

**CALIFORNIA DEPARTMENT OF TRANSPORTATION
AUTHORIZED ANAEROBIC THREAD LOCKING SYSTEM**



Each Caltrans-authorized anaerobic thread locking system requires 3 components:

1. **CLEANER** - to clean lubricant and oils from the threads of the stud and nut.
2. **PRIMER** - to promote rapid curing of the anaerobic compound and to minimize migration of compound on threads.
3. **ANAEROBIC THREAD LOCKING ADHESIVE** - to secure nut onto stud by filling the gap between nut and stud threads. Note: Anaerobic thread locking adhesive compounds will set only where no oxygen is available.

All components used in a single thread locking application shall be from one of the systems below and from the same thread locking adhesive manufacturer, following the Manufacturer's Application Instructions for Caltrans-Authorized Anaerobic Thread Locking Systems.

Authorized Anaerobic Thread Locking Systems				
Manufacturer Information	Component	Trade Name	Part No.	Expiration Date
Loctite (Industrial Division) 1 Henkel Way Rocky Hill, CT 06067 (800) 562-8483 www.loctite.com	Cleaner	ODC-Free Cleaner & Degreaser	22355	December 2018
	Primer	Loctite 7649	21348	
	Adhesive	Loctite 262	26243	
Permabond International 480 South Dean Street Englewood, NJ 07631 (800) 370-9647 www.permabond.com	Cleaner & Primer	Perma-Lok Anaerobic Surface Conditioner	ASC10	December 2018
	Adhesive	Permabond HH120	HH120	
Hernon Manufacturing, Inc. 121 Tech Drive Sanford, FL 32771 (800) 527-0004 www.hernon.com	Cleaner	Hernon Cleaner 62	EF-62	December 2018
	Primer	Hernon EF Primer 49 or 50	EF-49, EF-50	
	Adhesive	Hernon Nuts N' Bolts Anaerobic Adhesive	429	
Saf-T-Lok 300 Eisenhower Lane North Lombard, IL 60148 (630) 495-2001 www.saftlok.com	Cleaner & Primer	Primer T	19166	December 2018
	Adhesive	T77 High Strength Permanent Thread Locker	27741	
Pacer Industrial 9420 Santa Anita Avenue Rancho Cucamonga, CA 91730 www.supergluecorp.com	Cleaner	Acetone	-	December 2018
	Primer	Pacer Technology Anaerobic Primer	FG09621	
	Adhesive	ANL-77 Anaerobic Adhesive	FG 06150	

Table 1: Authorized Anaerobic Thread Locking System.

1. Follow Manufacturer's instructions for use.
2. For any special requirements, consult with an engineer.
3. Part numbers may vary based on amount of product purchased.