



## INSTRUCTIONS FOR APPLICATION OF ND VIBRA-TITE®

During the formation of any bond over oily, greasy, or dirty parts, a barrier film is formed between the part and the applied adhesive or coating. This results in weak adhesion of the adhesive/coating to the substrate. To avoid such a situation and thereby achieve maximum performance, it is very important to apply Vibra-Tite® to clean parts.

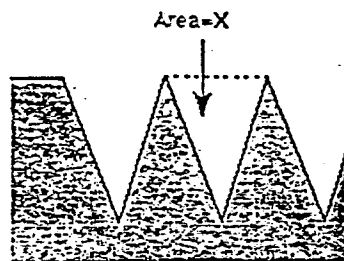
### **CLEANING**

MEK (Methyl Ethyl Ketone), Acetone, alkaline water (soap), or a variety of other cleaning chemical can be used to remove oil, grease, etc. from parts. The actual cleaning solution will depend on the type of parts being cleaned and the type of material on the parts.

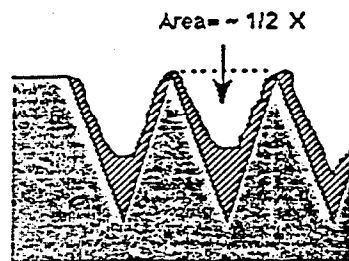
### **APPLICATION**

ND Vibra-Tite® can be applied in bulk by a ND Vibra-Tite® coating machine which uses a flow coating technique. Other modifications of flow coating can be used for the application of Vibra-Tite®. For flow coating, the material is poured over the part so that it coats the desired area and the excess flows down into a recycling container. For bulk automated coating, please contact your nearest ND service center. Vibra-Tite® can also be manually applied to parts by a variety of techniques, including the use of a brush. This is useful for small scale applications.

Vibra-Tite® may be thinned with additional Vibra-Tite® thinner to achieve appropriate application viscosity. For best results, standard recommended thread fill would be 30-50% of thread root area (see figure below).



Uncoated fastener



Fastener coated with ND Vibra-Tite®

### **DRYING**

Once the Vibra-Tite® has been applied, it must be dried to remove the solvent. Drying can be achieved by using ambient air or can be accelerated by using warm air or an oven. The temperature for this should not exceed 130°F as the solvent is flammable. Drying time is dependent on part size and configuration. Best results are found using considerable air flow in addition to heat.

### **CAUTION**

Exercise caution when working with flammable solvents.

**PLEASE NOTE:** The above are guidelines only. The best method will be different for different applications, substrates, and types of parts and this should be determined by actual trial.