

Revised
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TECHNICAL DATA SHEETS

TORQUE 60 RC

Description:

Torque 60 RC is a high viscosity gap filling silver paste used between machinery parts to repair worn areas and restore correct fits. It repairs worn shaft and housing, bearing spinouts, wallowed keyways and splines, threaded parts. Highly resistant to heat, vibrations, corrosion, water, gas, oil hydrocarbons many chemicals

Properties of Uncured Product:

Composition	Urethane Methacrylate
Appearance	Grey paste
Specific Gravity (77°F/25°C g/ml)	1.13
Viscosity, Brookfield HBT (77°F/25°C mPa.s)	
Spindle TB- 0.5 rpm	1000000 to 2000000 mPa.s
Spindle TB- 5 rpm	150000 to 350000 mPa.s
Flash Point, TCC	>93°C
Shelf life at 20°C	1 year
Storage temperature	8° - 28°C

HEAT CURE

Typical heat cure conditions consist of heating and maintaining bondline at a temperature of 40°C and after one hour 100% of strength on steel is achieved.

CURE SPEED VS. SUBSTRATE

% Full strength	Steel	Aluminium
25		
50	25 min	2 hrs
100	2-72 hrs	

CURE SPEED VS. JOINT GAP

% Full strength	Gap 0,154mm	Gap 0,27mm
25	2 hrs	3 hrs
50	4 hrs	10 hrs
100		

CURE SPEED VS. TEMPERATURE

% Full strength	Temperature	
	4°C	40°C
25	2 hrs	4 min
50	4 hrs	7 min
100	20-72 hrs	1 hrs

Properties of Cured Product:

Functional strength at 24 hrs 20° on steel		
Shear Strength (ISO 10123)		15 to 30 N.m
Shear Strength (DIN 54452)		16 to 26 N.m
Coefficient of thermal expansion (ASTM D696)		80 X 10 ⁻⁶ 1/K
Thermal conductivity (ASTM C177)		0.1 W/Mk
Specific heat		0.3 Kj.Kg ⁻¹ K ⁻¹
Temperature range		-55° +150°C

ENVIRONMENTAL RESISTANCE

Hot strength at temperature

Test Temp. °C	% retained strength
-25°	100%
0°	100%
50°	90%
100°	65%

Heat aging

Samples aged 3000 hours at indicated temperature and tested at room temperature.

Test temp. °C	% retained strength
120°	155%
150°	170%

Chemical / Solvent Resistance

Specimens immersed for 1000 hrs at indicated temperature and tested at room temperature.

	Test Temp. °C	% retained strength
50/50 Water / Glycol	87	80
Unleaded Petrol	22	100
Motor Oil	125	100
Brake Fluid	22	75
Acetone	22	80

Engineering Excellence

For technical information
and support call **1-800-552-0299** or visit our website at

www.instantca.com