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## TECHNICAL DATA SHEETS

### TORQUE 72TL

#### Description:

**TORQUE 72TL** is a very high temperature (+230° C) resistant, high strength anaerobic adhesive for locking and sealing thread connections and fitted parts. High viscosity and thixotropic effect allows larger tolerances. Highly resistant to corrosion, vibrations, water, gases, oils, hydrocarbons, and many chemicals.

#### PROPERTIES OF UNCURED PRODUCT (typical value)

Composition	Dimethacrylate ester
Appearance	Opaque Red/ Orange
Specific Gravity (77°F/25°C g/ml)	1.11
Viscosity, Brookfield (77°F/25°C mPa.s)	
Spindle 4- 20 rpm	4000 - 15000 mPa.
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)	18-28 N.m
Prevail torque (ISO 10964)	20-31 N.m
Coefficient of thermal expansion (ASTM D696)	80 X 10 <sup>-6</sup> 1/K
Thermal conductivity (ASTM C177)	0.1 W/Mk
Specific heat	0.3 Kj.Kg <sup>-1</sup> K <sup>-1</sup>
Temperature range	-55° +150°C

#### ENVIRONMENTAL RESISTANCE

##### Hot strength at temperature

Test. Temp. °C	% retained strength
20°	100%
50°	90%
100°	85%
150°	75%

##### Chemical / Solvent Resistance

Specimens immersed for 30 days at indicated temperature and tested at room temperature.

	Test Temp. ° C	% retained strength
Water	87	58
Gasoline	87	62
Motor Oil	87	62
Isopropyl Alcohol	87	87
Toluene	87	80



# TECHINCAL DATA SHEETS

## TORQUE 72TL



### HEAT CURE

Ty heating and maintaining bondline at a temperature of 40°C and after one hour than 100% of strength on steel is achieved.

### CURE SPEED VS. SUBSTRATE

% Full strength	Steel	AS Received Steel	Zn Dichromate
25	2 hrs	3 hrs	12 hrs
50	3 hrs	24 hrs	
100	20-72 hrs		

### CURE SPEED VS. TEMPERATURE

% Full strength	Temperature	
	5°C	40°C
25	2 hrs	8 min
50	4 hrs	15 min
100	65-72 hrs	1 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 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***