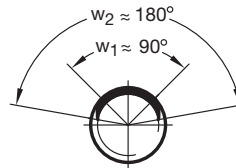


$l_1 \approx 2 \text{ to } 3 \times \text{Thread pitch}$
 $l_2 \approx 1,5 \times d$



w_1 : Coating core zone
 w_2 : Coating including edge zone

d Thread Diameter	l_1	$l_2 \approx$	M_{in} Maximum Torque	M_{out} Maximum Loosening Torque
M3	1 to 1.5	4.5	0.43	0.1
M4	1.5 to 2	6	0.9	0.15
M5	1.5 to 2.5	7.5	1	0.2
M6	2 to 3	9	2	0.6
M8	2.5 to 3	12	4	1
M10	3 to 4.5	15	5	1.5
M12	3.5 to 5	18	7	2.3
M16	4 to 8	24	10	4

The torque values are based on a test of a thread without preload, with a nut thread of 6H at room temperature.

Description

The polyamide patch coating (DIN 267/28) is a process whereby an elastic plastic material (Polyamide) is applied to part of a thread which creates a jamming action during the tightening of a nut.

The play between the bolt and nut is taken up by the Polyamide thus ensuring maximum surface contact between the uncoated thread areas. This process counteracts the loosening and unscrewing of the parts.

There is no setting time required. The thread contact is instantaneous. The feather edge of the Polyamide deposit prevents breakage.

Threads with polyamide patching have unlimited stock life.

Features

- High thread locking action
- This security aspect may be essential for certain applications of standard parts. Stockholding of liquid glue is eliminated.
- Multi use is possible whereby the jamming effect after the fifth removal is still around 50% of its original strength.
- Temperature range from -50 to +90°C (short duration 120°C)
- High chemical stability