

Parker Adhesive Applications Guide

| | Parker Product | Used in similar applications to Loctite: | Example Application | Viscosity | Breakaway Torque | Color | Partial Cure (as noted) | Total Cure (as noted) | Working Temperature °F (°C) | Available Sizes |
|---------------------|----------------|--|--|-----------|------------------|--------|-------------------------|-----------------------|-----------------------------|-----------------|
| Threadlockers | TL22 | 221 | Frequent disassembly, small diameter screws, flat head bolt locking, adjustment, and calibration screws. Use up to 1.50 in. thread diameter | Low | Low | Violet | 10-20 min. | 24 hrs. | -58 to 300 (-50 to 150) | 10g/50g |
| | TL55 | 242 | General use. Commonly used for pumps, compressors, gearboxes, machines and tooling which are periodically disassembled | Medium | Medium | Blue | 10-20 min | 24 hrs. | -58 to 300 (-50 to 150) | |
| | TL81 | 290 | High penetration and permanent assembly. Sealing porosities in porous metals, locking adjustment screws, preassembled items and other mounted parts up to .250 in. thread diameter | Very Low | High | Green | 10-20 min. | 24 hrs. | -58 to 390 (-50 to 200) | |
| | TL83 | 271 | Permanent assembly. Ideal for axle shafts, parts from vibratory machines, heavy equipment and security items | Low | High | Red | 10-20 min. | 24 hrs. | -58 to 300 (-50 to 150) | |
| | TL86 | 277 | Permanent assembly of large diameter stud bolts or screws. Ideal for axle shafts, parts from vibratory machines, heavy equipment and security items | High | High | Red | 10-20 min. | 24 hrs. | -58 to 300 (-50 to 150) | |
| Instant Adhesives | IA01 | 493 | Bonding metals with rubber and rigid surfaces. Good strength | Low | n/a | Clear | 1-20 sec. | 24 hrs. | -22 to 176 (-30 to 80) | 20g/100g |
| | IA04 | 495 | General purpose adhesive for bonding metals, rubbers and some plastics. Good strength | Medium | n/a | Clear | 1-20 sec. | 24 hrs. | -22 to 176 (-30 to 80) | |
| | IA06 | 496 | Bonding to any surface, including porous and flexible materials. Good strength | High | n/a | Clear | 1-20 sec. | 24 hrs. | -22 to 176 (-30 to 80) | |
| Retaining Compounds | RC81 | 601 | High temperature applications including bushings, bearings, oil, seals and pulleys | Low | High | Green | 3-20 min. | 24 hrs. | -58 to 390 (-50 to 200) | 10g/50g/250g |
| | RC83 | 640 | Interference fitting bushings, bearings, oil seals and pulleys | Medium | High | Green | 10-20 min. | 24 hrs. | -58 to 300 (-50 to 150) | |
| | RC84 | 638 | Loose fitting parts in high temperature applications. | High | High | Green | 3-20 min. | 24 hrs. | -58 to 300 (-50 to 150) | |
| Liquid Gaskets | GT21 | 573 | Thread Sealants | Low | Medium | Green | 150-180 min. | 24 hrs. | -58 to 300 (-50 to 150) | 50g/100g |
| | GG22 | 515 | Extra quick set time, gasketing gaps up to .031 in. , (0.8 mm) | Med-High | Low | Violet | 30-60 min. | 3 hrs. | -58 to 300 (-50 to 150) | |
| | GG23 | 574 | Gasketing, gaps up to .020 in.(0.5 mm) | Low | Medium | Orange | 150-180 min. | 24 hrs. | -58 to 300 (-50 to 150) | |
| | GT24 | 567 | Thread Sealants | High | Medium | White | 150-180 min. | 24 hrs. | -58 to 392 (-50 to 200) | |
| | GG25 | 518 | Gasketing, gaps up to .031 in. (0.8 mm) | High | Low | Red | 150-180 min. | 24 hrs. | -58 to 300 (-50 to 150) | |
| Surface Treatments | ST01 | 7452 | Activator to increase adhesion for Parker IA Series Instant Adhesives when used on inert plastics like PE, PP and Polyacetal | n/a | n/a | Clear | n/a | n/a | n/a | n/a |
| | ST02 | 7451 | Accelerator to reduce cure time for anaerobic Parker TL Series threadlockers & RC Series retaining compounds | n/a | n/a | Clear | n/a | n/a | n/a | |

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