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STANDARD

10964

First edition
1993-08-15

Adhesives — Determination of torque strength of anaerobic adhesives on threaded fasteners

Adhésifs — Détermination des couples fonctionnels sur des fixations filetées collées avec des adhésifs anaérobies



Reference number
ISO 10964:1993(E)

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 10964 was prepared by Technical Committee ISO/TC 61, *Plastics*, Sub-Committee SC 11, *Products*.

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Adhesives — Determination of torque strength of anaerobic adhesives on threaded fasteners

1 Scope

The test method described in this International Standard is used to make comparative assessments of the securing or locking effect of anaerobic adhesives used in threaded assemblies. This method may be used for other types of adhesives, if considered suitable.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 291:1977, *Plastics — Standard atmospheres for conditioning and testing*.

ISO 898-1:1988, *Mechanical properties of fasteners — Part 1: Bolts, screws and studs*.

ISO 898-2:1992, *Mechanical properties of fasteners — Part 2: Nuts with specified proof load values — Coarse thread*.

3 Definitions

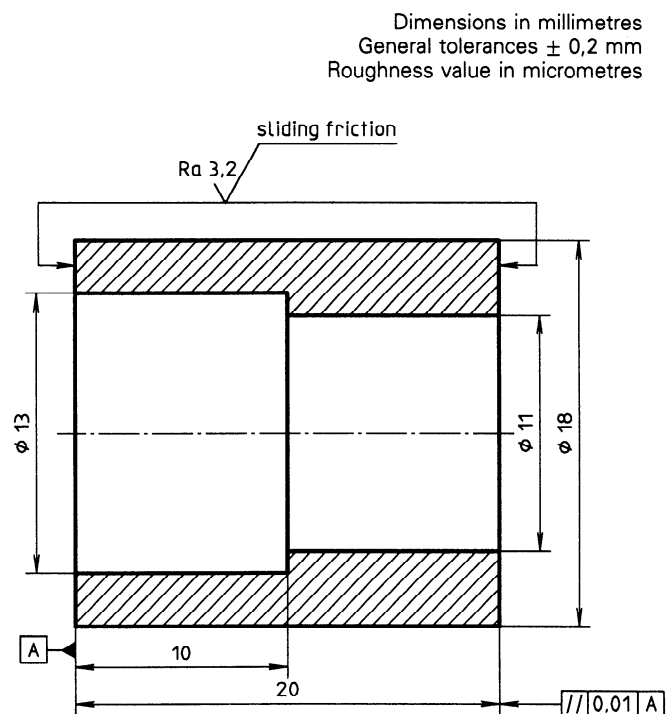
For the purposes of this International Standard, the following definitions apply.

3.1 on torque, T_{ON} : Maximum torque required to screw the nut onto a bolt precoated with adhesive.

3.2 input torque, T_{IN} : Torque applied to introduce or increase the axial load in the assembly.

It is used to overcome friction in the thread and under the bolt head.

3.3 breakaway torque, T_{BA} : Initial torque required to break the bond measured at the first movement between the nut and the bolt, when unscrewing an unseated assembly (without spacer sleeve, see figure 1).



47 HRC to 50 HRC hardness carbon steel.
Surface condition: corrosion and grease-free.

Figure 1 — Spacer sleeve

3.4 breakloose torque, T_{BL} : Initial torque required to decrease or eliminate the axial load in a preloaded assembly.