

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	

Parker Hannifin Corporation
O-Ring Division
 2360 Palumbo Dr.
 Lexington, KY 40509

phone 859 269 2351
 fax 859 335 5128
 www.parker.com



ENGINEERING YOUR SUCCESS.