

appendix 2

<p style="text-align: center;">SOP - Threadlocker Red Rework</p>		Date of Release	Rev.	1
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Tools	<p style="text-align: center;">Illustrations</p>			
M6 & M4 Hexagon Keys				
<p>Rework Procedures</p> <ol style="list-style-type: none"> 1. Use an M6 hexagon key to remove the big screw and make sure its surface is clean, dry, and free of grease (Fig. 1). 2. Apply the PERMATEX PX #27150 HIGH-STRENGTH THREADLOCKER RED evenly throughout the thread surface for half the length of the screw (Fig. 2 & Fig. 3). 3. Reinstall the big screw and leave for curing (Fig. 4). 4. Then use an M4 hexagon key to remove the small screw and make sure its surface is clean, dry, and free of grease (Fig. 5). 5. Apply the Threadlocker RED evenly throughout the thread surface for half the length of the screw (Fig. 6). 6. Reinstall the small screw and leave for curing (Fig. 7). 				
<p>Notices</p> <ol style="list-style-type: none"> 1. For maximum reliability, the clearance between the engaged nut and bolt should be filled with the adhesive. 2. Clean up any glue squeezed out of the joints with a rag (Fig. 8). 3. The curing time of the threadlocker usually takes about 48 hours. 4. When fully cured, the minimum loosening torque is as follows : Big Screw : 2.5 N.m Small Screw : 1.5 N.m 				