



Tuflok® Nylon Processing

Advantages

Blue patch identifies true Tuflok

Re-useable

Anti-vibrational

Engineered torque flexibility

Variable patch length and position

Eliminates secondary locking features
such as nuts, washers, etc.

Automatically locks in any position

Non Curing

Plate and Patch

Resistant to chemicals like alcohol,
petroleum, oil, kerosene,
diesel fuel and hydraulic fluids

PRELOK®

At PRELOK® we offer Europe's widest range of pre-applied locking and sealing solutions, eliminating the need for secondary locking devices, hand-applied liquid adhesives, or sealing tapes.

The Tuflok® Nylon anti-vibration locking patch, Blue Nylon patch when applied is permanently fused onto the screw thread of the parent component, and increases the prevailing removal torque, allowing the screw to be locked in any position upon assembly.

Tuflok® 180 Nylon anti-vibration locking patch

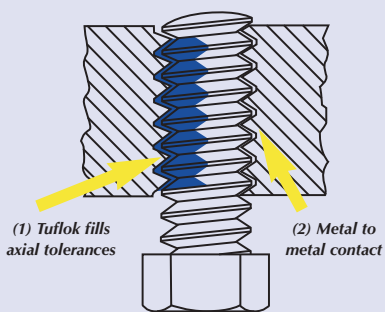
Tuflok® 180 Nylon anti-vibration locking patch, is a blue nylon patch permanently fused to the screw thread. This process provides excellent vibration resistance and torque performance for all applications requiring controlled loading and re-usability.

Tuflok® Nylon anti-vibration locking patch, is effective, whether or not the fastener is fully seated, making it ideal for applications where continual adjustment is required.

Tuflok® 360 Nylon anti-vibration locking patch

Tuflok® 360 Nylon anti-vibration locking patch, gives full circumference coverage (completely around the thread) and is suitable for applications requiring a fully re-usable high pressure seal against liquid or gas.

The Tuflok® Principle



A. The Tuflok® process consists of fusing the Blue Nylon 11 material onto a defined area of the male thread surface.

B. Upon installation into the female threaded component, the nylon material is compressed filling the axial tolerances between the threads (1).

C. The Tuflok® process creates a strong metal-to-metal radial loading on the flanks of the mating thread forms (2), which provides the locking action.

Industry Approvals

Our Tuflok® Nylon anti-vibration locking patch, product is approved to a wide range of industry standards including:-

DIN 267 part 28

BS 7715:1994

IFI 124 & 524

General Motors GM6189P

Ford WA970

Jaguar/Landrover.STJLR.60.5020.A970

and many more...



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Tuflok® Nylon Processing

Product Guide

Product	Colour	Type	Max Patch Length	Standard Patch Length	Standard Patch Lead	Storage Life @ Ambient Conditions	Operating Temp (°C)	Sealing Capacity 360° Patch	Re-Usability	Size Range
Tuflok	Blue	Nylon	40mm	4-6 Pitch	1-2 Pitch Lead	Indefinite	-56 + 120	>15 BAR (M10 Thread)	>5	M1-M30

- We currently process a range of Headed Components, Studs, Plugs and similar size parts.
- We can apply our coating to ferrous or non-ferrous materials (Steel, Aluminium, Stainless Steel or Brass).
- With our strategic Plating alliances we can offer a complete one-stop-shop Plate and Patch service.
- This is a general guide to the products we currently process.
- We are able to process other components subject to evaluation.

Standard Torque Characteristics

Thread Sizes	First Installation		First Removal		Fifth Removal	
	Prevailing Torque Max.		Min.		Min.	
	ibf/in	Nm	ibf/in	Nm	ibf/in	Nm
1.6	0.9	0.10	0.1	0.01	0.035	0.004
2	1.8	0.20	0.2	0.02	0.10	0.01
2.5	3.5	0.40	0.4	0.05	0.3	0.03
3	5.3	0.60	1.2	0.14	0.50	0.06
3.5	8.0	0.90	1.9	0.22	1.00	0.11
4	10.6	1.20	2.3	0.26	1.4	0.16
5	20.4	2.30	3.2	0.36	2.0	0.23
6	26.6	3.0	4.0	0.45	2.7	0.30
8	88.5	10.0	8.0	0.9	5.1	0.58
10	123.9	14.0	15.9	1.80	9.7	1.10
12	185.9	21.0	23.0	2.6	13.3	1.50
14	265.5	30.0	31.9	3.60	20.4	2.30
16	354.0	40.0	44.2	5.00	30.0	3.40
20	531.0	60.0	70.8	8.0	48.7	5.50
22	663.8	75.0	92.9	10.50	61.9	7.00
24	796.6	90.0	115.0	13.0	75.2	8.50

Torque Performance can be varied to suit specific application requirements. These figures may vary according to material specification and are intended as a guide. Torque characteristics for imperial thread sizes available upon request.

PRE-PRODUCTION SAMPLES ARE EVALUATED AND THEN PROCESSED FREE OF CHARGE

Recommendations

Hole Preparation

In all cases the female thread of the mating components should have the lead thread de-burred or countersunk to avoid damage to the patch material.

Thread Preparation

To obtain optimum patch performance both male and female threads should be in accordance with class 6g/6H (metric) or class 2 a/b (unified). High installation speeds can create galling of the threads affecting product performance.

Finishes

Tuflok can be applied to most popular plated finishes, as well as polymer and organic coatings.

Customer free issue components

Parts manufactured from non-ferrous material should be supplied free from any surface contaminants. Variations in material structure can effect heating capability of the part during processing, which may result in torque variation.

