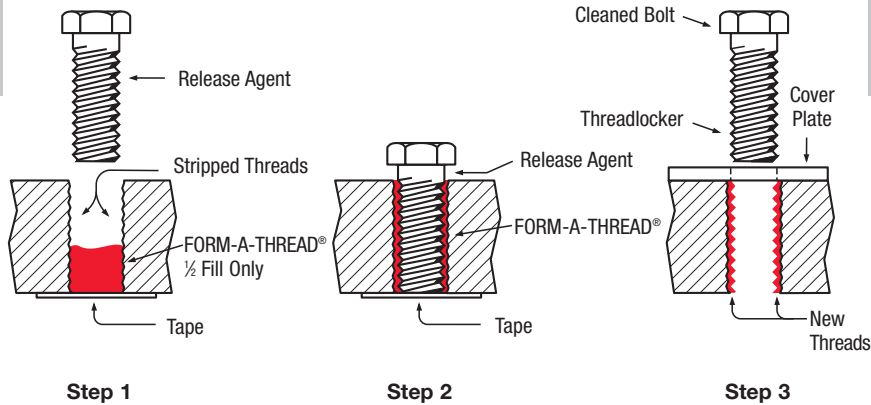


# THREAD REPAIR

## STRIPPED THREAD REPAIR



## STANDARD THREAD REPAIR

1. Follow instructions on Loctite® FORM-A-THREAD® package.
2. If cover plate is used for bolt alignment:
  - (a) Apply release agent to mating faces around repair area.
  - (b) Use “waxed” paper or similar film between faces.
3. A “jiggling/twisting” motion when initially inserting bolt improves thread conformation.

Note: NOT intended for engine stud repair.

## SMALL HOLE/FINE THREAD REPAIR

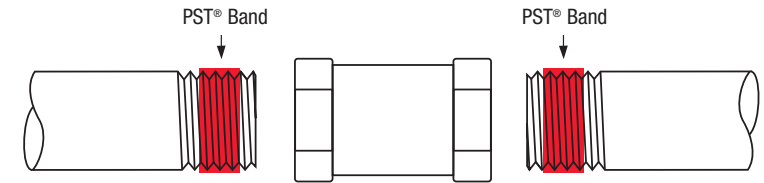
- OPTION 1. Drill out damaged hole to oversize, then follow STANDARD THREAD REPAIR.
- OPTION 2. Apply Loctite® FORM-A-THREAD® to screw and insert into damage hole. Clamp in place while product cures.

## STUD INSTALLATION – PERMANENT (LIGHT DUTY)

1. Use stud or cut “all thread” to desired length.
2. Do NOT apply release agent to stud.
3. Proceed as with STANDARD THREAD REPAIR.
4. Allow 30 minutes to cure.
5. Assemble as required.

# THREAD SEALING

## STANDARD FITTINGS – PIPES, HYDRAULIC, OR AIR



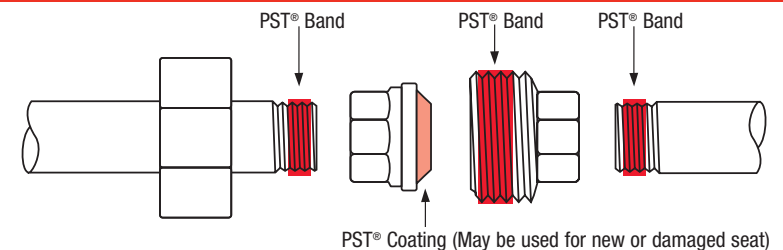
1. Clean parts of contamination. If necessary, spray Loctite® 7649™ Primer N™ onto threaded parts (male and female). Allow to dry.
2. Apply a band of Loctite® PST® Thread Sealant to male threads starting one to two threads from end of pipe.
3. Assemble parts snugly. Do not overtighten.
4. If initial pressure exceeds 1000 psi\*, wait 30 minutes before pressurizing.

Note: • For stainless steel components, use Loctite® 567™ PST® Thread Sealant.

- For general purpose thread sealing, use Loctite® 565™ PST® Thread Sealant or Loctite® QuickStix™ 561™ PST® Pipe Sealant.
- For fine filtration systems requiring zero contamination, use Loctite® 545™ Thread Sealant for hydraulic/pneumatic fittings.
- For easier disassembly or large diameter fittings, use Loctite® 564™ Thread Sealant.
- If sealing chemicals or strong acids/bases, refer to Fluid Compatibility Chart (LT-836).
- Do not use on oxygen or strong oxidizers (chlorine).
- For PVC or ABS pipe, use Loctite® No More Leaks™.

\*Depending on conditions

## PIPE UNIONS



1. Disassemble and, if necessary, spray all components with Loctite® 7649™ Primer N™. Allow to dry.
2. Apply a thin coating of Loctite® PST® Thread Sealant to union face.