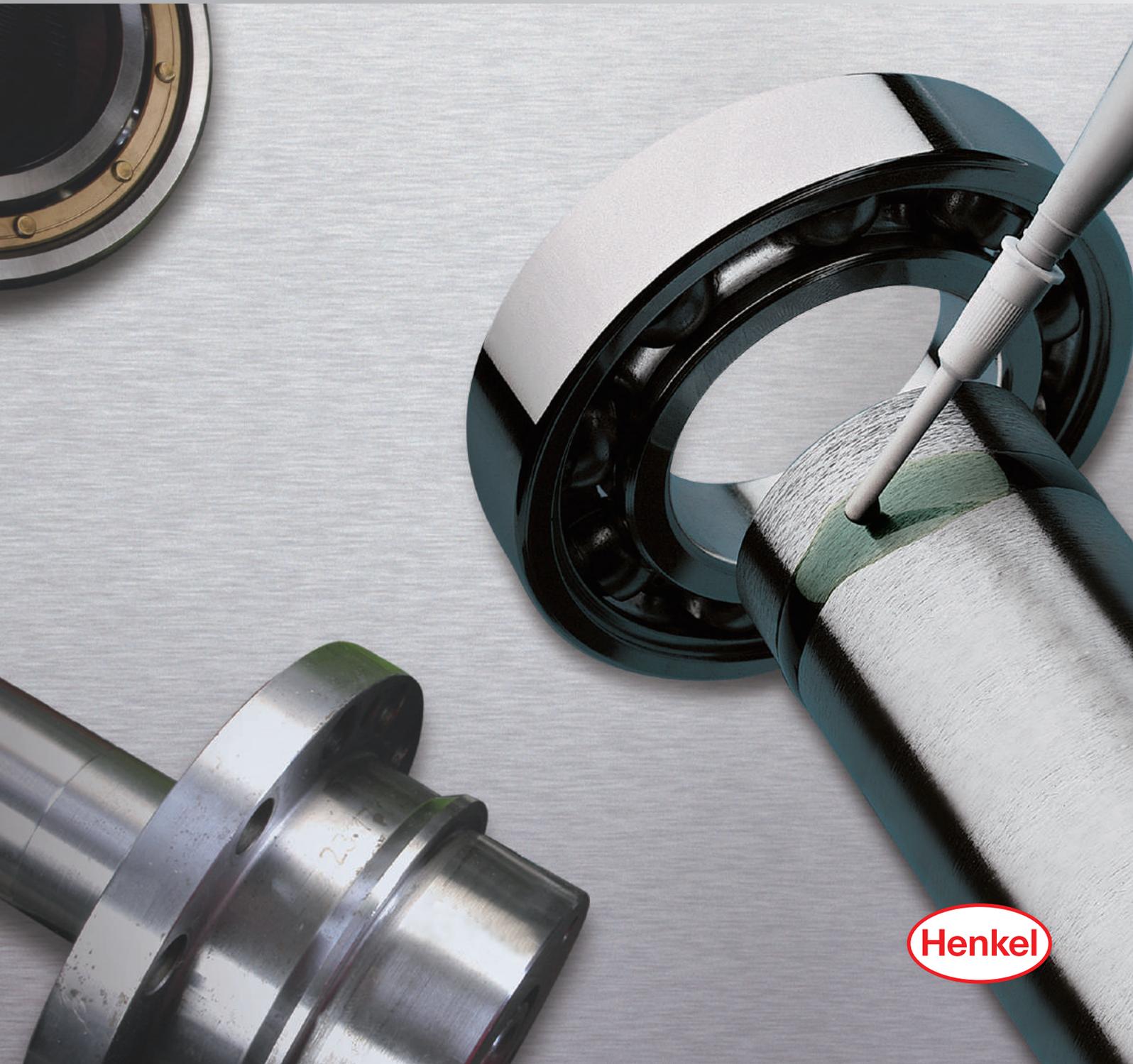


**LOCTITE**<sup>®</sup>

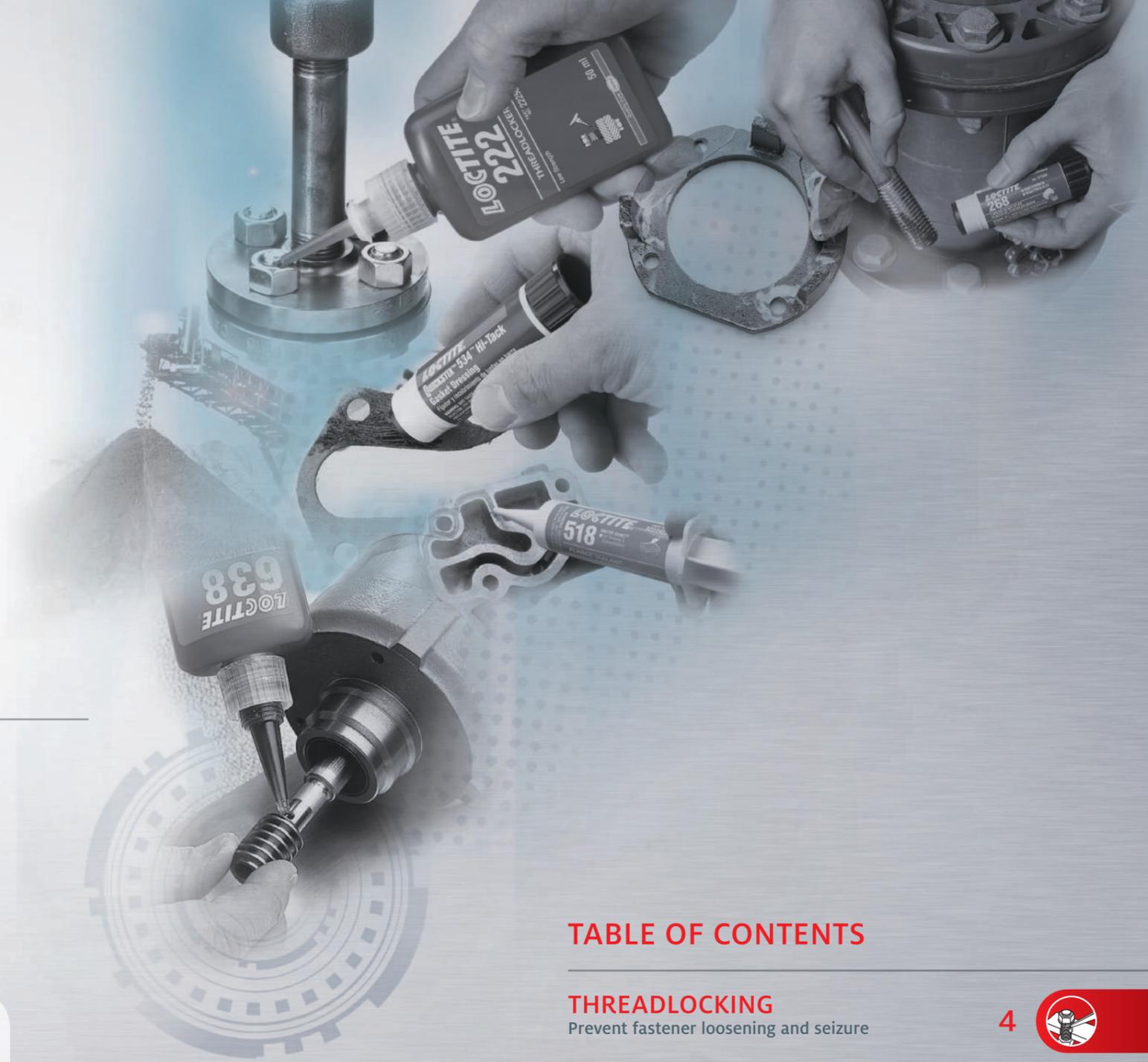
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# General Manufacturing Anaerobics Selector Guide



**Henkel**



**Value-Added Partnership**

Our large, experienced team of engineers provide documented design and application support.

**Cost Savings and Reliability**

LOCTITE® solutions are more cost effective compared to conventional mechanical methods.

**Global Leadership**

LOCTITE® is the global technology leader with wide product range sold through an extensive sales and distributor network.

**Superior Product Performance**

LOCTITE® adhesives and sealants are recognized as the best performing products in the industry.

**End-User Training**

We provide professional training programs to customers that help them identify opportunities for improving process efficiency, quality and costs.

**LOCTITE® is the world's #1 brand of engineering adhesives & sealants.**



**Achieving more with less**

Our commitment to leadership in sustainability is deeply embedded in our values. With our revised Sustainability Strategy for 2030, we are building on our strong track record. At the same time, we are aiming to address one of the central future challenges: to decouple growth from resource consumption. At the heart of this strategy is therefore the simple, yet challenging, ambition: to achieve more with less. It aims to create more value for our customers, consumers, communities and the company alike, while simultaneously reducing the environmental footprint.

MEMBER OF  
**Dow Jones Sustainability Indices**  
In Collaboration with RobecoSAM

2013 **WORLD'S MOST ETHICAL COMPANIES**  
WWW.ETHISPHERE.COM

**NYSE Euronext vigeo**

Corporate Responsibility **Prime**  
rated by **ekom re|se|air|h**

**SUSTAINALYTICS**

Member 2013/2014  
**STOXX**  
ESG LEADERS INDICES

**Global Challenges Index**

UNEP  
**FTSE4Good**

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# THREADLOCKING

## Locking of threaded fasteners

- » PREVENTS LOOSENING FROM SHOCK AND VIBRATION
- » SINGLE COMPONENT – CLEAN AND EASY TO APPLY
- » CAN BE USED ON VARIOUS SIZES OF FASTENERS – REDUCES INVENTORY COSTS
- » SEALS THREADS
- » STOPS RUST AND CORROSION



### ARE THE PARTS ALREADY ASSEMBLED?

**Helpful Hints:**

- Clean parts with LOCTITE® ODC-Free Cleaner and Degreaser before applying the adhesive.
- If the threadlocker will be applied below 40°F (5°C), pre-treat with LOCTITE® 7649 Primer N.
- If the parts were in contact with aqueous washing solutions or cutting fluids that leave a protective layer on the surface, wash with hot water before use.

YES		NO				
Wicking – Green		What strength do you require?				
Liquid Product		Low – Purple	Medium – Blue	High – Red	Semi-Solid Product	
LOCTITE® 290		LOCTITE® 222	LOCTITE® 243	LOCTITE® 248 (Up)	LOCTITE® 263	LOCTITE® 268 (Up)
#2 TO 1/2" (M2 TO M12)		Up to 1/4" (Up to M6)	1/4" to 3/4" (M6 to M20)	1/4" to 3/4" (M6 to M20)	Up to 1" (Up to M25)	Up to 3/4" (Up to M20)
High		Low	Medium	Medium	High	High
20 min./24 hr.		10 min./24 hr.	10 min./24 hr.	10 min./24 hr.	10 min./24 hr.	20 min./24 hr.
90/260 (10/29)		53/30 (6/3)	180/62 (20/7)	110/43 (12/4)	275/290	202/4 (22/0.5)
300°F (150°C)		300°F (150°C)	360°F (180°C)	300°F (150°C)	360°F (180°C)	300°F (150°C)
10 ml bottle - 1595016 50 ml bottle - 232085 250 ml bottle - 235226		10 ml bottle - 1595017 50 ml bottle - 228581 250 ml bottle - 228582	10 ml bottle - 1331537 50 ml bottle - 1311320 250 ml bottle - 1311322	9 g stick - 37772 19 g stick - 37773	10 ml bottle - 1331617 50 ml bottle - 1307415 250 ml bottle - 1307416	9 g stick - 1069297 19 g stick - 902328

**HENKEL SOLUTIONS**

Fastener Size	#2 TO 1/2" (M2 TO M12)
Strength	High
Cure Time (Fixture/Full Strength)*	20 min./24 hr.
Breakaway/Prevail Torque lb.in. (N.m)	90/260 (10/29)
Temperature Resistance for Continuous Service	300°F (150°C)
Package Size & IDH	10 ml bottle - 1595016 50 ml bottle - 232085 250 ml bottle - 235226

Fastener Size	Up to 1/4" (Up to M6)
Strength	Low
Cure Time (Fixture/Full Strength)*	10 min./24 hr.
Breakaway/Prevail Torque lb.in. (N.m)	53/30 (6/3)
Temperature Resistance for Continuous Service	300°F (150°C)
Package Size & IDH	10 ml bottle - 1595017 50 ml bottle - 228581 250 ml bottle - 228582

Fastener Size	1/4" to 3/4" (M6 to M20)
Strength	Medium
Cure Time (Fixture/Full Strength)*	10 min./24 hr.
Breakaway/Prevail Torque lb.in. (N.m)	180/62 (20/7)
Temperature Resistance for Continuous Service	360°F (180°C)
Package Size & IDH	10 ml bottle - 1331537 50 ml bottle - 1311320 250 ml bottle - 1311322

Fastener Size	1/4" to 3/4" (M6 to M20)
Strength	Medium
Cure Time (Fixture/Full Strength)*	10 min./24 hr.
Breakaway/Prevail Torque lb.in. (N.m)	110/43 (12/4)
Temperature Resistance for Continuous Service	300°F (150°C)
Package Size & IDH	9 g stick - 37772 19 g stick - 37773

Fastener Size	Up to 1" (Up to M25)
Strength	High
Cure Time (Fixture/Full Strength)*	10 min./24 hr.
Breakaway/Prevail Torque lb.in. (N.m)	275/290
Temperature Resistance for Continuous Service	360°F (180°C)
Package Size & IDH	10 ml bottle - 1331617 50 ml bottle - 1307415 250 ml bottle - 1307416

Fastener Size	Up to 3/4" (Up to M20)
Strength	High
Cure Time (Fixture/Full Strength)*	20 min./24 hr.
Breakaway/Prevail Torque lb.in. (N.m)	202/4 (22/0.5)
Temperature Resistance for Continuous Service	300°F (150°C)
Package Size & IDH	9 g stick - 1069297 19 g stick - 902328

\* Typical value @ 70°F (22°C)



Recommended for locking pre-assembled fasteners, i.e. instrumentation screws, electrical connectors, and set screws. Also seals porosities in welds and metal parts.

Recommended for low strength threadlocking of adjustment screws, countersunk head screws, and set screws; on collars, pulleys, tool holders, and controllers. Also for low strength metals such as aluminum or brass.

With improved oil tolerance, LOCTITE® 243 Threadlocker is effective on all types of metal threaded fasteners. Prevents loosening on vibrating parts such as pump, motor mounting bolts, gear boxes, or presses. Removable with hand tools.

Semi-solid stick form is convenient, portable, and great for hard-to-reach applications. LOCTITE® 248 Threadlocker – Medium Strength is the ideal general-purpose threadlocker for all nut and bolt applications, especially fasteners between 1/4" and 3/4" (M6 to M20). Removable with hand tools. Oil tolerance & primerless.

Versatile, high strength liquid threadlocker. Reliably locks and seals metal fasteners up to 1". Engineered to cure consistently on a variety of metals, despite minor surface contaminants. Works on steel, stainless steel and most plated fasteners. Tolerates thread lubrication, anti-corrosion and protection fluids. Rated for 360°F (180°C). Heat required for removal.

This convenient semisolid stick form is portable and less messy. Its high strength prevents loosening of threaded fasteners. Well suited for heavy-duty applications. Oil tolerance & primerless.

### ADDITIONAL PRODUCTS

Name	Strength/Color	Breakaway/Prevail Torque lb./in. (N.m)	Features
LOCTITE® 242	Medium - Blue	110/43 (12/4)	Fasteners 1/4" to 3/4" (M6 to M20)
LOCTITE® 220	Low - Blue	80/170	Removable grade, wicking, for small threads of 1/4" or smaller
LOCTITE® 277	High - Red	250/275 (28/31)	Fasteners up to 1 1/2"
LOCTITE® 262	High - Red	189/275 (21/31)	Fasteners up to 3/4" (M20)
LOCTITE® 271	High - Red	250/275 (28/31)	Fasteners up to 1" (Up to M25)
LOCTITE® 272	High - Orange	200/220 (22/24)	High Temp up to 11/2" (M36)

**LOCTITE® PRIMERS**

**Use LOCTITE® Primer to:**

1. Activate inactive surfaces.
2. Speed cure times for faster return to service.
3. Speed curing through larger gaps and deep threads.
4. Substantially speed cure times on cold parts.
5. Act as a cleaning agent.



Name	Color	Viscosity	Base	On-Part Life	Dry Time	Package Size & IDH
7649 Primer N	Clear/Green	2	Acetone	30 days	30 to 70 seconds	1.75 oz. - 1179077 100 ml - 555114 4.5 oz. - 475763 500 ml - 487644
7471 Primer T	Amber	2	Acetone/Isopropanol	7 days	30 to 70 seconds	1.75 oz. - 1179078 100 ml - 555104 4.5 oz. - 555110 500 ml - 555112

**Primer is optional with:**  
Active surfaces: Brass, copper, bronze, iron, soft steel, nickel.

**Primer is required with:**  
Inactive surfaces: Aluminum, stainless steel, magnesium, zinc, black oxide, cadmium, titanium, and others.



# THREAD SEALING

- » REPLACES TAPES AND PASTES
- » LIQUIDS ENSURE COMPLETE CONTACT BETWEEN THREADS FOR A 100% SEAL
- » LIQUIDS WILL NOT CREEP, SHRINK, SHRED OR BLOCK SYSTEMS (INCLUDING FILTERS)
- » DISASSEMBLY CAN BE ACHIEVED EASILY WITH BASIC HAND TOOLS



## ARE THE PARTS METAL OR PLASTIC?

**Helpful Hints:**

- If the sealant (LOCTITE® 545 Thread Sealant, LOCTITE® 565 PST Thread Sealant, LOCTITE® 567 PST Thread Sealant, or LOCTITE® 561 Pipe Sealant) will be applied below 40°F (5°C), pre-treat with LOCTITE® 7649 Primer N.
- All parts must be clean and dry before sealing - use LOCTITE® ODC-Free Cleaner and Defreaser.

### PLASTIC AND/OR METAL

Cord

Fine

### METAL PARTS

Are the threads fine or coarse?

Coarse

Do you prefer a solid or a liquid? (Solid is ideal for overhead or hard to reach applications)

Liquid

Semi-Solid

HENKEL SOLUTIONS	LOCTITE® 55	LOCTITE® 545	LOCTITE® 565	LOCTITE® 577	LOCTITE® 567	LOCTITE® 561
Description	Cord	Purple Liquid	White to off White Paste	Yellow Paste	White Paste	White Stick
Maximum Thread Size	4" (10.16 cm)	Up to 2" (5.08 cm)	Up to 2" (5.08 cm)	Up to 2" (5.08 cm)	3" (7.62 cm)	3" (7.62 cm)
Temperature Resistance	300°F (150°C)	300°F (150°C)	300°F (150°C)	265°F (130°C)	400°F (204°C)	300°F (150°C)
Maximum Pressure Resistance (psi)/Cure Time (N/mm²)	10,000 psi/instant (68.9)	10,000 psi/24 hrs. (68.9)	10,000 psi/72 hrs.	10,000 psi/72 hrs. (68.9)	10,000 psi/72 hrs. (68.9)	10,000 psi/72 hrs. (68.9)
Substrate to be Sealed	Metal, Plastic or Both	Metal	Metal	Metal	Stainless Steel, Aluminum	Metal
Instant Low Pressure Seal	Yes	No	Yes	No	Yes	Yes
Package Size & IDH	5,700 inches (150 m) - 270135 5,700 inches (150 m) - 342134 5,700 inches (150 m) - 1061210 1,968 inches (50 m) - 483282	50 ml bottle - 232095 250 ml tube - 1327769	50 ml tube - 339604 250 ml tube - 449139	50 ml tube - 232097 250 ml tube - 235280	50 ml tube - 231701 250 ml tube - 235608	19 g stick - 463973

ADDITIONAL PRODUCTS	
Name	Features
LOCTITE® 572	Easy application by hand. For use on construction pipe sealing.
LOCTITE® 542	Medium strength. The thixotropic nature reduces the migration of liquid product after application to the substrate.
LOCTITE® 569	Low strength. Original hydraulic sealant.
LOCTITE® 5651	Low strength. Easy application by hand. For use on construction pipe sealing.



Can be safely applied on metal and plastic threaded fittings. Potable water: NSF/ANSI 61 UL Listed and Certified to CSA International.



Recommended for fine threaded fittings as used in hydraulic and pneumatic installations and small fittings in general.



A general-purpose instant sealant for tapered and straight/tapered fittings.



Medium strength, general purpose sealant for use on coarse, threaded components.



Withstands temperatures to 400°F with excellent solvent resistance. Locks and seals tapered pipe threads and fittings, including high pressure applications. Disassembles with hand tools.



Semi-solid stick form is convenient, portable, and less messy. Formulated for fast, reliable curing on metal, tapered pipe threads and fittings. LOCTITE® 561 PST Pipe Sealant provides high pressure sealing and withstands continuous operating temperatures of -65°F to 300°F (-54°C to 150°C).



# GASKETING

## Sealing and Flanges

- » NO SHIMMING EFFECT – CONTROLLED TOLERANCES, NO NEED FOR RE-TORQUING
- » FILL ALL VOIDS – REDUCE THE NEED FOR A FINE SURFACE FINISH OF FLANGES
- » PARTS CAN BE DISASSEMBLED EASILY EVEN AFTER EXTENDED SERVICE
- » RESISTS HIGH PRESSURE WHEN FULLY CURED



### DOES THE EXISTING GASKET NEED TO BE USED AS A SHIM?

**Helpful Hints:**

- If there are traces of old gasket left on the parts to be sealed, clean with LOCTITE® 790 Chisel Gasket Remover, LOCTITE® 565 PST Thread Sealant, LOCTITE® 567 PST Thread Sealant, or LOCTITE® 561 PST Pipe Sealant will be applied below 40°F (5°C), pre-treat with LOCTITE® 7649 Primer N.
- All parts must be clean and dry before sealing – use LOCTITE® ODC-Free Cleaner and Degreaser.
- Anaerobic products cure between metal surfaces with the absence of air.

	<b>NO</b>	
<b>Are you sealing a rigid or a stamped flange?</b>		
<b>Rigid</b>		<b>Stamped</b>

<b>YES</b>
<b>Positioning cut gaskets</b>

HENKEL SOLUTIONS	LOCTITE® 518	LOCTITE® 510
<b>Color</b>	Red	Pink
<b>Gasket Type</b>	Formed-in-place	Formed-in-place
<b>Gap Fill</b>	0.010" (0.25 mm)	0.010" (0.25 mm)
<b>Cure Method</b>	Anaerobic	Anaerobic
<b>Fixture/Cure Time</b>	N.A./24 hrs.	N.A./24 hrs.
<b>Temperature Resistance (Continuous/Intermittent)</b>	300°F (150°C)/N.A.	400°F (204°C)/N.A.
<b>Instant Seal</b>	Excellent	Excellent
<b>Water/Glycol Resistance</b>	Excellent	Excellent
<b>Package Size &amp; IDH</b>	50 ml tube - 231697 300 ml cart. - 235269	50 ml tube - 235255 300 ml cart. - 231352 850 ml cart. - 939535

LOCTITE® 587	LOCTITE® 596	LOCTITE® Instant Gasket	LOCTITE® 534
Blue	Red	Black	Purple
Formed-in-place	Formed-in-place	Formed-in-place	Use with cut gasket
0.250" (6.35 mm)	0.250" (6.35 mm)	0.250" (6.35 mm)	N.A.
Moisture (RTV)	Moisture (RTV)	Moisture (RTV)	Anaerobic
50 min.	N.A./50 min.	5 min.	N.A.
400°F (204°C) 482°F (250°C)	600°F (316°C)	450°F (232°C) 482°F (250°C)	300°F (150°C)/N.A.
Excellent	Excellent	Excellent	Excellent
Excellent	N.A.	Excellent	N.A.
85 g tube - 231482 370 g cart. - 576854	85 g tube - 743065 85 g tube - 778136	90 ml - 743912 190 ml - 743913	19 g stick - 731749 19 g stick - 640804 19 g stick - 933726

ADDITIONAL PRODUCTS	
Name	Features
LOCTITE® 515 Gasket Eliminator Flange Sealant	For flexible applications. Cure speed: Unprimed - 1 to 12 hours. Primed - 15 minutes to 2 hours.
LOCTITE® 5127 Gasket Eliminator Flange Sealant	For flexible applications, high elongation. Unprimed - 4 to 24 hours. Primed - 1 to 24 hours.
LOCTITE® 574 Gasket Eliminator Flange Sealant	Fast curing, large gaps. Unprimed - 1 to 12 hours. Primed - 15 minutes to 2 hours.
LOCTITE® 790 Chisel Gasket Remover	Solvent. Dry time: Leave on surface for 5 to 10 minutes. Wipe/scrape clean.



Recommended for use on rigid iron, steel and aluminum flanges. Spray LOCTITE® 7649 Primer N on only one surface.



High temperature. Product has a temperature range to 400°F (204°C) with excellent solvent and chemical resistance. Makes or dresses gaskets in rigid assemblies. Eliminates gasket compression set.



All types of flanges including stamped sheet metal. Designed for superior bonding properties to oil contaminated metals.



High temperature silicone sealant makes the repair of industrial furnaces, ovens, boilers, exhaust stacks, high temperature stacks, ducting and heating elements.



Makes high-performance, leakproof gaskets in one minute. Equipment can be returned to service immediately. Blowout resistant. Outperforms precut gaskets.



No mess semi-solid formula offers added control and ease of use. Patented package is portable and won't leak or spill. Seals and holds the heaviest gaskets in place during assembly. Solvent-free and low odor. Suitable to 300°F (150°C).



# RETAINING

## Securing Cylindrical Assemblies

- » BOND NON-THREADED CYLINDRICAL METAL ASSEMBLIES
- » HIGH AND MODERATE STRENGTH PRODUCTS – CAN CARRY HIGH LOADS AND ELIMINATE FRETTING
- » FILL ALL VOIDS – PREVENT CORROSION
- » REDUCE THE NEED FOR CLOSE TOLERANCES
- » 100% CONTACT – LOAD AND STRESS ARE DISTRIBUTED EVENLY OVER THE JOINT



### IS THE ASSEMBLY BADLY WORN?

**Helpful Hints:**

- If the retaining compound will be applied below 40°F (5°C), pre-treat with LOCTITE® 7649 Primer N.
- All parts must be clean and dry before sealing – use LOCTITE® ODC-Free Cleaner and Degreaser.
- If the parts have been in contact with washing or cutting fluids containing nitrates, wash with hot water.

**YES - GAPS UP TO 0.020" (0.5 MM)**

**NO - GAPS TO 0.015" (0.4 MM)**

Do you require low, medium or high strength?

Low Strength

Medium Strength

High Strength

Do you require a high viscosity (slower flowing) or a low viscosity (faster flowing) product?

High Viscosity

Low Viscosity

HENKEL SOLUTIONS	LOCTITE® 660	LOCTITE® 641	LOCTITE® 609	LOCTITE® 668	LOCTITE® 638 <sup>Up</sup>	LOCTITE® 648 <sup>Up</sup>
Strength Required	High	Low	Medium	Medium	High	High
Shear Strength (N/mm <sup>2</sup> )	3,335 psi (23)	1,700 psi (11.7)	2,300 psi (15.8)	1,870 psi (12.8)	4,200 psi (29)	4,480 psi (31)
Diametrical Clearance	Up to 0.020" (0.5 mm)	Up to 0.006" (0.15 mm)	Up to 0.005" (0.1 mm)	Up to 0.005" (0.1 mm)	Up to 0.01" (0.25 mm)	Up to 0.006" (0.15 mm)
Temperature Resistance	300°F (150°C)	300°F (150°C)	300°F (150°C)	400°F (204°C)	356°F (180°C)	356°F (180°C)
Cure Time (Setup/Full Strength)	20 min./24 hr.	20 min./24 hr.	10 min./24 hr.	30 min./24 hr.	15 min./24 hr.	10 min./24 hr.
Package Size & IDH	50 ml tube - 231699	50 ml bottle - 387885 250 ml bottle - 1496874 250 ml bottle - 45081	50 ml bottle - 232100 250 ml bottle - 235286 250 ml bottle - 30998	19 g stick - 640470	50 ml bottle - 1800356 250 ml bottle - 1800355	50 ml bottle - 1800575 250 ml bottle - 1800574

\* Requires heat cure to achieve temperature resistance

#### ADDITIONAL PRODUCTS

Name	Features
LOCTITE® 680 <sup>Up</sup>	Gives best resistance to dynamic, axial and radial loads. Recommended for retaining shafts, gears, pulleys, and similar cylindrical parts.
LOCTITE® 620	Particularly suitable for applications where temperature resistance up to 200°C is required. Requires heat cure to achieve temperature resistance.
LOCTITE® 603	For close-fitting parts with light contamination. Typical applications include retaining roller bearings or oil impregnated bushings into housings.



Used for repairing worn coaxial parts without remachining; enables reuse of worn bearing seats, keys, splines, tapers, or for retaining shims.



A controlled strength retaining compound that is ideal for cylindrical parts that require disassembly.



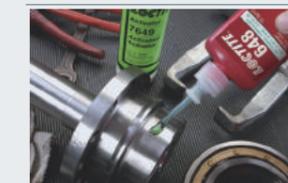
Recommended for parts that will need subsequent dismantling, i.e. retention of bearings onto shafts and into housings.



A high temperature retaining compound in a revolutionary semi-solid formula. Patented, no-mess package offers added convenience and portability. Ideal for gaps up to 0.005" (0.1 mm) on the diameter. Withstands temperatures to 400°F (204°C).



Maximum strength. For use where high dynamic force or cyclic loading is expected. Offers high temperature performance and oil tolerance.



Press Fit/High Strength/Rapid Cure. Offers high temperature performance and oil tolerance.

**LOCTITE®**  
**BONDERITE®**  
**TECHNOMELT®**  
**TEROSON®**  
**AQUENCE®**

Henkel products are designed to meet the specifications and testing standards of a variety of agencies. Because such standards change or may be modified, no warranty is given regarding such compliance. The information provided may be used as a quick reference tool to aid in design or application. For up-to-the-minute information on agency approvals, or to inquire about additional agency approvals, please contact Henkel Product Management team or local Technical Support team.

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