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Loctite 222

Loctite 222 Low Strength Threadlocking Adhesive Instruction Manual

Model: 222

1. PRODUCT OVERVIEW

Loctite 222 is a low-strength, thixotropic, methacrylate-based threadlocking adhesive designed for locking and sealing threaded fasteners that require easy disassembly with standard hand tools. This product prevents loosening and leakage from shock and vibration by filling all gaps between mating threads. It is suitable for all metal threaded assemblies, including passive substrates like stainless steel, aluminum, and plated surfaces. Loctite 222 is characterized by its purple color and fluoresces under UV light, aiding in product detection during service.

2. BENEFITS OF LOCTITE THREADLOCKERS

Loctite Threadlockers enhance the reliability and performance of threaded assemblies. The following points highlight the key advantages:



LOCTITE Threadlockers lock assemblies against vibration by filling all microscopic spaces between interfacing threads.

BENEFITS



01

INCREASE RELIABILITY



03

INCREASE END PRODUCT SERVICE LIFE



05

SAVE COST



07

ALLOW FOR DISASSEMBLY



02



OUTPERFORM LOCKING DEVICES

04



PREVENT GALLING AND CORROSION

06



MINIMIZE INVENTORY COST AND COMPLEXITY

08



EXCELLENT CHEMICAL AND THERMAL RESISTANCE

Image: Infographic illustrating the benefits of Loctite Threadlockers. These benefits include increased reliability, outperforming traditional locking devices, extending end product service life, preventing galling and corrosion, reducing costs, minimizing inventory complexity, allowing for easy disassembly, and providing excellent chemical and thermal resistance.

- **Increase Reliability:** Enhances the overall dependability of assembled components.
- **Outperform Locking Devices:** Provides superior locking compared to mechanical locking methods.
- **Increase End Product Service Life:** Contributes to the longevity of the final product.
- **Prevent Galling and Corrosion:** Protects threads from wear and environmental degradation.
- **Save Cost:** Reduces expenses associated with maintenance and part replacement.
- **Minimize Inventory Cost and Complexity:** Simplifies inventory management by reducing the need for various locking hardware.
- **Allow for Disassembly:** Enables easy removal of fasteners using standard hand tools, crucial for maintenance and repair.
- **Excellent Chemical and Thermal Resistance:** Maintains performance under various chemical exposures and temperature fluctuations.

3. SETUP AND PREPARATION

1. **Clean Surfaces:** For best results, clean all threaded surfaces (both bolt and nut) with a suitable cleaning solvent, such as Loctite SF 7063, and allow to dry.
2. **Surface Condition:** Loctite 222 is designed to tolerate minor surface contamination from industrial oils (e.g., motor oils, corrosion prevention oils, cutting fluids). However, excessive contamination should be removed.
3. **Primer (Optional):** If cure speed is too slow, or if working with inactive metals or large gap sizes, consider using an activator like Loctite SF 7649 or Loctite SF 7471. Consult the product's technical data sheet for specific recommendations.
4. **Temperature:** Apply the product at room temperature (20-25°C / 68-77°F) for optimal performance.

4. OPERATING AND APPLICATION INSTRUCTIONS

4.1. For Thru-Holes

- Apply several drops of Loctite 222 onto the bolt at the nut engagement area.
- Assemble and tighten as required.

4.2. For Blind Holes

- Apply several drops of Loctite 222 down the internal threads to the bottom of the blind hole.
- Assemble and tighten as required.

4.3. For Sealing Applications

- Apply a 360° bead of product to the leading threads of the male component, leaving the first thread free.
- Distribute the product to fill the gaps. For larger diameters and gaps, adjust product quantity accordingly.
- Assemble and tighten as required.

Cure Time: The product will fixture in approximately 10 minutes at room temperature. Full cure is achieved in 24 hours. Functional strength is typically reached sooner, allowing for handling.

5. MAINTENANCE AND DISASSEMBLY

5.1. Disassembly

Due to its low strength, Loctite 222 allows for easy disassembly using standard hand tools. No special heating or tools are typically required for removal.

5.2. Storage

Store Loctite 222 in its original container in a cool, dry location. Optimal storage temperature is between 8°C to 21°C (46°F to 70°F). Do not return unused product to the original container as contamination may reduce shelf life.

6. TROUBLESHOOTING

• Product Not Curing:

- Ensure surfaces are clean and free from heavy grease or oil.
- Verify that the product is applied between metal surfaces; anaerobic adhesives cure in the absence of air and in contact with metal.
- Consider using an activator (e.g., Loctite SF 7649) if working with inactive metals (e.g., zinc, cadmium, anodized aluminum) or if cure speed is critical.
- Check ambient temperature; very low temperatures can slow down the cure process.

• Difficulty Dispensing:

- If the nozzle is clogged, clear it with a pin or toothpick. Do not cut the nozzle opening larger than necessary.
- Ensure the bottle is stored upright to prevent clogging.

7. SPECIFICATIONS

Attribute	Value
Brand	Loctite
Model Number	222
Specific Uses For Product	Repair, Threadlocking
Material Compatibility	Aluminum, Metal
Item Form	Liquid
Special Feature	Fluorescent (Purple color)
Item Volume	50 Milliliters (1.69 Fluid Ounces)
Full Cure Time	24 Hours
Water Resistance Level	Waterproof
Viscosity Level	Low to Medium
Strength	Low Strength (Easy Disassembly)
Prevents Loosening	Yes, on vibrating assemblies

8. SAFETY INFORMATION

Always read the Material Safety Data Sheet (MSDS) for Loctite 222 before use. The MSDS provides detailed information on safe handling, personal protective equipment, and emergency procedures.

- **Ventilation:** Use in a well-ventilated area.
- **Skin Contact:** Avoid prolonged or repeated skin contact. Wash thoroughly with soap and water after handling.
- **Eye Contact:** In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.
- **Ingestion:** Do not ingest. If swallowed, seek medical advice immediately and show this container or label.
- **Keep Out of Reach of Children:** Store in a secure location away from children and pets.

9. WARRANTY AND SUPPORT

For specific warranty information or technical support regarding Loctite 222, please refer to the official Loctite website or contact Loctite customer service directly. Product performance is guaranteed when used according to instructions and within its shelf life.

For further assistance, visit the [Loctite Store on Amazon](#).