



Designation: D 5363 – 03^{ε1}

Standard Specification for Anaerobic Single-Component Adhesives (AN)¹

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This standard has been approved for use by agencies of the Department of Defense.

^{ε1} NOTE—Editorial corrections were made in Table 1 and footnote 1 in Table AN in August 2006.

1. Scope

1.1 This specification covers single-component anaerobic adhesives suitable for locking, sealing, and retaining threaded or cylindrical assemblies. The adhesives are cured to a solid state when confined between closely fitting active metal surfaces.

1.2 This specification is intended to be a means of classifying anaerobic adhesives. It is not intended for engineering design purposes.

1.3 This specification is intended to replace Military Specifications MIL-S-22473, MIL-S-46163, and MIL-R-46082.

1.4 The values stated in SI units are to be regarded as the standard.

1.5 The following safety hazards caveat pertains only to the test methods portion, Section 7, of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

- A 109/A 109M Specification for Steel, Strip, Carbon (0.25 Maximum Percent), Cold-Rolled
- B 36/B 36M Specification for Brass Plate, Sheet, Strip, and Rolled Bar
- B 209 Specification for Aluminum and Aluminum-Alloy Sheet and Plate
- B 633 Specification for Electrodeposited Coatings of Zinc on Iron and Steel
- D 56 Test Method for Flash Point by Tag Closed Cup Tester

D 439 Specification for Automotive Gasoline³

D 445 Test Method for Kinematic Viscosity of Transparent and Opaque Liquids (and Calculation of Dynamic Viscosity)

D 770 Specification for Isopropyl Alcohol

D 907 Terminology of Adhesives

D 1084 Test Methods for Viscosity of Adhesives

D 1193 Specification for Reagent Water

D 2693 Specification for Ethylene Glycol

D 3951 Practice for Commercial Packaging

D 4562 Test Method for Shear Strength of Adhesives Using Pin-and-Collar Specimen

D 4800 Guide for Classifying and Specifying Adhesives

D 5648 Test Method for Torque-Tension Relationship of Adhesives Used on Threaded Fasteners (Lubricity)

D 5649 Test Method for Torque Strength of Adhesives Used on Threaded Fasteners

D 5657 Test Method for Fluid Tightness Ability of Adhesives Used on Threaded Fasteners

E 122 Practice for Calculating Sample Size to Estimate, With a Specified Tolerable Error, the Average for a Characteristic of a Lot or Process

2.2 Military Standards:

MIL-STD-105 Sampling Procedures and Tables for Inspection by Attributes⁴

MIL-STD-129 Marking for Shipment and Storage⁴

MIL-STD-810 Environmental Test Methods and Engineering Guides⁴

MIL-STD-118 Commercial Packaging of Supplies and Equipment⁴

2.3 Federal Standards:

FED-STD-313 Material Safety Data Sheets, Preparation and Submission of⁴

2.4 Federal Specifications:

FF-N-836 Nut: Square, Hexagon, Cap, Slotted, Castle, Knurled, Welding and Single Ball Seat⁴

¹ This specification is under the jurisdiction of ASTM Committee D14 on Adhesives and is the direct responsibility of Subcommittee D14.60 on Adhesive Material Classification System.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Withdrawn.

⁴ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, http://www.dodssp.daps.mil.

PPP-B-636 Box, Shipping, Fiberboard ⁴
 QQ-P-416 Plating, Cadmium, Electrodeposited ⁴

2.5 Military Specifications:

MIL-R-46082 Retaining Compounds, Single-Component, Anaerobic ⁴
 MIL-S-22473 Sealing, Locking, Retaining Compounds; Single-Component ⁴
 MIL-S-46163 Sealing, Lubricating, and Wicking Compounds: Thread-Locking, Anaerobic, Single-Component ⁴
 MIL-T-5624 Turbine Fuel, Aviation, Grades JP-4 and JP-5 ⁴

2.6 U.S. Department of Transportation (DOT):

Code of Federal Regulations, Parts 100 to 199, Department of Transportation Rules and Regulations for the Transportation of Explosives and Other Dangerous Articles ⁵

2.7 Society of Automotive Engineers:

SAE J311 Fluid for Passenger Care Type Automatic Transmissions, Information Report ⁶
 SAE J429 Mechanical and Material Requirements for Externally Threaded Fasteners ⁶
 SAE AMS 2629 Jet Reference Fuel ⁶

3. Terminology

3.1 *Definitions*—Some terms in this specification are defined in Terminology D 907.

3.1.1 *active metal surface, n*—relative to anaerobic adhesives, a metal surface that initiates the formation of free radicals within anaerobic adhesives.

3.1.2 *anaerobic adhesive, n*—an adhesive that is kept in the uncured state by oxygen, as in air, and that cures in the absence of oxygen when exposed to metal ions, especially copper or iron.

3.1.3 *Newtonian behavior, n*—the property of a liquid in which its viscosity is constant over a stated range of strain rates. (Compare *non-Newtonian behavior*.)

3.1.4 *non-Newtonian behavior, n*—the property of a liquid in which its viscosity is not constant over a stated range of strain rates. (Compare *Newtonian behavior*.)

3.1.5 *thixotropy, n*—in a liquid, the property of thinning when subjected to strains greater than the yield strain and of rethickening with time upon subsequent rest.

3.1.5.1 *Discussion*—The liquid must exhibit yield to be thixotropic. If the liquid is deformed more than the yield strain, the underlying elastic network is disrupted and its viscosity is reduced. The network reestablishes itself in time when at rest.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *breakaway torque*—the initial torque required to break the bond, measured at the first movement between the nut and the bolt, when unscrewing an unseated assembly.

3.2.2 *prevailing torque, n*—the torque measured at 180° rotation of the nut.

3.2.2.1 *Discussion*—Prevailing torque was originally defined in MIL-S-46163 and MIL-S-22473 as the average of the four torques measured at 90, 180, 270, and 360° rotation of the

nut. Studies have shown that the torque measured at 180° rotation of the nut is statistically equivalent to the average of the torque measured at the four ¼ turns. Since measuring the torque at the one angle of rotation is more efficient, prevailing torque is most often defined as the torque measured at 180° rotation of the nut. However, for purposes of this specification, the definition of prevailing torque as the average of the four torques measured at 90, 180, 270, and 360° rotation of the nut is also acceptable.

4. Classification

4.1 Anaerobic adhesives are classified into groups in accordance with their performance properties. These groups are subdivided into classes and grades, as shown in Table AN.

NOTE 1—For example, the designation AN 0411 would indicate:

AN	=	anaerobic adhesive (from Guide D 4800),
04 (Group)	=	retaining compound,
1 (Class)	=	low strength, and
1 (Grade)	=	viscosity of 100–500 mPa.

5. Requirements

5.1 *General Requirements*—General requirements are properties that are inherent in every lot of adhesive produced, but may be tested in accordance with Table AN at a frequency agreed on by the purchaser and the manufacturer in order to verify specification conformance.

5.1.1 *Ultraviolet Fluorescence*—The uncured adhesive shall fluoresce under ultraviolet illumination when tested in accordance with 7.1.

5.1.2 *Color and Workmanship*—The color supplied shall be the color for the given group, class, and grade, as specified in Table AN. The uncured adhesive shall be smooth and homogeneous after shaking, free from lumps, caked material, and particles of foreign matter when examined in accordance with 7.2.

5.1.3 *Flash Point*—The uncured adhesive shall have a flash point above 93°C when tested in accordance with 7.3.

5.1.4 *Storage Stability*—The strength shall conform to the properties specified for the given class in Table AN. The viscosity shall increase no more than 50 % above the uppermost limit for the given grade in Table AN when tested in accordance with 7.12.

5.1.5 *Toxicity*—The supplier shall furnish a Material Safety Data Sheet (MSDS) in accordance with FED-STD-313 so that the user can evaluate the safety of the material for the proposed use.

5.1.6 *Solvent Resistance*—The average strength of each adhesive, after solvent immersion testing in accordance with 7.11, shall meet the requirements specified for the given class in Table AN.

5.1.7 *Hot Strength*—The average strength of each adhesive, after hot-strength testing in accordance with 7.8, shall meet the requirements specified for the given class in Table AN.

5.1.8 *Heat Aging*—The average strength of each adhesive, after heat-aging testing in accordance with 7.9, shall meet the requirements specified for the given class in Table AN.

⁵ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, <http://www.access.gpo.gov>.

⁶ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

TABLE 1 Wicking Requirements for Group 02 Products, N · m min

	Pretorqued		Non-Pretorqued			
	Steel	Plated	Steel		Plated	
	Prevail	Prevail	Break	Prevail	Break	Prevail
Class 4	1.1	0.6	1.1	1.1	0.6	0.6
Class 5	5.6	0.8	1.1	5.6	0.8	0.8
Class 6	8.5	4.2	1.1 †	8.5	0.6	4.2

† N·m value for Class 6 was corrected editorially.

TABLE 2 Cure Time for Speed-of-Cure Test

Group	Class	Time
01	all	6 h
02	1, 2, 3	90 min
02	4, 5, 6	15 min
03	all	60 min

TABLE 3 Primer Qualification Requirements % of Strength at Standard Conditions

Grade N		Grade T			
Plated		Steel		Plated	
Cure	Strength	Cure	Strength	Cure	Strength
6 h	50 %	10 min	50 %	30 min	50 %
24 h	100 %	40 min	100 %	2 h	100 %

5.1.9 *Cold Strength*—The average strength of each adhesive, after cold-strength testing in accordance with 7.10, shall meet the requirements specified for the given class in Table AN.

5.1.10 *Lubricity*—Group 03 products shall show lubricity on the thread flanks to within $\pm 10\%$ of an as-received phosphate and oil, $\frac{3}{8}$ in.-16 grade 5 bolt, when tested in accordance with 7.14.

5.1.11 *Fluid Tightness*—Groups 01, 02, and 03 products shall be capable of making leak-tight assemblies when tested in accordance with 7.15.

5.1.12 *Wicking*—The average breakaway and prevailing torque strength for Group 02, Class 4, 5, and 6 products, when tested in accordance with 7.16, shall meet the requirements specified in Table 1.

5.2 *Detail Requirements*—Detail requirements are properties which are adjusted in each lot of adhesive produced to provide different groups, classes, and grades, and are tested on every lot in accordance with Table AN to verify specification conformance.

5.2.1 *Viscosity*—The uncured adhesive shall have a viscosity within the range given in Table AN for the grade specified when tested in accordance with 7.4.

5.2.2 *Speed of Cure*—The average strength of each adhesive, when tested in accordance with 7.7, shall meet the requirements specified for the given class in Table AN.

5.2.3 *Strength at Standard Conditions*—Standard conditions are 21 to 25°C (69.8 to 77°F) and 45 to 55 % relative humidity.

5.2.3.1 *Groups 01, 02, and 03 Products*—The average strength of each adhesive, when tested in accordance with 7.5, shall meet the requirements specified for the given class in Table AN.

5.2.3.2 *Group 04 Products*—The minimum strength of each adhesive, when tested in accordance with 7.6, shall meet the requirements specified for the given class in Table AN.

6. Other Requirements

6.1 *Suffixes*—When requirements are needed that supersede or supplement Table AN, they shall be specified through the use of suffixes.

6.2 When using the callout for materials covered by this specification, the suffixes that are found in Annex A1 may be used for the specific requirements for the material for the application intended. In general, the suffix letter gives the general requirement needed, the first digit following gives the test condition, and the second digit gives the specific requirement.

6.3 Additional suffixes will be added to this specification as test methods and requirements are developed. A further list of suffixes can be found in Guide D 4800 and may be used for additional requirements as appropriate.

NOTE 2—Using the information from Note 1, an example of the suffix system follows. The designation AN 0411 H11 P15 would indicate:

AN 0411	=	information from Note 1,
H	=	hot strength,
1	=	to be tested in accordance with 7.8 at a test temperature of 204°C,
1	=	hot strength shall meet the requirement stated in Table 2,
P	=	package/container,
1	=	bottle (plastic), and
5	=	250 mL.

6.4 *Qualification of Primers*—Primers Grade N and Grade T shall be tested in accordance with 7.17 with adhesive specified by the adhesive manufacturer, and shall meet the requirements specified in Table 3.

**TABLE AN Basic Properties—Anaerobic Adhesives
Group 1 Products**

Group	Description	Class	Description	Grade	Color (5.1.2)	Strength at Standard Conditions, Prevailing Torque Strength (5.2.3.1), N-m	Viscosity (5.2.1), mPa-s	Solvent Resistance (5.1.6), Prevailing Torque, N-m, min	Hot Strength (5.1.7), Prevailing Torque, N-m, min	Heat Aging (5.1.8), Prevailing Torque, N-m, min	Cold Strength (5.1.9), Prevailing Torque, N-m, min	Speed of Cure (5.2.2), Prevailing Torque, N-m, min		
01	Threadlocking and retaining adhesives; slow curing; Newtonian flow properties	1		1 0	green	17.0–42.4	10–25	17.0	10.2 ^A	8.5 ^A	17.0	8.5		
		2		1	red	11.3–28.2	10–25	11.3	6.8 ^A	5.6 ^A	11.3	5.6		
				2	orange	11.3–28.2	40–80	11.3	6.8 ^A	5.6 ^A	11.3	5.6		
				3	red	11.3–28.2	100–250	11.3	6.8 ^B	5.6 ^A	11.3	5.6		
				4 0	red	11.3–28.2	1000–10000	11.3	6.8 ^B	5.6 ^A	11.3	5.6		
		3		1 0	yellow	7.9–19.8	100–200	7.9	4.7 ^B	3.9 ^A	7.9	3.9		
				4		1	blue	4.5–11.3	10–25	4.5	2.7 ^A	2.3 ^A	4.5	2.3
						2	blue	4.5–11.3	100–250	4.5	2.7 ^B	2.3 ^A	4.5	2.3
		3 0	blue			4.5–11.3	1000–10000	4.5	2.7 ^A	2.3 ^A	4.5	2.3		
		5		1	purple	2.3–5.6	10–25	2.3	1.3 ^A	1.1 ^A	2.3	1.1		
2 0	purple			2.3–5.6	100–250	2.3	1.3 ^B	1.1 ^A	2.3	1.1				
6		1	brown	1.1–2.8	10–25	1.1	0.7 ^A	0.6 ^A	1.1	0.6				
		2	brown	1.1–2.8	100–250	1.1	0.7 ^B	0.6 ^A	1.1	0.6				
		3 0	brown	1.1–2.8	1000–10000	1.1	0.7 ^A	0.6 ^A	1.1	0.6				
7		1 0	yellow	0.8–1.5	100–250	0.8	0.4 ^A	0.4 ^A	0.8	0.4				
0	other	0												

TABLE AN Continued
Groups 2 and 3 Products

Group	Description	Class	Description	Grade	Color (5.1.2)	Strength at Standard Conditions, Torque Strength (5.2.3.1), N-m				Viscosity (5.2.1), mPa-s	Solvent Resistance (5.1.6), N-m, min		Hot Strength (5.1.7), N-m, min ^A	
						Steel		Plated			Steel		Steel	
						Break	Prevail	Break	Prevail		Break	Prevail	Break	Prevail
02	Threadlocking adhesives; fast curing; Newtonian flow properties	1		1 0	red	16.9–39.5	16.9–56.5	5.6–39.5	4.5–56.5	6000–8000	8.4	8.4	8.4	8.4 ^C
		2		1 0	red	16.9–39.5	16.9–56.5	4.5–39.5	4.5–56.5	400–600	8.4	8.4	8.4	8.4 ^A
	3		1 0	blue	11.3–22.6	5.6–17.0	3.4–22.6	2.3–22.6	110–150	5.6	2.8	5.6	2.8 ^C	
	4	wicking	1 0	blue	2.3–11.3	2.3–11.3	1.1–11.3	1.1–11.3	10–30	1.1	1.1	1.1	1.1 ^C	
	5	wicking	1 0	blue	2.3–11.3	11.3–22.6	1.7–22.6	1.7–22.6	10–30	1.1	5.6	1.1	5.6 ^C	
	6	wicking	1 0	green	2.3–16.9	17.0–56.5	1.1–11.3	8.5–56.5	10–30	1.1	8.5	1.1	8.5 ^A	
		0	other	0										
03	Threadlocking adhesives; fast curing; thixotropic flow properties; lubricating	1		1 0	purple	3.4–11.3	1.1–11.3	1.1–11.3	0.6–11.3	at 2 rpm ≥ 5000 at 20 rpm 800–1600	1.7	0.5	1.7	0.5 ^C
		2		1 0	blue	7.9–22.6	2.3–22.6	1.1–22.6	0.6–22.6	at 2 rpm ≥ 5000 at 20 rpm 800–1600	3.9	1.1	3.9	1.1 ^B
	3		1 0	red	11.3–28.2	11.3–33.9	5.6–28.2	5.6–28.2	at 2 rpm ≥ 5000 at 20 rpm 1200–2400	5.6	5.6	5.6	5.6 ^A	
	0	other	0											

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TABLE AN Continued
Groups 2 and 3 Products

Group	Description	Class	Description	Grade	Color (5.1.2)	Heat Aging (5.1.8), N-m, min ^A		Cold Strength (5.1.9), N-m, min		Speed of Cure (5.2.2), N-m, min	
						Steel		Steel		Steel	
						Break	Prevail	Break	Prevail	Break	Prevail
02	Threadlocking adhesives; fast curing; Newtonian flow properties	1		1 0	red	8.4	8.4 ^C	8.4	8.4	8.4	8.4
		2		1 0	red	8.4	8.4 ^A	8.4	8.4	8.4	8.4
		3		1 0	blue	5.6	2.8 ^C	5.6	2.8	5.6	2.8
		4	wicking	1 0	blue	1.1	1.1 ^C	1.1	1.1	1.1	1.1
		5	wicking	1 0	blue	1.1	5.6 ^C	1.1	5.6	1.1	5.6
		6	wicking	1 0	green	1.1	8.5 ^A	1.1	8.5	1.1	8.5
		0	other	0							
03	Threadlocking adhesives; fast curing; thixotropic flow properties; lubricating	1		1 0	purple	1.7	0.5 ^C	1.7	0.5	1.7	0.5
		2		1 0	blue	3.9	1.1 ^B	3.9	1.1	3.9	1.1
		3		1 0	red	5.6	5.6 ^A	5.6	5.6	5.6	5.6
		0	other	0							