



Loctite® Primers

Surface Preparation Products to Ensure Maximum Performance of Anaerobic Machinery Adhesives

Why use Loctite® Primers?

To speed up cure

- Significantly speed up the cure time of Loctite® Anaerobic Machinery Adhesives for threadlocking, thread sealing, gasketing and retaining applications.
- Recommended for challenging assemblies of metal parts that are cold, have large gaps or deep threads.
- Speed up the cure time of Loctite® Primerless Anaerobic Machinery Adhesives.
- Solvent-based versions act as cleaning agents.

When are Loctite® Primers recommended?

On inactive metals*

- Loctite® Anaerobic Machinery Adhesives cure in the absence of air and presence of metal ions. When assembling inactive metal parts, which are low in metal ions, the use of Loctite® Primers are recommended to ensure proper performance of Loctite® Anaerobic Machinery Adhesives.

Inactive Metals* (Primers Recommended)			Active Metals (Primers Optional)	
Plated Parts	Zinc	Magnetite Steel	Iron	Bronze
Anodized Aluminum (Alodine®, Iridite™)	Pure Aluminum	Iconel™	Plain Steel	Nickel
Titanium	Cadmium	Silver	Copper	Manganese
Stainless Steel	Magnesium	Gold	Brass	Monel™
Galvanized Steel	Natural or Chemical Black Oxide			Kovar™

Loctite® Primer Properties Chart

	Product	Item #	Package Type and Size	Physical Property	On-Part Life	Dry Time	Agency Approvals
Solvent Based	7471™ Primer T™	19267 22477 19268	1.75 fl. oz. bottle 4.5 oz. net wt. aerosol can 1 gallon can	Liquid	7 days	30 to 70 seconds	MIL-S-22473E for existing designs, ASTM D-5363 for new designs
	7649™ Primer N™	19269 21347 21348 19266	1.75 fl. oz. glass bottle 25 g net wt. aerosol can 4.5 oz. net wt. aerosol can 1 gallon can	Liquid	30 days	30 to 70 seconds	MIL-S-22473E for existing designs, ASTM D-5363 for new designs, NSF/ ANSI 61, NSF P1, CFIA
Solventless	7090™	19368 12695	1 fl. oz. bottle 1 liter bottle	Liquid	1 hour	<10 minutes	N/A
	Loctite® 7088™ Primer Stick	1069258	17 g stick	Semisolid	30 days	N/A	N/A

LOCTITE®



Loctite® 7088™ Primer Stick

Our patented semisolid formula outperforms liquid primers.

Product benefits

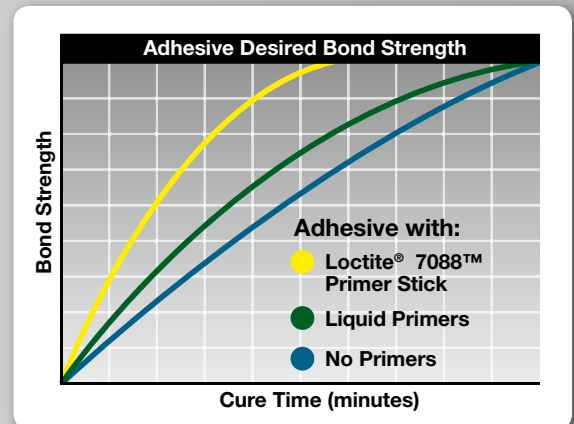
- Makes Loctite® Anaerobic Machinery Adhesives reach desired bond strength faster than liquid primers

Solvent-free – environmentally and user-friendly

- Lower flammability
- Low odor
- VOC compliant

Convenient stick package

- Pocket-friendly
- No spill
- Great for overhead applications
- Neat addition to any toolbox



Note: Loctite® 7088™ Primer Stick also works well with Loctite® Two-Step Acrylic Magnet Bonders

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