^{LMS}

TYPICAL CURING PERFORMANCE

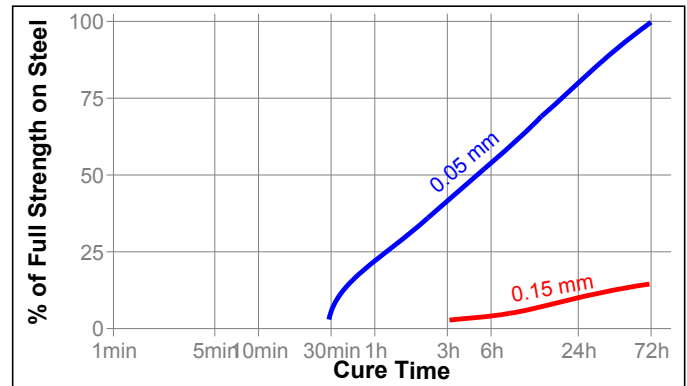
Cure Speed vs. Substrate

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.



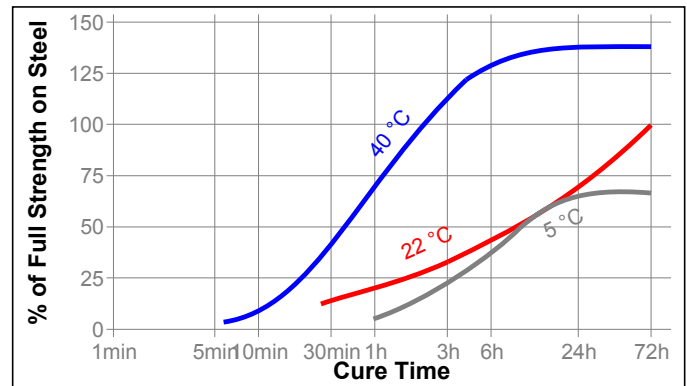
Cure Speed vs. Bond Gap

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.



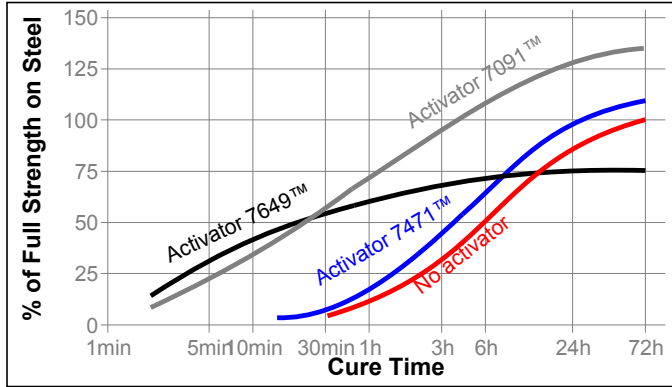
Cure Speed vs. Temperature

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 the breakaway strength developed with time on M10 zinc dichromate steel nuts and bolts using Activator 7471™ and 7649™ and tested according to ISO 10964.

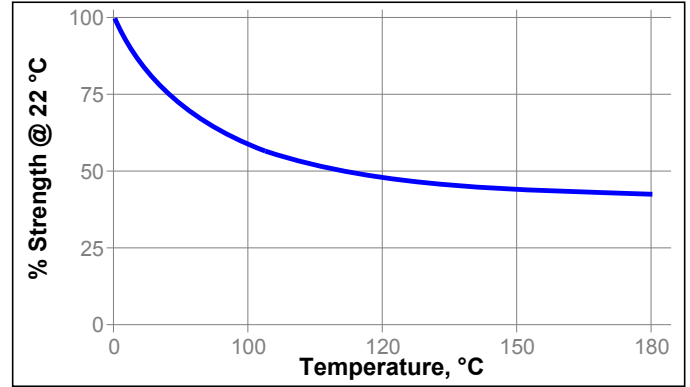


TYPICAL ENVIRONMENTAL RESISTANCE

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



TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

After 24 hours @ 22 °C

Breakaway Torque, ISO 10964, Unseated:

M10 X 1.5 black oxide bolts and steel nuts	N·m	19
	(lb.in.)	(170)
M10 brass nuts and bolts	N·m	28
	(lb.in.)	(250)
M10 zinc dichromate nuts and bolts	N·m	15
	(lb.in.)	(130)
M10 stainless steel nuts and bolts	N·m	15
	(lb.in.)	(130)

Prevail Torque @ 180°, ISO 10964, Unseated:

M10 X 1.5 black oxide bolts and steel nuts	N·m	3
	(lb.in.)	(25)
M10 brass nuts and bolts	N·m	4
	(lb.in.)	(35)
M10 zinc dichromate nuts and bolts	N·m	4
	(lb.in.)	(35)
M10 stainless steel nuts and bolts	N·m	3
	(lb.in.)	(25)

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

M10 black oxide bolts and steel nuts	N·m	25
	(lb.in.)	(220)

Prevail Torque @ 180°, ISO 10964, Pre-torqued to 5 N·m:

M10 black oxide bolts and steel nuts	N·m	4
	(lb.in.)	(35)

Compressive Shear Strength, ISO 10123:

Steel pins and collars (degreased)	N/mm ²	5 ^{LMS}
	(psi)	(725)

After 7 days @ 22 °C

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

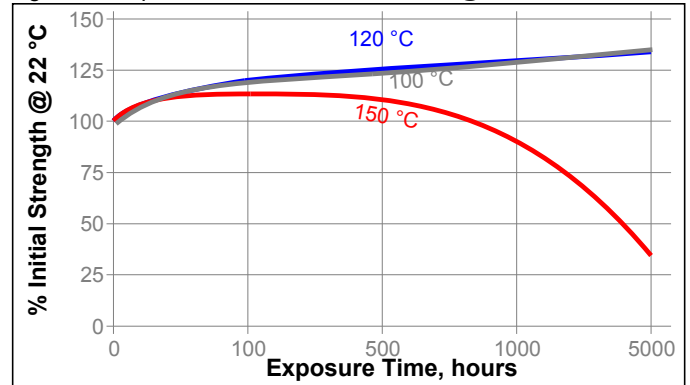
M10 stainless steel nuts and bolts	N·m	16
	(lb.in.)	(140)

Prevail Torque @ 180°, ISO 10964, Pre-torqued to 5 N·m:

M10 stainless steel nuts and bolts	N·m	2
	(lb.in.)	(20)

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 h	500 h	1000 h	5000 h
Motor oil	125	105	100	95	75
Unleaded Petrol	22	105	110	115	80
Brake fluid	22	95	105	105	100
Ethanol	22	95	95	100	90
Acetone	22	90	70	75	115
Antifreeze	87	105	110	105	105
E85 Ethanol fuel	22	90	95	90	80
B100 Bio-Diesel	22	95	100	105	110

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

M10 Stainless steel nuts and bolts

Environment	°C	% of initial strength			
		100 h	500 h	1000 h	5000 h
Sodium Hydroxide, 20%	22	90	100	95	100
Phosphoric Acid, 10%	22	110	95	80	105
DEF (Adblue)	22	95	100	100	90

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.
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 April 11, 2011. 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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Reference 0.2