

LOCTITE[®] 567[™] OLD

(TDS for old formulation of Loctite[®] 567[™]) April 2015

PRODUCT DESCRIPTION

LOCTITE[®] 567[™] OLD provides the following product characteristics:

Technology	Acrylic
Chemical Type	Methacrylate ester
Appearance (uncured)	Smooth, creamy, off-white paste ^{LMS}
Components	One component - requires no mixing
Viscosity	High
Cure	Anaerobic
Secondary Cure	Activator
Application	Thread sealing
Strength	Low

This Technical Data Sheet is valid for LOCTITE[®] 567[™] OLD manufactured prior to the dates outlined in the "Manufacturing Date Reference" section.

LOCTITE[®] 567[™] OLD 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. The high lubricating properties of this compound prevent galling on stainless steel, aluminum and all other metal pipe threads and fittings. LOCTITE[®] 567[™] OLD is recommended for industrial applications in the chemical processing, petroleum refining, pulp/paper, waste treatment, textile, utilities/power generation, marine, automotive, industrial equipment, gas compression and distribution industries. It is also recommended for industrial plant fluid power systems.

UL Classification

Classified by Underwriters Laboratories Inc.[®] MH8007 - Fire hazard is small. No flash point in liquid state. Ignition temperature 455 °C. For use in devices handling gasoline, petroleum oils, natural gas (pressure not over 300 PSIG), butane and propane not exceeding 2 in. pipe size. **Note:** This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

ULC Classification

Classified by Underwriters Laboratories of Canada Inc. MH27131 - An anaerobic material which contains a lubricant and sets to form a tight seal and maintain a controlled locking strength. For use in joining threaded pipe connections or other closely fitting metal parts in devices handling natural gas and methane, gasoline and petroleum oils, and propane and butane at pressures not exceeding 13,790 kPa. Ignition temperature greater than 460 °C. Classed less than 10 below paraffin oil with respect to fire hazard. **Note:** This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

Approved by the Australian Gas Association Certificate number 3207 Class III rated working pressure 2000 kPa, working temperature -10 to 205°C. **Note:** This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

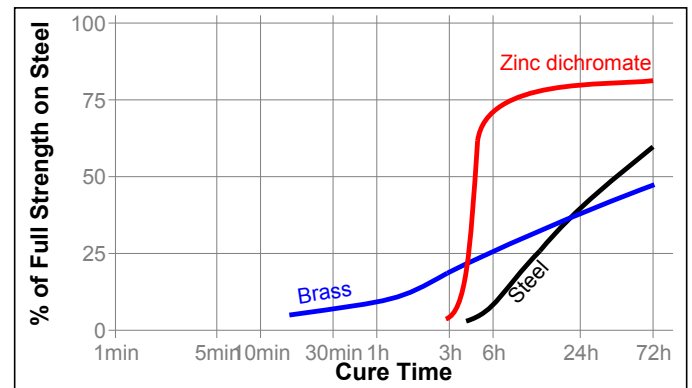
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.1
 Flash Point - See SDS
 Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):
 Spindle 7., speed 2 rpm 280,000 to 800,000^{LMS}

TYPICAL CURING PERFORMANCE

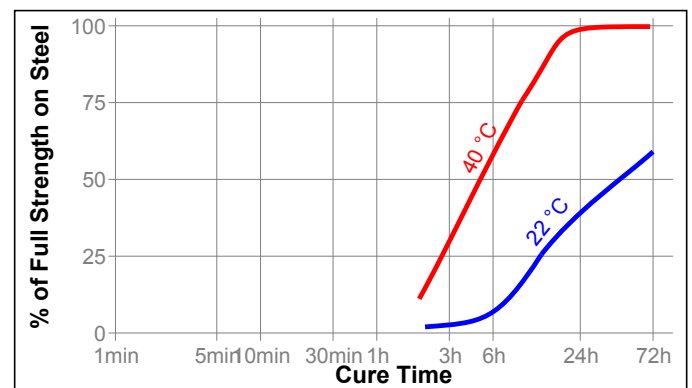
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the breakaway strength developed with time on 3/8 NPT steel pipe tees and plugs compared to different materials and tested according to ASTM D6396.



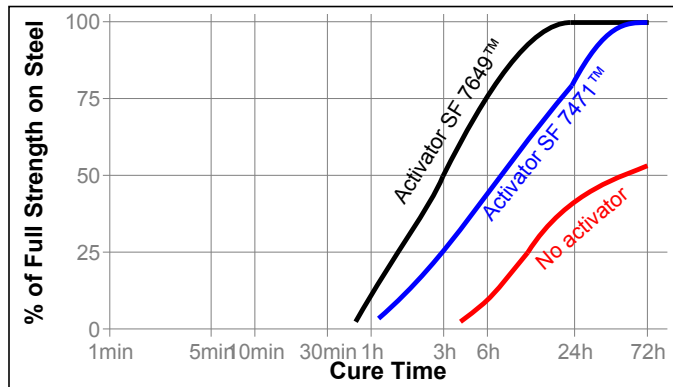
Cure Speed vs. Temperature

The rate of cure will depend on the temperature. The graph below shows the breakaway strength developed with time at different temperatures on 3/8 NPT steel pipe tees and plugs and tested according to ASTM D6396.



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 3/8 NPT steel pipe tees and plugs using Activator SF 7471™ and SF 7649™ and tested according to ASTM D6396.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K ⁻¹	80×10 ⁻⁶
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

Breakaway Torque, ISO 10964:			
3/8 x 24 steel nuts (grade 2) and bolts (grade 2)	N·m	≥1.7 ^{LMS}	(lb.in.) (≥15)

After 4 hours @ 22 °C

Breakaway Torque, ISO 10964:			
3/8 x 24 steel nuts (grade 2) and bolts (grade 2)	N·m	≥0.3 ^{LMS}	(lb.in.) (≥2.6)

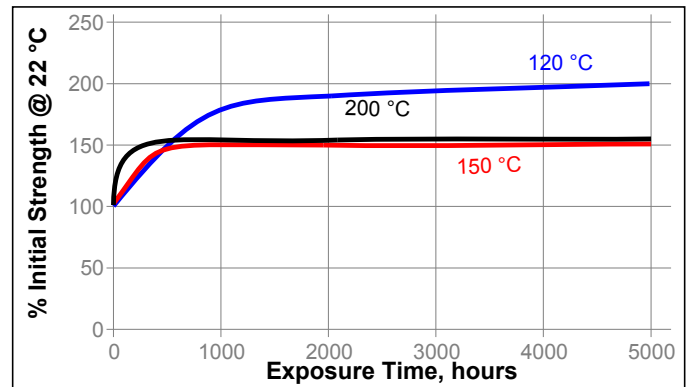
TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 72 hours @ 22 °C

Breakloose Torque, ISO 10964, Pre-torqued to 1.1 N·m:	
M10 steel fasteners (degreased)	

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
Motor oil (MIL-L-46152)	40	100	100	100
Gasoline	22	90	80	80
Brake fluid	22	90	90	80
Ethanol	22	85	85	85
Acetone	22	75	70	60
1,1,1 Trichloroethane	22	90	90	85
Water/glycol 50/50	87	100	75	75
E85 Ethanol fuel	22	N/A	85	130
B100 Bio-Diesel	22	N/A	105	90
DEF (AdBlue®)	22	N/A	130	120

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 LOCTITE® SF 7471™ or LOCTITE® SF 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 compliant practices, assemble and wrench tighten fittings in accordance with manufacturers recommendations.
- 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 (480F). 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^{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 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.

Manufacturing Date Reference

This Technical Data Sheet is valid for LOCTITE® 567™ OLD manufactured prior to the dates below:

<u>Made in:</u>	<u>Last manufacturing date:</u>
U.S.A.	May 2016
China	May 2016
Brazil	April 2016

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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Reference 1.5