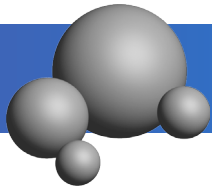


ND PATCH®

Locking & Sealing



DESCRIPTION:

The ND Patch coating process produces a completely dry product that is fused to the fastener and is ready to use right out of the box. ND Patch performs immediately upon assembly with no curing time required.

How ND Patch Works: When assembled with a mating part the resilient ND Patch is compressed. The compressed engineered plastic (normally Nylon) Patch provides locking action in the thread instead of at the bearing surface due to its vibration dampening characteristics. In general, the resilience of ND Patch holds the fastener in place without adhesives or thread distortion. Due to its resilience, Patch can be repeatedly adjusted and reused.

ND Patch and ND 360° Ring Patch is normally positioned one to three threads back from the end of the fastener to assure ease of starting. The normal coating length of the Patch is four to six threads. Special Patch location and coating length can be specified for specific applications.

As with all of our ND-Applied products, we can apply Patch to your fasteners at any one of our regional service centers, or we can supply you with fasteners already coated with ND Patch.

FEATURES:

Improved Sealing: ND 360° Ring Patch provides excellent locking performance as well as increased sealing ability by completely filling the thread helix with an elastic 360° nylon dam.

Retains Full Strength: ND Patch process involves no drilling or milling, so there is no loss of the fastener's strength or hardness and no troublesome burrs or chips.

Saves Money: Use of ND Patch eliminates the need for costly lock washers, cotter pins, or castellated nuts. You get a close fit without the costs involved in obtaining close tolerances. Moreover, ND Patch is less expensive than applying bottled thread locking compounds at the point of assembly.



ND Patch meets or exceeds the performance requirements of the following specifications and/or standards:

MILITARY:

- U.S. Military: MIL-N-25027, MIL-N-25027 MIL-F-18240E, MIL-DTL-18240F

AUTOMOTIVE:

- Chrysler: PF-5144, PF-5461, PF-6157, PF-6158
- Ford: ES-382101-S100, ES-378813-S100, ES-N800688-S100, WA970, ES-21002-S100
- General Motors: GM 6189P

INDUSTRIAL FASTENER INSTITUTE:

- IFI: IFI 100, IFI 124, IFI 524
- DIN: DIN 267 Part 28

OEM:

- Detroit Diesel: 9S240
- Eaton: 205372
- Meritor (Rockwell): Q-70
- New Process Gear: PS-616

For a complete list contact ND Industries.

FEATURES CONTINUED:

Resists Heat & Cold: ND Patch meets and exceeds IFI Specifications 124 & 524 as well as Military specification MIL-DTL-18240F, Type P, for temperatures from -70°F (-57°C) up to +250°F (+121°C).

Chemical Resistant: ND Patch will not dry, shrink, or lose resiliency when exposed to commercial solvents, alcohol, gasoline, oil, caustic soda, jet fuel, etc.

Reusable: Fasteners coated with ND Patch can be reused repeatedly without damage to threads. ND Patch is particularly resistant to deformation, which makes it ideal for repeated use.

Saves Effort: ND Patch greatly reduces the need for retightening.

Saves Time: Fasteners coated with ND Patch can be automatically fed through standard feeding devices.

SPECIFICATIONS:

Primary Usage	Lock and Seal
Reusability	Up to 15 on-off cycles
Material	Nylon 11
Color	Yellow (Other colors available upon request**)
Hardness	Shore D (ASTM D2240) 70-80 Durometer
Salt Spray Resisttance	(ASTM B117) 1000+ hours (X Scribe)
Taber Abrasion	(ASTM D4060) 10-18 mg loss CS-10 wheel, 1000g load , 1000 cycles. (Varies with color)
Dielectric Strength	(ASTM D149 short time) 800-1200 volts/mil @ 10.0 mils (Varies with color)
Direct Impact Resistance	(MPTM 0002) 160 in. lbs. @ 10.0 mils
Shelf Life	The on part shelf life is indefinite under ideal storage conditions [+40°F (+4°C) to +90°F (+32°C)], but recertification must occur once a year.

** QPL-18240 & MIL-DTL-18240F requires yellow nylon

ND Patch is a product of ND Industries, Inc., U.S.A.



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