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Product Description Sheet

Form-A-Thread® Stripped Thread Repair Kit

Maintenance, Repair & Operations, September 2008

PRODUCT DESCRIPTION

LOCTITE® Form-A-Thread® Stripped Thread Repair Kit consists of a two-component, gray and blue repair material and a one-component release agent. Form-A-Thread® can be used to repair stripped threaded assemblies in a variety of metal and wood.

TYPICAL APPLICATIONS

Form-A-Thread® can be used to repair damaged threaded metal assemblies. Typical applications include threaded assemblies on oil pans, valve covers, distributor caps transmission pans and housing.

PRODUCT FEATURES

Easy to Use:

- One kit repairs all sizes
- Requires no machine shop skills
- Repairs typical assemblies not possible by other means.

Fast, Reliable, Versatile:

- Works on a wide range of materials
- Achieves handling strength in 5 minutes
- Achieves full strength in two hours
- Cures to machinable hardness in two hours

Safe to use:

- Non-flammable

Directions for use

1. Coat bolt with release agent.
2. Dispense and mix equal amounts of Form-A-Thread® compounds on clean surface.
3. Apply into application.
4. Screw bolt into place.
5. Wait 5 minutes and remove bolt.
6. Allow compound to cure for 30 minutes before use.

PROPERTIES OF UNCURED MATERIAL

Repair Material

	Typical Value
Chemical Type	Dimethacrylate Ester
Appearance	Gray, mixed
Odor	Mild pungent
Specific Gravity	1.57
Flash Point, °F	>200

Release Agent (liquid)

	Typical Value
Chemical Type	Silicone Emulsion
Appearance	Blue
Odor	None
Flash Point	None

MAXIMUM TORQUE VALUES FOR REPAIRED THREADS

Bolt Type	Bolt Sizes				
English Inches Grade 5	1/4	5/16	3/8	7/16	1/2
Metric mm Grade 8.8	6	8	10	11	12
Max. Recommended Torque (in. lbs.)	23	45	82	129	193

Bolt Type	Bolt Sizes				
English Inches Grade 5	9/16	5/8	3/4	7/8	1
Metric mm Grade 8.8	14	16	19	22	25
Max. Recommended Torque (in. lbs.)	273	375	648	1080	1538

TECHNICAL DATA

Form-A-Thread® is a high-technology chemical system that restores threads to damaged fastener assemblies. The prime advantage of Loctite's system is the fact that Form-A-Thread® repairs almost all common fastener sizes and thread grades.

Form-A-Thread® is used on most metals (aluminum, iron, steel, brass, magnesium, copper, etc.)

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm compatibility of the product with such substrates.

Storage

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact your local Technical Service Center.

Ordering Information

Item #	Container Size
28654	4.8 ml Syringe, Tool Box Size

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

NOT FOR PRODUCT SPECIFICATIONS
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.
PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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Note

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