



Designation: D5648 – 01 (Reapproved 2014)

Standard Test Method for Torque-Tension Relationship of Adhesives Used on Threaded Fasteners (Lubricity)¹

This standard is issued under the fixed designation D5648; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method covers the determination of the torque-tension relationship (lubricity) of adhesives used for locking and sealing threaded fasteners.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *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

D907 Terminology of Adhesives

2.2 *Society of Automotive Engineers Standards:*

SAE J174 Torque Tension Test Procedure for Steel Threaded Fasteners³

SAE J429 Mechanical and Material Requirements for Externally Threaded Fasteners³

2.3 *Federal Specification:*

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

3. Terminology

3.1 *Definitions*—Many of the terms in this test method are defined in Terminology D907.

¹ This test method 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 Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, http://www.sae.org.

⁴ 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.

4. Summary of Test Method

4.1 This test method consists of applying adhesive to a threaded fastener and measuring the developed tension applied to the fastener at specified torques. Alternatively, the torque required to reach specified levels of bolt tension may be measured.

5. Significance and Use

5.1 On some applications of threaded fasteners, it is desirable to control either the amount of developed tension when a specified range of torque has been applied or the torque required to develop a specified range of tension. This test method is used to determine the effect of using adhesives on the torque-tension relationship of threaded fasteners.

5.2 Accurate torque-tension relationships may be measured only by defining and controlling the many related test parameters.

6. Apparatus

6.1 *Tension-Measuring Device*, capable of measuring the axial tension induced in the bolt as it is tightened, having an accuracy within $\pm 5\%$ of the test load.

6.2 *Torque-Measuring Device*, of suitable capacity having an accuracy within $\pm 5\%$ of a given torque reading.

7. Test Specimens

7.1 *Bolts*—As-received, phosphate-and-oil-treated, $\frac{3}{8}$ -in. size, 16 threads per inch, Unified National Coarse thread series ($\frac{3}{8}$ by 16 UNC), Grade 5 bolts in accordance with SAE J429, having a minimum length of 1½ in. (38.1 mm) with hexagonal head.

7.2 *Steel Nuts*—As-received, Type II, Style 4, nominally $2\frac{1}{64}$ in. (8.3 mm) thick, conforming to Fed. Spec. FF-N-836.

NOTE 1—Other fastener sizes and substrates may be used upon agreement between the supplier and the user of adhesives.

7.3 *Hardened Washers*, conforming to the dimensional, metallurgical, mechanical, and finish requirements given in Table 1 of SAE J174.

8. Procedure

8.1 Determine the torque-tension relationship on not less than five specimens as follows: