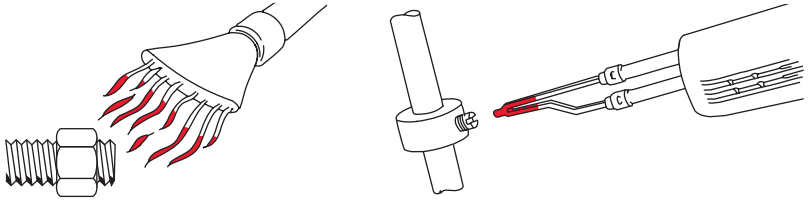
THREADLOCKING, THREAD SEALING & RETAINING

LOW AND MEDIUM STRENGTH PRODUCTS

Disassemble with hand tools.

HIGH STRENGTH PRODUCTS

- Apply localized heat (500°F or higher) to assembly for 5 minutes.
- Disassemble with hand tools while hot.

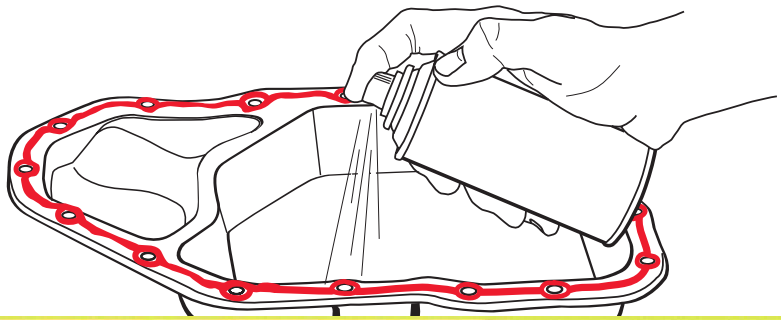


GASKETING

- Disassemble flange using hand tools.

Note: For anaerobic gaskets, clean with Loctite® Chisel® Gasket Remover.

For silicone gaskets, clean with Loctite® Chisel® MC-Free Gasket Remover.



GENERAL INFORMATION

Figure A

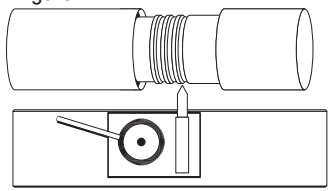


Figure B

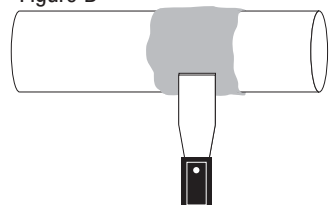
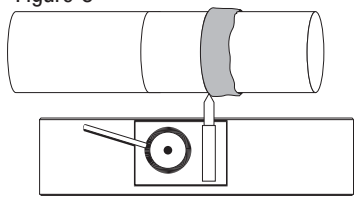


Figure C



1. Using a lathe, undercut desired depth according to the table below:

Shaft diameter	Desired undercut
½" to 1" (13 – 25 mm)	1/16" (1.5 mm)
1" to 3" (25 – 74 mm)	⅛" (3.0 mm)

2. Finish undercutting by machining a rough-cut surface or "gramophone" pattern; the larger the diameter of the shaft, the deeper the threads. (See Figure A)
3. Clean the shaft of any cutting fluids or oils with Loctite® ODC-Free Cleanser & Degreaser.
4. Apply a very thin layer of Loctite® Fixmaster® Superior Metal by forcing it into the bottom of the threads. Turn the shaft at a very low speed and continue to apply more material by using a tool, such as a putty knife, that can be bent. (See Figure B)
5. Allow the product to cure for the required period at 70°F (20°C) or higher (if necessary, apply dry heat to speed up the cure).
6. Machine repaired area to original dimensions of the shaft (see Figure C) using the guidelines below:

   Lathe Speed: 150 ft./min. (46 m/min.)

   Feed Rate:
   - Roughening: 0.025 in./rev. (0.64 mm/rev.)
   - Finishing: 0.010 in./rev. (0.25 mm/rev.)

   Top Rake/Side and Front Clearance: 3°

Note: Cut dry; use carbide or high-speed steel bits. If polishing