

Revised
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TECHNICAL DATA SHEETS

TORQUE 62TL

Description:

TORQUE 62TL is a medium viscosity anaerobic adhesive for thread locking of large diameter studs, nuts and bolts of all types that require to be dismantled. Highly resistant to heat, corrosion, vibrations, water, gases, oils, hydrocarbons and many chemicals.

PROPERTIES OF UNCURED PRODUCT (typical value)

Composition	Dimethacrylate ester
Appearance	Red, Fluorescent Liquid
Specific Gravity (77°F/25°C g/ml)	1.1
Viscosity, Brookfield (77°F/25°C mPa.s)	
Spindle 3- 2 rpm	2500 to 7500 mPa.s
Spindle 3 - 20 rpm	1200 to 2400 mPa.s
Flash Point, TCC	>93°C
Shelf life at 20°C	1 year
Storage temperature	8° - 28°C

PROPERTIES OF CURED PRODUCT (typical value)

	Functional strength at 24 hrs 20° on steel	
Breakaway torque (ISO 10964)		14 to 29 N.m
Breakloose torque (DIN 54454)		25 to 50 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%
50°	95%
100°	75%
150°	50%

Heat aging

Samples aged 2000 hours at indicated temperature and tested at room temperature.

Test temp. °C	% retained strength
120°	65%
150°	25%

Chemical / Solvent Resistance

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

	Test Temp. ° C	% retained
strength		
50/50 Water / Glycol	87	85
Leaded Petrol	22	100
Motor Oil	125	75
Brake Fluid	22	100
Acetone	22	95



TECHINCAL DATA SHEETS

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HEAT CURE

Typical heat cure conditions consist of heating and maintaining bondline at a temperature of 40°C and after one hour more than 80% of strength on steel is achieved.

CURE SPEED VS. SUBSTRATE

% Full strength	Steel	Brass	Stainless Steel
25	25 min	30 min	15 hrs
50	40 min		
100	10-72 hrs		

CURE SPEED VS. JOINT GAP

% Full strength	Gap 0,05mm	Gap 0,25mm
25	20 min	9 hrs
50	40 min	24 hrs
100	12- 72 hrs	

CURE SPEED VS. TEMPERATURE

% Full strength	Temperature	
	5°C	40°C
25	6 hrs	15 min
50	8 hrs	20 min
100		4 - 72 hrs

DIRECTIONS FOR USE

Use on clean and degreased parts. The product will cure correctly between close fitting flanged parts with gaps up to 0,05mm. Flanges should be tightened as soon as possible after assembly to avoid shimming.

GENERAL INFORMATION

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.

Engineering Excellence

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

www.instantca.com