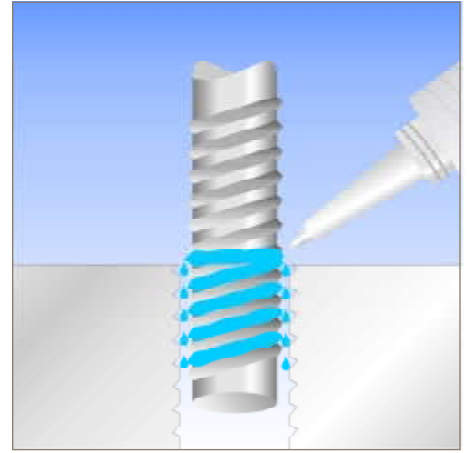


Threadlocker Anaerobic Adhesives

TL Series



Lock, Seal and Retain

Parker TL Series Anaerobic Adhesives are liquid resins that cure (in the absence of air) when placed in contact with metallic or threaded parts. They provide high resistance to pressure, vibration and fill 100% of gaps between parts enhancing the locking and sealing forces. Overflow is not likely to contaminate or obstruct the application and can be easily wiped away (as long as it is exposed to air) by using oils or polar solvents. Threadlockers are available in three levels of break away torque and are distinguished by force required by disassembly and viscosity.

The TL series adhesives are resistant to water, fuel, gases, oils, and other chemical products. They offer a wide temperature range (see properties chart on next page) and are used primarily in applications with screws, bolts, drop bolts, latch pulleys, gearboxes, busing, sleeves, bearings, valves, flanges, shafts and rotors.



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Product Features:

- Prevents loosening and leakage
- Solvent free
- No mixing, easy to use
- Quickly cures at room temperature
- Wide temperature range (see properties chart on next page)
- Resistant to major chemicals
- Cost Effective
- Creates barrier that prevents rust, oxidation and corrosion
- Can be dispensed manually, semi-automatically or automatically



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Usage Guidelines:

- Clean parts, completely eliminate oily and other contaminant particulates, such as rust, dust and previous adhesive from surfaces
- Can be applied directly from its original container
- Cover the entire surface to be bonded with the product to avoid failures on bond or seal
- Apply the product on one of the surfaces and rotate the piece in place three times to evenly spread the product
- Keep the container tightly closed to maintain product integrity

Set Time:

Initial cure occurs in less than 20 minutes, varying on the application,

components and gap fills it is used in. When using on large gaps or when the setting time is too long, it is recommended to use the Activator ST02 to accelerate cure speed.

General Information:

This product should not be used in pure high oxygen systems, nor is it recommended for use with chlorine or other oxidizers.

Storage:

- Store product in cool and dry location, in its original container, at 70°F (21°C)
- To avoid product contamination, do not return used product to original container
- Do not expose the product to excessive heat or direct sun light

Safety Precautions:

- While handling the product, use such personal protection devices as safety glasses and gloves
- In case of contact with eyes, wash with plenty of water and get medical attention if irritation persists
- In case of contact with skin, use a paper or tissue to remove excess and then wash with plenty of water and neutral soap. Get medical attention if skin irritation persists
- If clothes are contaminated, remove immediately to avoid prolonged contact, resulting in skin irritation
- Keep this industrial product out of the reach of children³

TL Series Typical Properties Chart

Parker Part Number	Color	Working Temperature	Activator Used	Gap Fill	Viscosity	Setting Time ¹		Torque		Torque
						Partial	Total	Breakaway	Prevail ²	
						Min.	Hrs.	N.m	N.m	
TL22	Violet	-58 to 302°F -50 to 150°C	ST02	0.12	(Low) 200 to 500	10 to 20	24	6 to 15	1 to 6	Low
TL55	Blue	-58 to 302°F -50 to 150°C	ST02	0.12	(Medium) 1500 to 2000	10 to 20	24	15 to 30	8 to 14	Medium
TL81	Green	-58 to 392°F -50 to 200°C	ST02	0.07	(Very Low) 8 to 12	10 to 20	24	30 to 70	18 to 40	High
TL83	Red	-58 to 302°F -50 to 150°C	ST02	0.20	(Low) 500 to 800	10 to 20	24	30 to 70	18 to 40	High
TL86	Red	-58 to 302°F -50 to 150°C	ST02	0.30	(High) 5000 to 7000	10 to 20	24	30 to 70	18 to 40	High

1. The setting time is strongly influenced by substrate, room temperature and presence of activators. Above data referred to substrate carbon steel in temperature of 72°F (22°C) without use of activators.
2. Refer to MSDS for additional information.

