

CALTRANS-APPROVED ANAEROBIC THREAD LOCKING SYSTEMS

Each Caltrans-approved anaerobic thread locking system requires 3 components:

1. **CLEANER** - to clean lubricant and oils from the threads of the stud and nut.
2. **PRIMER** - to promote rapid curing of the anaerobic compound and to minimize migration of compound on threads.
3. **ANAEROBIC THREAD LOCKING ADHESIVE** - to secure nut onto stud by filling the gap between nut and stud threads. Note: Anaerobic thread locking adhesive compounds will set only where no oxygen is available.

All components used in a single thread locking application shall be from one of the systems below and from the same thread locking adhesive manufacturer, following the Manufacturer's Application Instructions for Caltrans-Approved Anaerobic Thread Locking Systems.

| Approved Anaerobic Thread Locking Systems | | | |
|--|------------------|---|--------------|
| Manufacturer Information | Component | Trade Name | Part No. |
| Loctite (Industrial Division) 1 Henkel Way Rocky Hill, CT 06067 (800) 562-8483 www.loctite.com | Cleaner | ODC-Free Cleaner & Degreaser | 22355 |
| | Primer | Loctite 7649 | 21348 |
| | Adhesive | Loctite 262 | 26243 |
| Permabond International 480 South Dean Street Englewood, NJ 07631 (800) 370-9647 www.permabond.com | Cleaner & Primer | Perma-Lok Anaerobic Surface Conditioner | ASC10 |
| | Adhesive | Permabond HH120 | HH120 |
| Hernon Manufacturing, Inc. 121 Tech Drive Sanford, FL 32771 (800) 527-0004 www.hernonmfg.com | Cleaner | Hernon Cleaner 62 | EF-62 |
| | Primer | Hernon EF Primer 49 or 50 | EF-49, EF-50 |
| | Adhesive | Hernon Nuts N' Bolts Anaerobic Adhesive | 429 |
| Saf-T-Lok 300 Eisenhower Lane North Lombard, IL 60148 (630) 495-2001 www.saftlok.com | Cleaner & Primer | Primer T | 19166 |
| | Adhesive | T77 High Strength Permanent Thread Locker | 27741 |
| Pacer Industrial 9420 Santa Anita Avenue Rancho Cucamonga, CA 91730 www.supergluecorp.com/pacer-industrial | Cleaner | Acetone | - |
| | Primer | Pacer Technology Anaerobic Primer | FG09621 |
| | Adhesive | ANL-77 Anaerobic Adhesive | FG 06150 |

Table 1: Approved Anaerobic Thread Locking System.

1. Follow Manufacturer's instructions for use.
2. For any special requirements, consult with an engineer.
3. Part numbers may vary based on amount of product purchased.