


appendix 4

	<p>Toll Free: 87 PERMATEX (877-376-2839)</p> <p>10 Columbus Blvd., Hartford, Connecticut 06106</p> <p>6875 Parkland Boulevard, Solon Ohio 44139</p>	<h3 style="margin: 0;">Technical Data Sheet</h3> <h2 style="margin: 0;">High Strength Threadlocker RED</h2> <p style="text-align: right; margin: 0;">INDUSTRIAL</p>
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PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex® High Strength Threadlocker RED is a **high strength** anaerobic threadlocking material, which cures between engaged threads to form a unitized assembly that helps resist leakage, shock and vibration. The product is a single component, anaerobic liquid that cures when confined in the absence of air between close fitting metal surfaces. Ideal for all 1/4inch to 3/4inch diameter nut and bolt assemblies where future disassembly is improbable. Excellent chemical resistance and temperature resistance range of -54°C to +149°C (-65°F to +300°F). Meets or exceeds the requirements of Military Specification Mil-S-46163A Type II, Grade K.

PRODUCT BENEFITS

Improved Reliability

- Eliminates vibration issues
- Seals against leakage
- Prevents rusting of threads
- Cures without cracking or shrinking

Easy Application

- No mixing
- No curing outside of joint
- No torque compensation required during assembly

TYPICAL APPLICATIONS

Prevents loosening and leakage of threaded fasteners. Particularly suitable for applications such as:

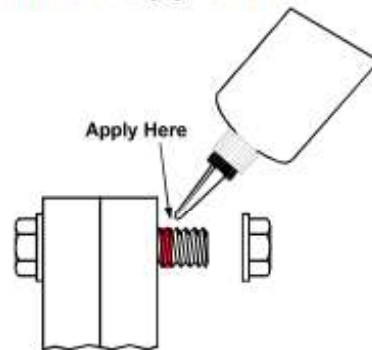
- Cylinder block
- Rocker arm studs
- Ring gear bolts
- Frame bolts
- Frame brackets
- Hydraulic press studs

DIRECTIONS FOR USE

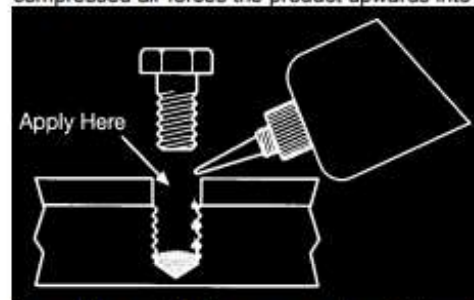
For assembly

1. Clean all threads (Bolt and Hole) with a cleaning solvent such as Permatex® Brake and Parts Cleaner and allow to dry.
2. Determine if the threads to be bonded are **Active** or **Inactive Metals** (Ref: Cure Speed vs. Substrate on the second page). If material is an **Inactive Metal**, spray all threads with Permatex® Surface Prep (24163) and allow 30 seconds to dry. Priming is not required if the material is an **Active Metal**. If unknown, it's always best to use the primer.
3. Shake the product thoroughly before use.
4. To prevent the product from clogging in the nozzle, do not allow the tip to touch metal surfaces during application.
5. **For Thru Holes**, apply several drops of product onto the

bolt at the nut engagement area.



6. **For Blind Holes**, apply several drops down female threads into the bottom of the hole. As threads are engaged, compressed air forces the product upwards into the threads.



7. Assemble and tighten as usual. When tightening to established torque values, torque compensation is not required.

For Cleanup

1. Residual liquid films and/or fillets outside the joint are readily soluble in Permatex® Brake and Parts Cleaner.
2. Cured product can be removed with a combination of soaking in Permatex® Gasket Remover and mechanical abrasion such as a wire brush.

For Disassembly

1. Apply localized heat to nut or bolt to approximately 232°C (450°F). Disassemble while hot.

For Reassembly

1. Remove loose product from nut and bolt.
2. Apply primer to all threads, regardless of metal type.
3. Assemble and tighten as usual.

NOT FOR PRODUCT SPECIFICATIONS.
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.
PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.
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