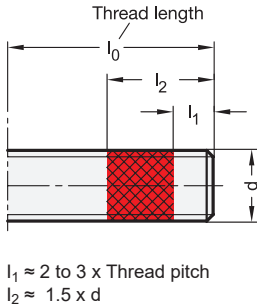


### Information

Polyamide patch coating is offered for GN 615.3 (see page 840) spring plungers. A blue coating indicates type K or KN, green indicates type KS or KSN (high spring load). Polyamide complete coating is available for GN 252 and GN 252.5 blanking plugs (see page 1685) as a type.

### MVK Thread locking gluing Micro encapsulation precote 80 (red)



d	l1	l2 ≈	MIN in Nm max. insertion torque	MLB in Nm min. breakaway torque	Mout in Nm max. loosening torque
M 5	1.5 ... 2.5	7.5	0.5	1	6.5
M 6	2 ... 3	9	0.8	1.8	10
M 8	2.5 ... 4	12	1.5	4	26
M 10	3 ... 4.5	15	3	10	55
M 12	3.5 ... 5	18	5	16	95
M 16	4 ... 6	24	11	35	250
M 20	5 ... 7.5	30	14	45	500

The torque value comply with DIN 267 Part 27. They are based on a test of a thread without preload with a nut thread of 6H at room temperature. For thread lengths  $l_0 < l_2$ ,  $l_2$  is reduced in such a way that one to two thread turns are not coated at the end of the thread.

### Description

The principle of micro encapsulation MVK (gluing) consists of a liquid plastic material and hardener encapsulated in a thin polymer film which is embedded in a lacquer like carrier deposited in patch form on a thread. This patch dries and the component can be stored and handled in a normal manner.

When fitting a bolt with this patch the two capsules will burst under the pressure and friction between the two threads. The liquid plastic material and hardener will mix leading to a chemical reaction which will harden the glue, thus giving the required thread locking.

The setting of the mixture will start after 10 – 15 minutes. Sufficient hardness is achieved after about 30 minutes but complete setting is reached after 24 hours.

Adjustment and setting process must be completed within about 5 minutes.

The thread locking can be cracked by applying the Mout torque on the thread or alternatively by heating the component over +170 °C. It is not recommended to re-use the thread.

Threads, free from oil and grease give increased strength of locking action.

Components treated with this process can be stored for up to 4 years.

### Features

- Thread locking to the highest order to prevent the self loosening and component loss even under vibration. Not suitable for adjustable bolts or screws.
- This security aspect may be essential for certain applications of standard parts. Stockholding of liquid glue is eliminated.
- Low insertion torque
- Temperature resistant from – 40 °C up to 170 °C
- Excellent chemical stability

### GPC Tightening with thread coating Precote 5 (white)

#### Description

Precote 5 is a non-reactive, film-forming emulsion with mineral solids for coating threaded parts.

The coating generates a seal against gases and liquids in threaded parts, both in cylindrical / cylindrical and in cylindrical / conical pairs. Corrosion in the threaded connection is prevented.

The coating is solvent-free, dry and non-sticky. It is non-hazardous for health.

The minimum storage stability in unmounted state is 4 years.

#### Features

- The sealing coat is a captive element of the locking screw. It saves storing and mounting locking materials.
- The sealing effect sets in after mounting, no curing time is required.
- The friction rating of the thread remains virtually constant, the working-loose torque is low, max. reusable once.
- Sealing effect of thread: cylindrical / cylindrical < 15 bar cylindrical / conical > 50 bar
- Operating temperature – 60 °C to +150 °C
- Good chemical resistance, e.g. against oils, water, petrol and solvents

Threaded plugs DIN 906

