

# Parker Adhesive Applications Guide

	Parker Part Number	Used in similar applications to:	Example Application	Specifications	Viscosity	Breakaway Torque	Color	Fixture Time	Total Cure (as noted)	Working Temperature °F
Threadlockers	TL22	Loctite 222	Low strength, easy to disassemble for often serviced applications. Best results on 1/4" bolts and smaller	ASTM D5363 GP1 CL5 GR2 MIL-S-46163 TY2 GR M	Low	Low	Purple	10 min.	8 hrs.	-60 to 300
	TL55	Loctite 242 Permatex 24250	Medium strength, may need air tools to disassemble. Commonly used in applications which are periodically disassembled	ASTM D5363 GP3 CL2 GR1 MIL-S-46163 TY2 GR N	Medium	Medium	Blue	10 min	8 hrs.	-60 to 300
	TL81	Loctite 290 Permatex 29050	Wicking grade for preassembled items. High strength, best results on fasteners smaller than 1/4"	ASTM D5363 GP2 CL6 GR1 MIL-S-46163 TY3 GR R	Very Low	High	Green	10 min.	8 hrs.	-60 to 300
	TL83	Loctite 271 Permatex 27150	High strength, low viscosity for applications which are rarely serviced. Best results on fasteners up to 1"	ASTM D5363 GP2 CL2 GR1 MIL-S-46163 TY1 GR K	Low	High	Red	10 min.	8 hrs.	-60 to 300
	TL85	Loctite 262 Permatex 26250	High strength, medium viscosity. Low assembly force as compared to TL86. Best results on fasteners 3/4 to 1 1/4"	ASTM D5363 GP3 CL3 GR1 MIL-S-46163 TY2 GR O	Medium	High	Red	10 min.	8hrs.	-60 to 300
	TL86	Loctite 277 Permatex 27750	High strength, high viscosity for permanent assembly. Best results on fasteners over 1"	ASTM D5363 GP2 CL1 GR1 MIL-S-46163 TY1 GR L	High	High	Red	10 min.	8 hrs.	-60 to 300
Instant Adhesives	IA01	Loctite 493	Wicking grade for preassembled items or broad, perfectly flat surfaces	MIL-A-46050C TY2 CL1	Very Low	n/a	Clear	< 5 seconds	8 hrs.	-65 to 200
	IA04	Loctite 495	General-purpose adhesive for bonding metal, rubber, and some plastics. Good strength for gaps up to .004"	MIL-A-46050C TY2 CL1	Medium	n/a	Clear	< 10 seconds	8 hrs.	-65 to 200
	IA06	Loctite 496 Permatex 40140	Bonding to any surface, including porous and flexible materials like wood and foam. Best for difficult to bond applications, fills gaps up to .006"	MIL-A-46050C TY2 CL2	High	n/a	Clear	< 8 seconds	8 hrs.	-65 to 200
	IA26	Loctite 414	General-purpose adhesive for bonding metal, rubber, and some plastics. Fills gaps up to .005"	MIL-A-46050C TY2 CL2	High	n/a	Clear	< 8 seconds	8 hrs.	-65 to 200
	IA28	Loctite 498	General-purpose adhesive for bonding metals, rubbers, and some plastics. Highest viscosity for large gaps up to .008"	MIL-A-46050C TY2 CL3	Very High	n/a	Clear	< 15 seconds	8 hrs.	-65 to 200
	IA96	Black Max	Rubber toughened instant adhesive, fills gaps up to .009". Excellent impact and shear resistance.	MIL-A-46050C TY2 CL3	Very High	n/a	Black	< 12 seconds	8 hrs.	-65 to 250
Retaining Compounds	RC81	Loctite 601 Permatex 60910	Low viscosity for press fit sleeves, races & bushings.	MIL-R-46082B TY1	Low	High	Green	10 min.	8 hrs.	-65 to 350
	RC83	Loctite 640 Permatex 64050	Interference fitting bushings, bearings, oil seals, and pulleys. Best product for extreme high temperature use	MIL-R-46082B TY2	Medium	High	Green	40 min.	8 hrs.	-65 to 450
	RC84	Loctite 638 Permatex 68050	High strength and viscosity for retaining loose fitting parts. Fills gaps up to .010"	n/a	High	High	Green	2 min.	8 hrs.	-65 to 350
Thread Sealant	GT21	Loctite 573	Thread Sealant, slow curing for maximum positioning time	n/a	Low	Medium	Green	90 min.	8 hrs.	-65 to 350
	GT24	Loctite 567 Permatex 56750	Thread Sealant, excellent for high temperature applications, low disassembly torque	n/a	High	Low	White	15 min.	8 hrs.	-60 to 450
	GT26	Loctite 565 & 592	Pipe Sealant, general purpose, works quickly and disassembles easily	n/a	Medium to High	Low	White	10 min.	8 hrs.	-60 to 350
	GT42	Loctite 545 Permatex 54550	Thread Sealant, no fillers for high pressure hydraulic systems	n/a	Low	Medium	Purple	15 min.	8 hrs.	-60 to 350
	GT82	Loctite 569	Thread Sealant, general purpose for fittings up to 3/4", works very well on fine threads	n/a	Very Low	Medium	Brown	10 min.	8 hrs.	-60 to 350
Instant Gaskets	GG22	Loctite 515 Permatex 51531	Quick set time, Gasketing gaps up to .035"	n/a	Medium to High	Low	Purple	15 min.	8 hrs.	-65 to 350
	GG23	Loctite 574	Fast set gasketing, gaps up to .020"	n/a	Low	Medium	Orange	5min.	6 hrs.	-65 to 350
	GG25	Loctite 518 Permatex 51813	Gasketing, gaps up to .050"	n/a	High	Low	Red	20 min.	8 hrs.	-65 to 350
Activators	ST01	Loctite 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	n/a	Clear	n/a	n/a	n/a
	ST02	Loctite 7451	Accelerator to reduce cure time for anaerobic Parker TL series threadlockers & RC series retaining compounds	n/a	n/a	n/a	Clear	n/a	n/a	n/a

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