

INTERNATIONAL  
STANDARD

**ISO**  
**10964**

First edition  
1993-08-15

---

---

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

**iTeh STANDARD PREVIEW**

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

[ISO 10964:1993](https://standards.iso.org/standards/catalog/standards/sist/f76ee66d-7945-4117-8386-32350fc3ae2c/iso-10964-1993)

[https://standards.iteh.ai/catalog/standards/sist/f76ee66d-7945-4117-8386-  
32350fc3ae2c/iso-10964-1993](https://standards.iteh.ai/catalog/standards/sist/f76ee66d-7945-4117-8386-32350fc3ae2c/iso-10964-1993)



Reference number  
ISO 10964:1993(E)

## 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*.

[ISO 10964:1993](#)

<https://standards.iteh.ai/catalog/standards/sist/f76ee66d-7945-4117-8386-32350fc3ae2c/iso-10964-1993>

© ISO 1993

All rights reserved. No part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from the publisher.

International Organization for Standardization

Case Postale 56 • CH-1211 Genève 20 • Switzerland

Printed in Switzerland

# 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.

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).

## 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*.

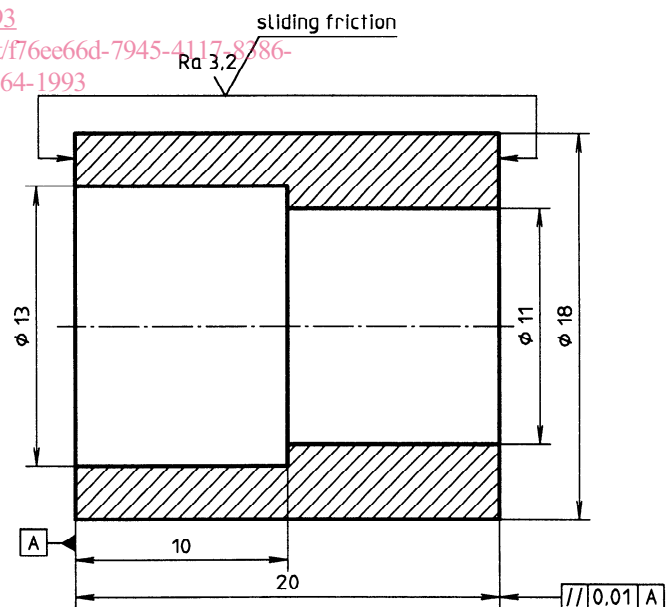
## 3 Definitions

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.

Dimensions in millimetres  
General tolerances  $\pm 0,2$  mm  
Roughness value in micrometres



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.

**3.5 prevailing torque,  $T_p$ :** Torque measured after the initial breakage of the bond at a specified angle of rotation of the nut. For testing against a specification, the angle shall be  $180^\circ$ .

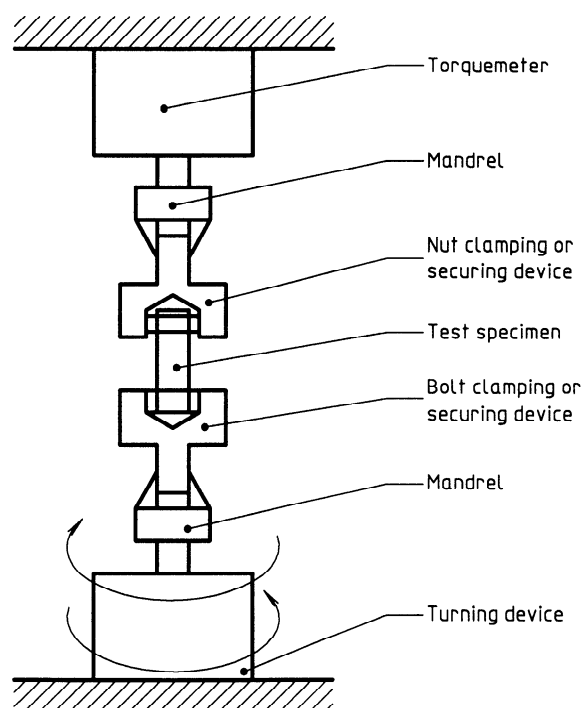
#### NOTES

1 A round-robin test program, recently performed, showed there is no significant difference between prevailing torque measured at  $180^\circ$  and prevailing torque determined as the mean of the four torque readings determined at  $90^\circ$ ,  $180^\circ$ ,  $270^\circ$  and  $360^\circ$ .

2 For quality control or purposes other than testing the adhesive against a specification, other angles may be agreed between the manufacturer and the purchaser of the adhesive.

If prevailing torque is measured at an angle other than  $180^\circ$ , the angle shall be denoted by a subscript; i.e.  $T_{360}$ . Otherwise, prevailing torque measured at  $180^\circ$  shall be designated by  $T_p$ .

NOTE 3 The prevailing torque can be defined as  $T_{max}$  when not testing to a specification,  $T_{max}$  being the maximum torque measured within the first  $360^\circ$  rotation of the nut after the initial breakage of the bond.



**Figure 2** — Example of test apparatus with graphic recording  
(standards.iteh.ai)

## 4 Principle

The test method consists of determining the torque required to unscrew a bonded nut and bolt assembly, including the initial torque required to break the bond, and the torque measured after turning the nut  $180^\circ$ . The torque strengths are determined for unseated assemblies and for seated assemblies preloaded with a specified input torque.

## 5 Apparatus

**5.1 Test machine with graphic recording,** consisting of a clamping device to secure the bolt head, a device for turning the nut at a constant speed, a torque-measuring device (see figure 2) and a recorder with a response time of 1 ms or less.

If a recorder is not used, a data storage system shall be employed so that the torque data as a function of the angle of turning can be recalled and plotted at a later time.

**5.2 Test machine with direct reading,** consisting of a clamping device to secure the head of the bolt, and a torque wrench accurate to  $\pm 5\%$  (see figure 3).

## 6 Test specimens

**6.1** For testing against a specification, the test specimen shall be an M10  $\times$  38, property class 8.8, zinc-phosphated steel bolt and a similar M10 nut, specified in ISO 898-1 and ISO 898-2.

NOTE 4 Any size and surface finish of fastener combination may be used by agreement between the interested parties.

All fasteners used in unseated assemblies shall have a radial gap of 0,1 mm to 0,2 mm on the minor diameter. The cutting oil used in their manufacture shall be lanolin-free.

**6.2** Degrease all nuts and bolts in a permitted cleaning medium, store in a desiccator at  $23^\circ\text{C} \pm 2^\circ\text{C}$ , and keep them clean. Use degreased specimens within four days or discard.

**6.3** The specimens shall be conditioned and tested in one of the standard laboratory atmospheres specified in ISO 291, which shall be stated in the test report.

# 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.

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).

## 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*.

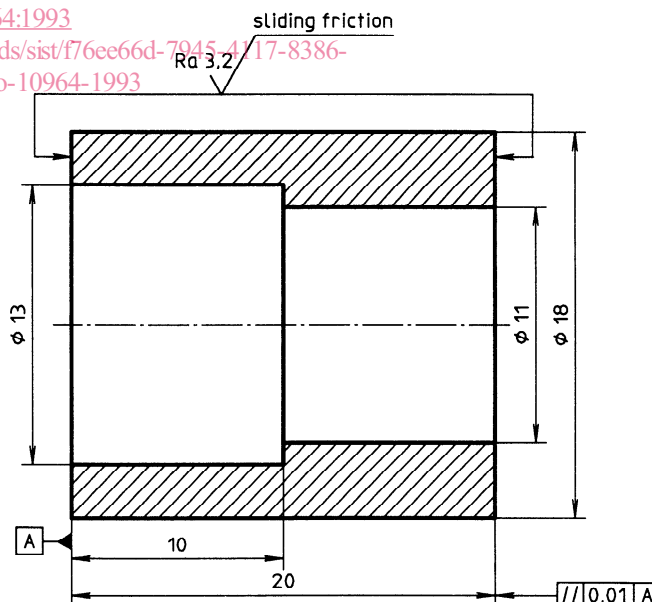
## 3 Definitions

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.

Dimensions in millimetres  
General tolerances  $\pm 0,2$  mm  
Roughness value in micrometres



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.

**3.5 prevailing torque,  $T_p$ :** Torque measured after the initial breakage of the bond at a specified angle of rotation of the nut. For testing against a specification, the angle shall be  $180^\circ$ .

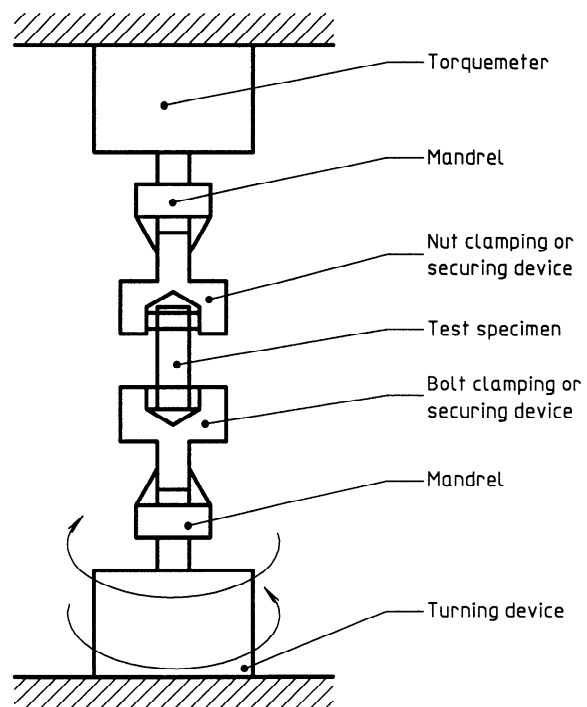
#### NOTES

1 A round-robin test program, recently performed, showed there is no significant difference between prevailing torque measured at  $180^\circ$  and prevailing torque determined as the mean of the four torque readings determined at  $90^\circ$ ,  $180^\circ$ ,  $270^\circ$  and  $360^\circ$ .

2 For quality control or purposes other than testing the adhesive against a specification, other angles may be agreed between the manufacturer and the purchaser of the adhesive.

If prevailing torque is measured at an angle other than  $180^\circ$ , the angle shall be denoted by a subscript; i.e.  $T_{360}$ . Otherwise, prevailing torque measured at  $180^\circ$  shall be designated by  $T_p$ .

NOTE 3 The prevailing torque can be defined as  $T_{max}$  when not testing to a specification,  $T_{max}$  being the maximum torque measured within the first  $360^\circ$  rotation of the nut after the initial breakage of the bond.



**Figure 2** — Example of test apparatus with graphic recording  
(standards.iteh.ai)

## 4 Principle

The test method consists of determining the torque required to unscrew a bonded nut and bolt assembly, including the initial torque required to break the bond, and the torque measured after turning the nut  $180^\circ$ . The torque strengths are determined for unseated assemblies and for seated assemblies preloaded with a specified input torque.

## 5 Apparatus

**5.1 Test machine with graphic recording,** consisting of a clamping device to secure the bolt head, a device for turning the nut at a constant speed, a torque-measuring device (see figure 2) and a recorder with a response time of 1 ms or less.

If a recorder is not used, a data storage system shall be employed so that the torque data as a function of the angle of turning can be recalled and plotted at a later time.

**5.2 Test machine with direct reading,** consisting of a clamping device to secure the head of the bolt, and a torque wrench accurate to  $\pm 5\%$  (see figure 3).

## 6 Test specimens

**6.1** For testing against a specification, the test specimen shall be an M10  $\times$  38, property class 8.8, zinc-phosphated steel bolt and a similar M10 nut, specified in ISO 898-1 and ISO 898-2.

NOTE 4 Any size and surface finish of fastener combination may be used by agreement between the interested parties.

All fasteners used in unseated assemblies shall have a radial gap of 0,1 mm to 0,2 mm on the minor diameter. The cutting oil used in their manufacture shall be lanolin-free.

**6.2** Degrease all nuts and bolts in a permitted cleaning medium, store in a desiccator at  $23^\circ\text{C} \pm 2^\circ\text{C}$ , and keep them clean. Use degreased specimens within four days or discard.

**6.3** The specimens shall be conditioned and tested in one of the standard laboratory atmospheres specified in ISO 291, which shall be stated in the test report.

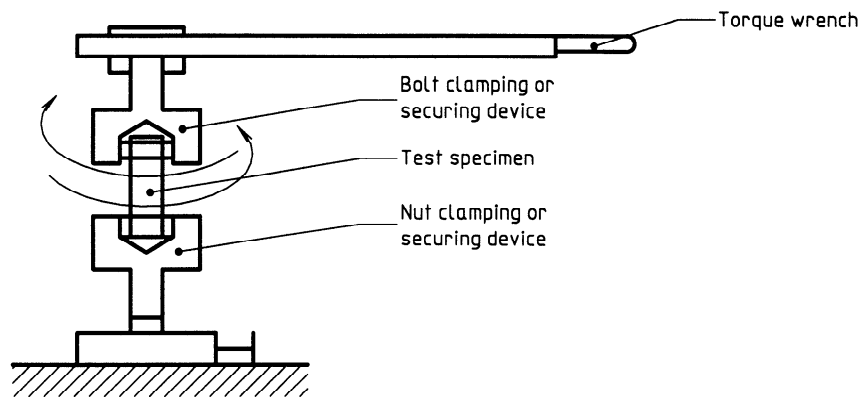


Figure 3 — Example of test apparatus with direct reading

## 7 Application of adhesive

7.1 Nuts and bolts shall be preassembled prior to application of the adhesive. Any pairs showing sticking due to burrs or damaged threads shall be discarded. Disassemble the parts.

7.2 Apply sufficient adhesive to the bolt to completely cover an area equal to the height of the nut plus two threads. Also apply adhesive to the threads of the nut.

## 8 Assembly

8.1 Assemble not less than five specimens for each test according to 8.2 or 8.3.

8.2 For unseated assemblies, screw the nut onto the bolt by hand allowing two threads to protrude. For preapplied adhesive, screw the nut onto the coated bolt using the apparatus in 5.1 or 5.2 and record the on torque. Allow two coated threads to protrude (see figure 4).

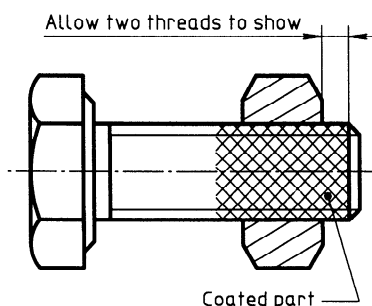


Figure 4 — Unseated assembly

8.3 For seated assemblies, screw the nut onto the bolt by hand until the nut strikes the spacer sleeve. Using the apparatus described in 5.1 or 5.2, apply the input torque to load the assembly (see figure 5).

NOTE 5 The preferred input torque is 40 N·m.

iTeh STANDARD PREVIEW

(standards.iteh.ai)

ISO 10964:1993

<https://standards.iteh.ai/catalog/standards/sist/f76ee66d-7945-4177-8386-32350fc3ae2c/iso-10964-1993>

32350fc3ae2c/iso-10964-1993

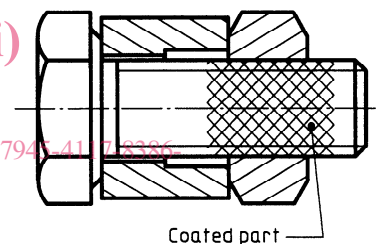


Figure 5 — Seated assembly

8.4 Cure the adhesive in accordance with the adhesive manufacturer's instructions, with the test specimens standing vertically on the bolt heads.

## 9 Test procedure

9.1 Secure the bolt head in the clamping device and unscrew the nut at a constant speed. The speed of testing shall be given in the test report.

NOTE 6 The preferred speeds are 2 rpm or 5 rpm or 10 rpm. While it is recognized that a truly constant test speed using a torque wrench as specified in 5.2 cannot be achieved, experience has shown that a specified testing speed can be closely approximated if care is taken to do so.

9.2 Record the breakaway torque or breakloose torque and the prevailing torque in N·m, as measured on the graphic recording equipment or from a direct reading if a torque wrench is used. If graphic record-



ing equipment is used, breakaway and breakloose torques shall be measured at the point on the curve of initial deviation from linearity.

## **10 Precision**

The precision of this test method is not known because interlaboratory data are not available. When interlaboratory data are obtained, a precision statement will be added at the time of revision.

## **11 Test report**

The test report shall contain the following information:

- a) reference to the present International Standard;
- b) all information necessary for complete identification of the adhesive tested, including type, source, date of manufacture, manufacturer's code number, batch or lot number, and form;
- c) specimen size used;
- d) method of cleaning and surface preparation prior to bonding;
- e) application and bonding conditions used in preparing the specimens;
- f) conditioning procedure used for specimens prior to testing, and test atmosphere;
- g) number of specimens tested;
- h) testing speed;
- i) input torque;
- j) test equipment and recording mode;
- k) average values and standard deviations determined for breakaway torque, breakloose torque and prevailing torque.

# **iTeh STANDARD PREVIEW** **(standards.iteh.ai)**

[ISO 10964:1993](https://standards.iteh.ai/catalog/standards/sist/f76ee66d-7945-4117-8386-32350fc3ae2c/iso-10964-1993)

<https://standards.iteh.ai/catalog/standards/sist/f76ee66d-7945-4117-8386-32350fc3ae2c/iso-10964-1993>



**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

This page intentionally left blank

[ISO 10964:1993](#)

<https://standards.iteh.ai/catalog/standards/sist/f76ee66d-7945-4117-8386-32350fc3ae2c/iso-10964-1993>