



# Parker Adhesive Applications Guide

Parker Product	Parker Part Number	Used in similar applications to:	Example Application	Viscosity	Breakaway Torque	Color	Partial Cure (as noted)	Total Cure (as noted)	Working Temperature (F, C)	Available Sizes
Threadlockers	TL22	Loctite 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	Loctite 242 Permatex 24250	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	Loctite 290 Permatex 29050	High penetration and permanent assembly. Sealing porositels in porous metals. locking adjustment screws, preassembled items and other mounted parts up to .250 in. thread diameter	Very Low	Med-High	Green	10-20 min.	24 hrs.	-58 to 390 (-50 to 200)	
	TL83	Loctite 271 Permatex 27150	Permanent assembly. Ideal for axle shafts, parts from vibratory machines, heavy equipment and security items	Low-Med	High	Red	10-20 min.	24 hrs.	-58 to 300 (-50 to 150)	
	TL86	Loctite 277 Permatex 27750	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)	
	IA01	Loctite 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)	
Instant Adhesives	IA04	Loctite 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)	20g/100g
	IA06	Loctite 496 Permatex 40140	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	Loctite 601 Permatex 60910	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	Loctite 640 Permatex 64050	Interference fitting bushings, bearings, oil seals and pulleys	Medium	High	Green	10-20 min.	24 hrs.	-58 to 300 (-50 to 150)	
	RC84	Loctite 638 Permatex 68050	Loose fitting parts in high temperature applications.	High	High	Green	3-20 min.	24 hrs.	-58 to 300 (-50 to 150)	
	GT121	Loctite 573	Thread Sealants	Low	Medium	Green	150-180 min.	24 hrs.	-58 to 300 (-50 to 150)	
Thread Sealant	GT124	Loctite 567 Permatex 56750	Thread Sealants	High	Medium	White	150-180 min.	24 hrs.	-58 to 392 (-50 to 200)	50g
	GG22	Loctite 515 Permatex 51531	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	Loctite 574	Gasketing, gaps up to .020 in.(0.5 mm)	Low	Medium	Orange	150-180 min.	24 hrs.	-58 to 300 (-50 to 150)	
Instant Gasket	GG25	Loctite 518 Permatex 51813	Gasketing, gaps up to .031 in. (0.8 mm)	High	Low	Red	150-180 min.	24 hrs.	-58 to 300 (-50 to 150)	100g
	ST01	Loctite 7452	Activator to increase adhesion for Parker IA Series Instant Adhesives when used on inert plastics like PE, PP and Polyacetel	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	Clear	n/a	n/a	n/a	

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