



Technical Data Sheet

3M™ Scotch-Weld™ Threadlocker Anaerobic Adhesive TL22



[Regulatory Info/SDS](#)

Product Description

3M™ Scotch-Weld™ Threadlocker Anaerobic Adhesives are one-component anaerobic adhesives that cure and seal threaded assemblies that meet a wide range of applications to prevent vibration loosening and/or leakage. All products provide excellent vibration, corrosion, and shock resistance. Engineered to provide different strengths, temperatures, nut/bolt sizes, and other requirements, some threadlockers allow removal and meet various selections depending on the specific application.

Product Features

- 3M™ Scotch-Weld™ Threadlocker TL22 is removable with hand tools. It is a low strength (low torque removal) threadlocker for small diameter, fine threaded screws, set screws, nuts, bolts and hex and slot driven components such as keyed fasteners.
- Prevent corrosion
- Fluorescence
- Liquid (before cure)
- Shock and vibration resistance
- Fast setting
- 24 hour cure at room temperature

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Uncured Physical Properties

Attribute Name	Test Method	Value
Color		Purple ¹
Viscosity		800-1,600 cP ²
Chemistry		Dimethacrylate
Fixture Time	ISO 10964	20min (avg time) (10-30min range)

¹ Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

² Brookfield Viscometer spindle #3 at 20 rpm

Typical Physical Properties

Attribute Name	Value
Cured Color	Purple

Typical Cured Characteristics

Test Condition: Continuous

Attribute Name	Value
Temperature Range	-54 — 149 °C

Typical Performance Characteristics

Attribute Name	Test Method	Value
Breakaway Torque	ISO 10964	95in-lb - typical value (30-100in-lb range)
Strength		Low
Prevailing Torque		40in-lb - typical value (10-100in-lb range) ¹
Long Term Temperature Resistance		149 °C (300 °F) ²
Minimum Long Term Temperature Resistance		-54 °C (-65 °F) ²

¹ Reference ISO 10964. To convert to (N.m) divide (in.lb) by 8.851.

² Long Term (day, weeks)

Handling/Application Information

Directions for Use

3MTM Scotch-Weld™ Threadlocker Anaerobic Adhesives are not recommended for use on most plastics due to potential cracking of plastic parts. Also, they are not recommended for use in piping systems that contain pure oxygen or an oxygen-rich environment, chlorine, or strong oxidizing substances.

For Assembly:

1. Ensure parts are clean, dry and free from oil, grease and dirt. For best results, clean and dry parts with solvent or 3MTM Scotch-Weld™ Activator. (Activator can also be used on inactive surfaces or to accelerate the cure on active surfaces.)
2. If not sure of surface type, always use activator. Refer to Material surface Activity and Cure Speed section for more information.
3. Shake the adhesive bottle well before use.
4. Avoid touching the metal surfaces with the bottle tip since the metal ions may react with the adhesive upon contact and eventually may clog the bottle tip.
5. Apply adhesive onto the threaded part where the contact area will be in the final assembly. For larger parts, use more adhesive and rotate the threaded part to spread adhesive evenly around contact area.
6. For through holes, apply several drops of adhesive onto the bolt at the nut engagement area. For blind holes, apply several drops of the adhesive down the internal threads to the bottom of the hole.
7. Assemble the nut / fastener and tighten as required.
8. Allow assemblies to set for sufficient time so that handling strength or full cure will occur before further processing or testing

For Disassembly:

1. Loosen or remove with regular hand tools.
2. If hand tools do not work due to the assembled parts being well tightened, apply localized heat (approx.. 400°F / 254°C) to the nut or bolt and disassemble while parts are still hot. Use extreme caution when working with heat sources (e.g. heat gun, flames, etc.)

Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) in the original, unopened packaging, out of direct sunlight. For best performance, use this product within 12 months from date of manufacture.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577

Automotive Disclaimer

Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Information

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ISO Statement

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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