

## LOCTITE® PC 3967

Known as

## Loctite® Form-A-Thread Stripped Thread Repair Kit

August 2015

## PRODUCT DESCRIPTION

LOCTITE® PC 3697 Stripped Thread Repair Kit consists of a two-component, gray and blue repair material and a one-component release agent. LOCTITE® PC 3697 can be used to repair stripped threaded assemblies in a variety of metal and wood.

## TYPICAL APPLICATIONS

LOCTITE® PC 3697 can be used to repair damaged threaded metal assemblies. Typical applications include threaded assemblies on oil pans, valve covers, distributor caps transmission pans and housing.

## **PRODUCT FEATURES**

#### Easy to Use:

- One kit repairs all sizes
- Requires no machine shop skills
- Repairs typical assemblies not possible by other means.

## Fast, Reliable, Versatile:

- Works on a wide range of materials
- · Achieves handling strength in 5 minutes
- Achieves full strength in two hours
- Cures to machinable hardness in two hours

## Safe to use:

• Non-flammable

## PROPERTIES OF UNCURED MATERIAL Repair Material

Typical Value
Chemical Type
Dimethacrylate Ester
Appearance
Odor
Odor
Specific Gravity
Flash Point,°F

Typical Value
Dimethacrylate Ester
Gray, mixed
Mild pungent
1.57

>200

## Release Agent (liquid)

Typical Value
Chemical Type Silicone Emulsion
Appearance Blue
Odor None
Flash Point None

## **MAXIMUM TORQUE VALUES FOR REPAIRED THREADS**

Bolt Type	Bolt Size						
English Inches Grade 5	1/4	5/16	3/8	7/16	1/2		
Metric mm Grade 8.8	6	8	10	11	12		
Max. Recommended Torque (in.lbs)	23	45	82	129	193		

Bolt Type	Bolt Size							
English Inches Grade 5	9/16	5/8	3/4	7/8	1			
Metric mm Grade 8.8	14	16	19	22	25			
Max. Recommended Torque (in.lbs)	273	375	648	1080	1538			

#### **TECHNICAL DATA**

LOCTITE® PC 3697 is a high-technology chemical system that restores threads to damaged fastener assemblies. The prime advantage of Loctite's system is the fact that LOCTITE® PC 3697 repairs almost all common fastener sizes and thread grades. LOCTITE® PC 3697 is used on most metals (aluminum, iron, steel, brass, magnesium, copper, etc.)

## **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 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.

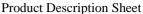
## Directions for use

- 1. Coat bolt with release agent.
- Dispense and mix equal amounts LOCTITE® PC 3697 compounds on clean surface.
- 3. Apply into application.
- 4. Screw bolt into place.
- 5. Wait 5 minutes and remove bolt.
- 6. Allow compound to cure for 30 minutes before use.

## Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure







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to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

#### 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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