Technical Data Sheet

H.B. Fuller | Engineering Adhesives

62TL

62TL is a medium viscosity red anaerobic adhesive for thread locking of large diameter studs, nuts and bolts of all types not requiring dismantling. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals. Permanent adhesion (may require heat to disassemble). Higher viscosity for improved coverage of larger threaded areas.

Technology / Base	Dimethacrylate Ester
Type of Product	Threadlocking Adhesive
Components	One Component
Curing	Anaerobic with Secondary Heat Cure
Appearance / Color	Red
Consistency	Thixotropic Liquid

Features and Benefits

- Threadlocking Large Diameter Studs, Nuts and Bolts Requiring Disassembly
- Highly Resistant to Corrosion, Vibrations, Water, Gases, Oils, Hydrocarbons, and Many Chemicals
- Thixotropic Liquid Reducing Sag Flow
- Prevents Fasteners from Loosening
- Prevents Rust and Corrosion

Technical Data

Physical Property	Value	Condition/Method
Uncured Material Characteristics		
Viscosity	2500 to 7500 cPs	Brookfield at 25°C, Spindle 3, 2 rpm
Specific Gravity	1.1	
Flash Point	> 93°C	
Shelf Life	12 months unopened	
Storage Condition	8 to 28°C	
Gap Fill	0.05 mm maximum	
Set Time on Steel	10 to 72 hours	
Handling Strength		
Functional Strength		
Solubility		
Full Cure Conditions	10 to 72 hours at room temperature, or 40°C bondline temperature for 1 hour to achieve ≥80% of strength on steel	
Cured Material Properties		
Coefficient of Thermal Expansion	80 ppm/K	ASTM D696
Thermal Conductivity	0.1 W/mK	ASTM C177
Specific Heat	0.3 kJ/kgK	
Breakaway Torque	14 to 29 N-m	ISO 10964
Prevailing Torque		
Breakloose Torque	25 to 50 N-m	DIN 54454
Pin/Collar Shear Strength		
Service Temperature	-55ºC to 150ºC	
Shear Strength		
Tensile Strength		
Pressure Resistance		

Cure Speed At Various Temperatures			% of Room Temperature Strength
	25%	**50%**	**100%**
5°C	6 hrs	8 hrs	
40°C	15 min	20 min	4 to 72 hrs

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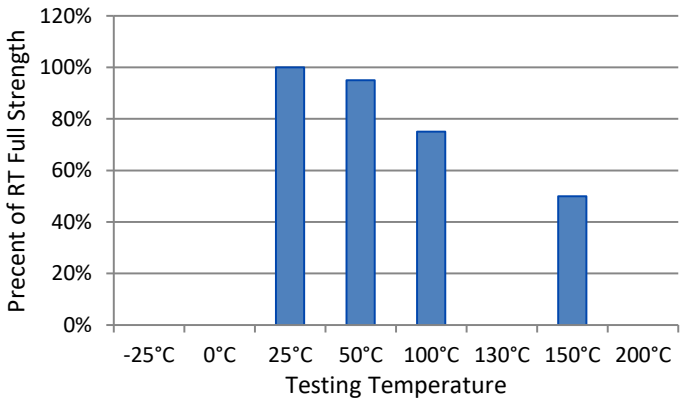
Physical Property		Value	Condition/Method
Cure Speed On Various Substrates			% of Room Temperature Strength
	25%	**50%**	**100%**
Steel	25 min	40 min	10 to 72 hrs
Stainless Steel	15 hrs		
Brass	30 min		
Zn Dichromate	25 min	40 min	10 to 72 hrs
Heat Aging Testing			
	2000 hrs at 120°C	65%	Room Temperature Strength
	2000 hrs at 150°C	25%	Room Temperature Strength
Cure Speed For Various Gap Sizes			% of Room Temperature Strength
	25%	**50%**	**100%**
0.05mm	20 min	40 min	12 to 72 hrs
0.25mm	9 hrs	24 hrs	
Chemical Resistance Testing			
	Test Temperature	% of Room Temperature Strength	Condition
50% Water/50% Glycol	87°C	85%	1000 hours measured at room conditions
Unleaded Gasoline	22°C	100%	1000 hours measured at room conditions
Motor Oil	125°C	75%	1000 hours measured at room conditions
Brake Fluid	22°C	100%	1000 hours measured at room conditions
Acetone	22°C	95%	1000 hours measured at room conditions

General Instructions

Surfaces to be bonded should be clean and dry and free of grease. Product should be applied in enough quantity to fill all engaged threads or gap. The product performs best in thin bond gaps. Very large gaps may create gaps that will affect the cure speed and overall strength. Good contact is essential. It is recommended to confirm compatibility of the product with all substrates prior to use. This product is not recommended for use with strong oxidizing materials. Where aqueous washing systems are used to clean the surfaces before bonding, these aqueous washes can affect the cure and performance of the adhesive. This product is not normally recommended for use on plastics, users must check compatibility of the product with such substrates.

Specifications

Hot Strength (%RT strength, tested at temperature)



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Storage

Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

Safety and Disposal

For complete safety and handling information, please refer to the appropriate Safety Data Sheets prior to using this product.

Curing Performance

The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

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