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Technical Data Sheet

Permatex® Stripped Thread Repair

AAM Revised 09/02

PRODUCT DESCRIPTION

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

S.I.N.: 834-300

PRODUCT BENEFITS

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 variety of metals
- Achieves handling strength in 5 minutes
- Achieves full strength in two hours
- Cures to machinable hardness in two hours

Safe to use:

- Non-flammable

TYPICAL APPLICATIONS

Permatex® Stripped Thread Repair can be used to repair damaged threaded metal assemblies. Typical applications include threaded assemblies on oil pans, valve covers, distributor caps, transmission pans and housings.

DIRECTIONS FOR USE

1. Both parts of the threaded assembly must be cleaned and free of dirt, oil and grease.
2. Cleaning can be performed using a solvent such as Permatex® Brake and Parts Cleaner.
3. Apply the release agent onto the bolt including the end of the bolt.
4. Mix equal parts of both repair materials into a homogeneous thin paste and apply to the female thread.
5. If the repair is on a through hole, apply a piece of tape as backing to keep the compound in the hole.
6. Position the bolt by screwing motion two to three threads deeper than the normal position of use. This will assure even dispersion of the compound into the threads and full length of engagement during tightening.

PROPERTIES OF UNCURED MATERIAL

Repair Material

| | Typical Value |
|-------------------------|----------------------|
| Chemical Type | Dimethacrylate Ester |
| Appearance | Gray, mixed |
| Odor | Mild pungent |
| Flash Point T.O.C. (°F) | >200 |

Release Agent (liquid)

Typical Value

| | |
|---------------|-------------------|
| Chemical Type | Silicone Emulsion |
| Appearance | Blue liquid |
| 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 |
| (ft. lbs.) | 2 | 4 | 7 | 11 | 16 |

| 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 |
| (ft. lbs.) | 23 | 31 | 54 | 90 | 128 |

TECHNICAL DATA

Permatex® Stripped Thread Repair is a high-technology chemical system that restores threads to damaged fastener assemblies. The prime advantage of the Permatex® system is the fact that Stripped Thread Repair repairs almost all common fastener sizes and thread grades.

Stripped Thread Repair may be used on most metals including aluminum, iron, steel, brass, magnesium, copper, etc.

Temperature range -65°F to +300°F (-54°C to +149°C)

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).

ORDERING INFORMATION

| Part Number | Container Size |
|-------------|------------------------|
| 81668 | .44 oz. net weight kit |

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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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.

NOTE

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