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Technical Data Sheet
Product 601

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PRODUCT DESCRIPTION

LOCTITE® Product 601 is a single component anaerobic adhesive which cures rapidly between metal surfaces where air is excluded.

TYPICAL APPLICATIONS

Used to bond cylindrical fitting parts, particularly where low viscosity is required.

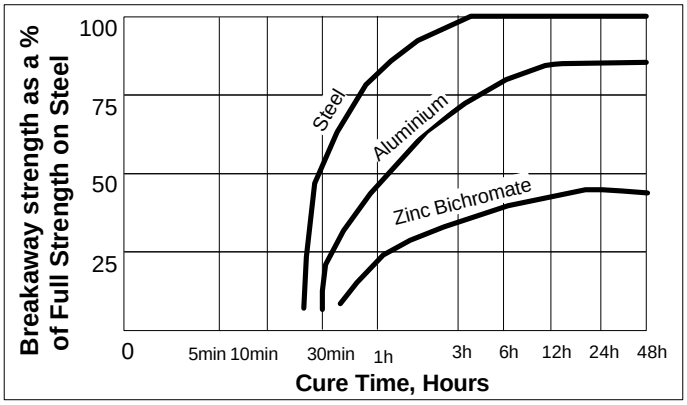
PROPERTIES OF UNCURED MATERIAL

	Typical Value	Range
Chemical Type	Dimethacrylate Ester	
Appearance	Green, fluorescent	
Specific Gravity @ 25°C	1.1	
Viscosity @ 25°C, mPa.s		
Brookfield RVT -		
Spindle 1 @ 20.0 rpm		100 to 150
DIN 54453, mPa.s		
D = 277 1/S		100 to 150
Flash Point (COC), °C	>100	
Vapour pressure, mbar	<5	
Shelf life @ 5 to 28°C, months	12	

TYPICAL CURING PERFORMANCE

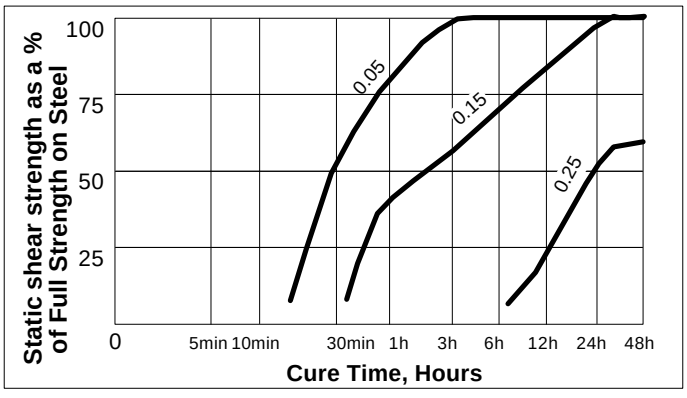
Cure speed vs. substrate

Figure 1 shows the rate of cure on pins and collars made from different materials. The static shear strength was determined according to MIL-S-46082.



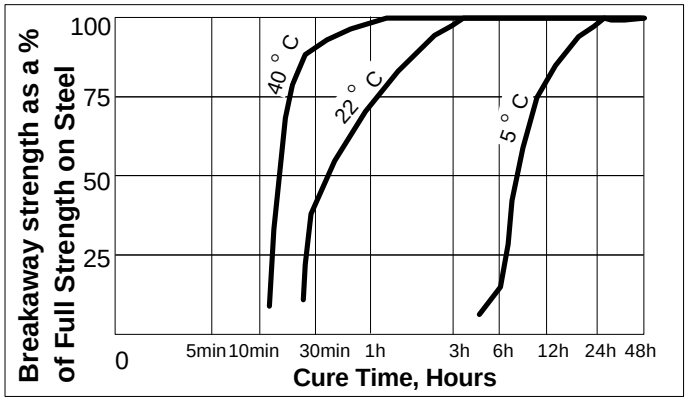
Cure speed vs. bond gap

Figure 2 shows the rate of cure through different gaps. These tests were made on steel pins and collars with specified gaps. Test procedure in accordance with MIL-R-46082. The development of static shear provided a measurement of the rate of cure.



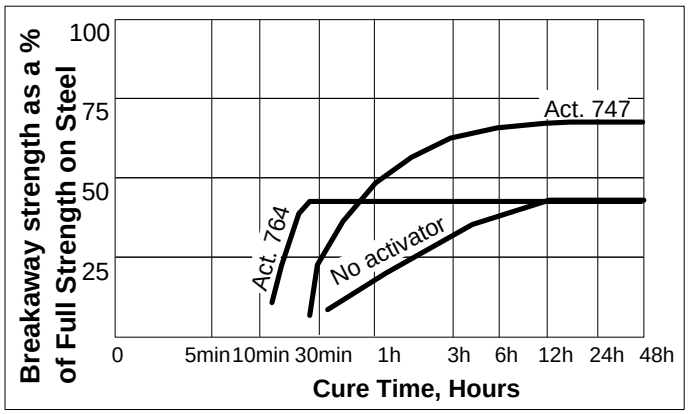
Cure speed vs. ambient temperature

Figure 3 shows how the rate of cure varies with ambient temperature. Tests were made on pins and collars according to MIL-R-46082.



Cure speed vs. activator

Where cure speed is unacceptably long (because of substrate, temperature or gap) performance may be improved by treating the surface with LOCTITE ACTIVATOR 764 or ACTIVATOR 747. This effect is indicated in figure 4. Tests were carried out according to MIL-R-46082 on zinc bichromate steel pins and collars.



PHYSICAL PROPERTIES OF CURED MATERIAL AND OPERATING PARAMETERS

Time to achieve full strength on steel @ 22°C (0.05mm), hours:	12
Coefficient of thermal expansion, ASTM D696, K^{-1}	100 x 10^{-6}
Coefficient of thermal conductivity, ASTM C177, W.m-1 K-1	0.1
Specific Heat, $kJkg^{-1} K^{-1}$	0.3
Recommended gap, mm	0.05
Maximum gap, mm	0.15

PERFORMANCE OF CURED MATERIAL

(After 24 hours at 22°C)

Static shear strength, MIL-R-46082, N/mm^2	18 to 30
Static shear strength, DIN 54452, N/mm^2	16 to 30
Breakaway torque, MIL-S-46163, N.m:	15 to 40
Prevail torque, MIL-S-46163, N.m	25 to 50
Breakloose torque, DIN 54454, N.m:	40 to 60
Maximum prevail torque, DIN 54454, N.m:	40 to 60

N.B. Ranges are based on mean ± 2 σ values

NOT FOR PRODUCT SPECIFICATIONS
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.
PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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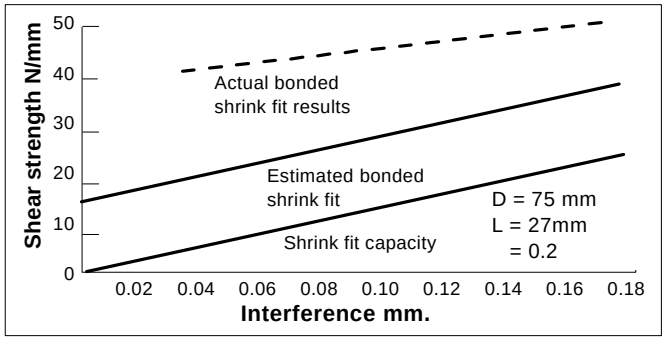
COMBINATION ADHESIVE/INTERFERENCE FITS

The strength of a press or shrink fit can be considerably increased by incorporating a retaining adhesive. An estimate of strength can be obtained by combining the frictional force due to the interference fit and the adhesive strength with appropriate correction factors. A typical strength improvement for a bonded shrink fit is shown in the graph.

Shear strength vs interference for bonded and unbonded shrink fits



DYNAMIC FATIGUE RESISTANCE

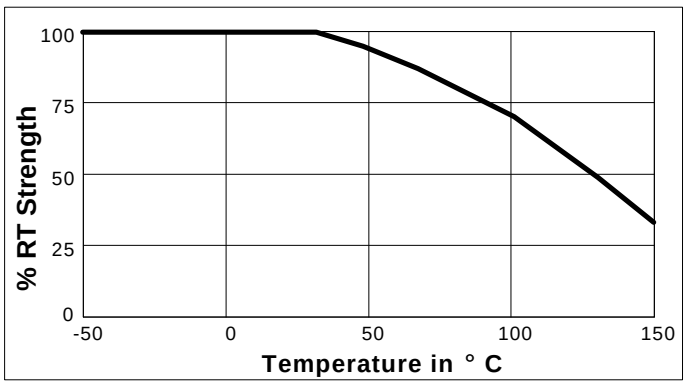
Resistance to dynamic fatigue loading will depend on a number of factors, including design of joint, type of loading and temperature. Extensive studies show the following factors can be used to determine endurance limit as a percent of ultimate static strength.

Type of loading	Bonded slip fit	Bonded press fit	Bonded shrink fit
Axial loading	10%	10%	10%
Torsional loading	30%	35%	35%

TYPICAL ENVIRONMENTAL RESISTANCE

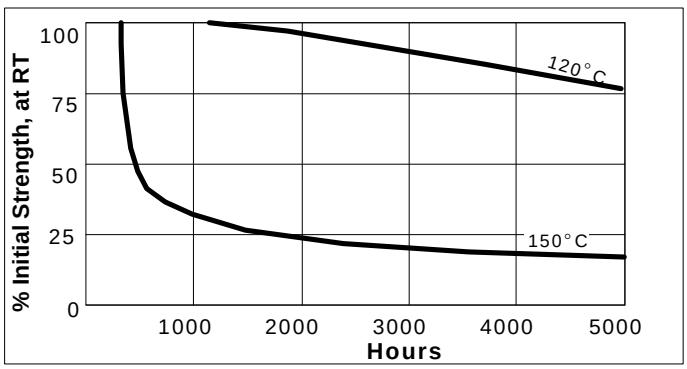
Hot strength

Strength Test procedure MIL-R-46082.
Substrate Steel pins and collars.
Cure procedure 1 week at 22°C



Heat ageing

Strength Test procedure MIL-R-46082.
Substrate Steel pins and collars.
Cure procedure 1 week at 22°C



Chemical/solvent Resistance

Strength Test procedure DIN 54452.
Substrate Steel pins and collars.
Cure procedure 1 week at 22°C

Solvent	Temp.	% initial strength retained at 100hr	500hr	1000hr
Motor oil (MIL-L-46152	125°C	100	100	100
Unleaded petrol	22°C	100	100	100
Leaded petrol	22°C	100	100	100
Brake fluid	22°C	100	100	100
Ethanol	22°C	100	100	100
Acetone	22°C	100	100	85
1.1.1. trichloroethane	22°C	100	100	100
Water/glycol	87°C	100	85	80

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 oxidising 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 best performance surfaces should be clean and free of grease. Product should be applied to the bolt in sufficient quantity to fill all engaged threads. This product performs best in thin bond gaps, (0.05mm). Very large thread sizes may create large gaps which will affect cure speed and strength. This product is designed to give controlled friction, (torque/tension ratio), during assembly. In critical tightening applications this ratio should be confirmed.

Storage

Product shall be ideally stored in a cool, dry location, in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labelled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to it's original container. For further specific shelf life information contact your local Technical Service Centre.

Data Ranges

The data contained herein may be reported as a typical value and/or range (based on the mean value ±2 standard deviations). Values are based on actual test data and are verified on a periodic basis.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a licence under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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