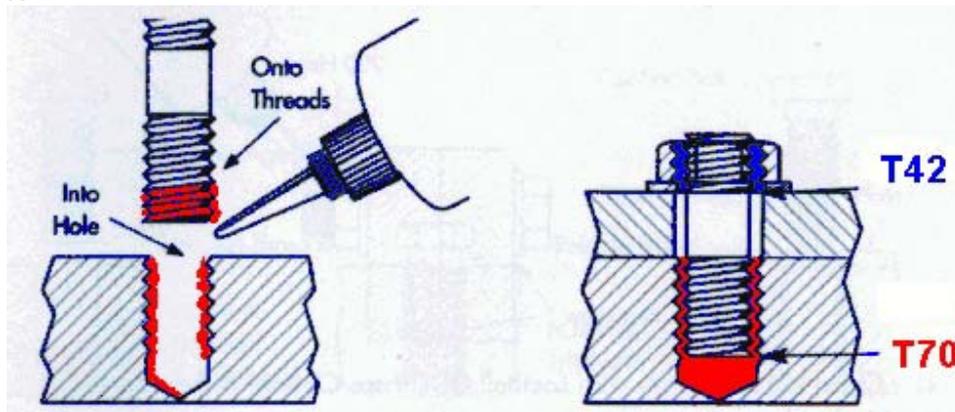


**APPLICATION METHOD A-103****APPLICATION METHOD FOR STUD THREADLOCKING IN BLIND HOLES**

This method pertains to the application of SAF-T-LOK products for threadlocking and/or sealing blind holes. The procedure is to be used when assembling threaded metal parts, using SAF-T-LOK threadlockers or sealing products.

**PROCEDURE**

1. Solvent clean the parts of any contamination. Use primer if parts must go back in service promptly.
2. Apply the sealing compound to the male threads. Apply to the threads of the blind hole where the assembled stud will rest.
3. Assemble the stud to the required depth or torque.
4. The assembled parts will be sealed within one hour. A full cure will occur within 24 hours (or 4 hours with Primer).
5. After cure of the T70 stud application, continue the assembly by applying the T42 threadlocking compound to the male threads of the stud.
6. Assemble the joints to the required torque. Do not over tighten.
7. The assembled parts will be low pressure sealed within one hour. A full cure will occur within 24 hours (or 4 hours with Primer).