



1001 Trout Brook Crossing
 Rocky Hill, CT 06067-3910
 Telephone: (860) 571-5100
 FAX: (860) 571-5465

Product Description Sheet

Product 204

Industrial Products, April 2000

PRODUCT DESCRIPTION

Dri-Loc Threadlocker is a dry-to-the-touch preapplied film for threaded fasteners. It remains inert on the fastener until assembly of the threads releases a quick curing resin. The resin fills all the voids in the threads and cures to securely lock and seal the assembly.

TYPICAL APPLICATIONS

Dri-Loc 204 prevents loosening through vibration to provide locking and sealing of threaded assemblies including:

- Locking
 - Carburetor screws
 - Transmission nuts
 - Head bolts
 - Truck axle bolts
 - Tower bolts
- Sealing
 - Transmission bolts
 - Pipe plugs and fittings

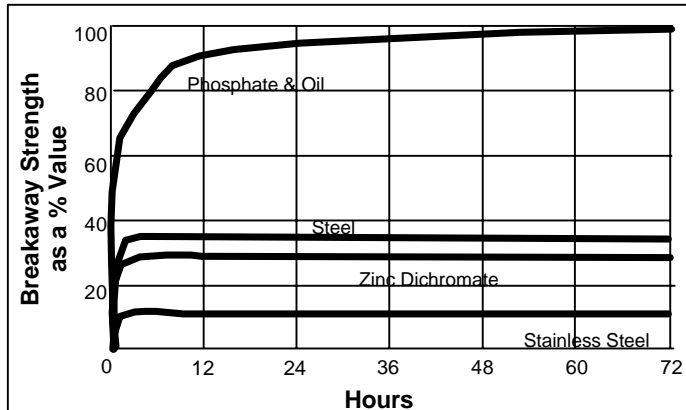
PROPERTIES OF UNCURED MATERIAL

Chemical Type	Typical Value
Appearance	Methacrylate ester
Toxicity	Red
Flash point	Low
	Above 200°F(93°C)

CURING PERFORMANCE AFTER FASTENER ASSEMBLY

Cure speed vs. substrate

The graph shown below shows the rate of cure on 3/8 - 16 nuts and bolts made from different materials.



TYPICAL PROPERTIES OF CURED MATERIAL PERFORMANCE OF CURED MATERIAL

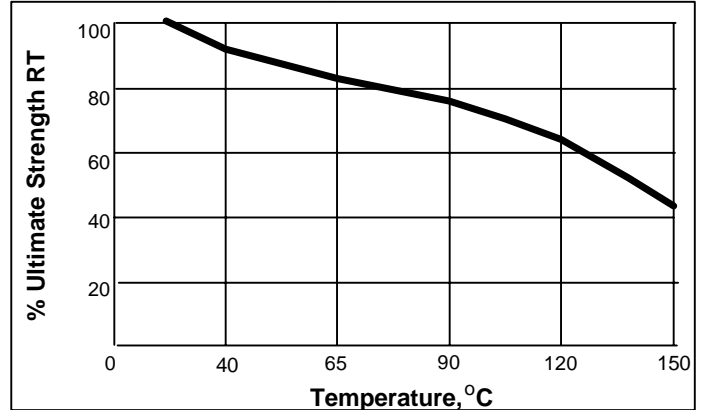
Strength range	Typical Value
Breakaway torque- 3/8-16 Grade 5 phos. & oil nuts and bolts	High 280 lb.-in.
Shear strength lb./in. psi	3100
Temperature range	-65°F to +300°F (-54°C to +150°C)
On part life	4 years
Cure time @ RT	72 hours
Fixture time @ RT	10 minutes

TYPICAL ENVIRONMENTAL RESISTANCE

Hot Strength

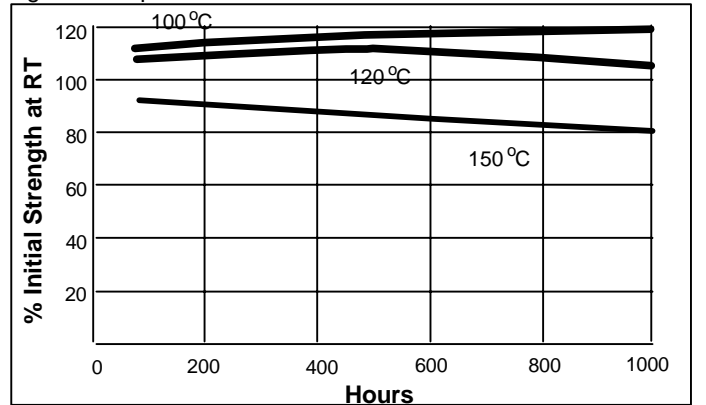
Test procedure	Breakaway torque, on 3/8-16 phosphate and oil nuts and bolts in accordance with MIL-S-46163 procedures
Substrate	Phosphate and oil 3/8-16 nuts & bolts
Cure procedure	72 hours at 72°F (22°C)

Conditioned and tested at temperature



Heat Aging

Aged at temperature indicated and tested at 22°C



Chemical / Solvent Resistance

Aged under conditions indicated and tested at 22°C.

Solvent	Temp		% Initial Strength retained at Hours		
	°F	°C	100	500	1000
Motor Oil	257	125	117	96	86
Motor Oil	188	87	125	112	105
ATF	257	125	100	100	100
Gasoline(unleaded)	72	22	102	113	119
Brake Fluid	72	22	101	105	114
Ethanol	72	22	102	112	112
1,1,1 Trichloroethane	72	22	104	116	112
Water/Glycol (50%/50%)	188	87	119	112	108

SURFACE COMPATIBILITY

Loctite adhesives/sealants may stain or discolor some metals. However, the effect on performance of the adhesive has been shown to be inconsequential. **Dri-Loc Threadlockers are not recommended for use on copper or brass.**

GENERAL INFORMATION**Application Method**

Dri-Loc 204 is applied to threaded parts by authorized converters throughout the United States who have automatic fastener cleaning, feeding, coating, rust proofing and drying equipment. Quantities can be handled promptly with minimum turnaround time. Sample bolts should be sent to the nearest authorized converter where they will coat your parts and return them to you for evaluation. **SAMPLE TESTS ARE RECOMMENDED TO OBTAIN DESIRED RESULTS ON YOUR PARTS.** Contact the nearest Loctite Technical Service Center for the authorized converter nearest to you.

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). It is recommended to confirm compatibility of the product with such substrates.

Storage

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

Data Ranges

The data contained herein may be reported as a typical value and/or range. 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 license 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.