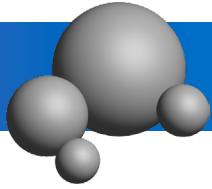


ND MICROSPHERES® EPOXY

Locking & Sealing

ND Industries® is ISO9001:2000 / AS9001B / QPL-18240F Listed / QSLM Registered



DESCRIPTION:

- ❑ ND Microspheres are microencapsulated, room temperature curing adhesives that can be applied to male or female threaded fasteners of all sizes and configurations.
- ❑ ND Microspheres remain inert until the coated fastener is assembled to its mating part. The forces of engagement crush the microscopic capsules of epoxy resin, mix the separate reactant components, and initiate a chemical reaction which locks the parts together.
- ❑ Within minutes of assembly, ND Microspheres forms a substantial bond between the mating surfaces. Curing continues, normally, for 72 hours following installation in order to achieve full strength.
- ❑ ND Microspheres 593 DPC is available in powder form which, once reconstituted with the recommended solvent, exhibits the same properties as factory supplied liquid material.

FEATURES:

- ❑ **Low Prevailing On Torque:** Assembles easily with common hand tools.
- ❑ **Exceptional Locking Power:** Extensive testing indicates that ND Microspheres provides two to four times greater breakaway torque than conventional “plastic” fastener locking devices.
- ❑ **Versatile:** ND Microspheres are compatible with most sizes, configurations, materials and finishes.
- ❑ **Surpasses Industrial Fastener Institute Standards:** ND Microspheres meets or exceeds all performance requirements of IFI 125 and IFI 525 as well as automotive specifications when used on clean, dry and/ or dry phosphated surfaces.
- ❑ **Long Shelf Life:** Once applied, ND Microspheres remains inert until a cure is activated by engagement with a mating thread. Store in cool dry environment.

Competes with 3M® Scotch-Grip®



FEATURES CONTINUED:

- ❑ **Unaffected By Foreign Substances:** Oil, gasoline, salt- spray, acids, solvents, water, and air have virtually no effect on Microspheres when introduced after a final cure has been achieved. The cross-linked molecular structure of ND Microspheres makes it one of the most resistant types of adhesives.
- ❑ **Saves Money:** ND Microspheres brand ND-applied thread adhesive is less expensive than applying bottled thread locking compounds at the point of assembly.

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

AUTOMOTIVE:

- Chrysler: MS-CC76 Type A&C, PF-6616
- Ford: ES-20007-S100, ES-20010-S100, ESS-M11P24-A1 & A2, WSS-M11P45-A1, WX-200
- General Motors: GMW 14657B, GM6175M, GME00151

INDUSTRIAL FASTENER INSTITUTE:

- IFI: IFI 125, IFI 525
- DIN: DIN 267

OEM:

- Dana: ES-PS-0614, PS-612
- Delphi: DX5204023
- Eaton: PS-005
- Holden: HN1737
- Meritor (Rockwell): Q-43
- TRW: TMS-P-10559, TPS-C-20,089

For a complete list contact ND Industries.

SPECIFICATIONS:

Bulk Material Properties			
Formula*	ND Microspheres® 593-S	ND Microspheres® 1193-S	ND Microspheres® 593 DPC
Typical Colors (see note 1)	Blue or Yellow	Orange or Neutral	Blue or Yellow
Appearance	Liquid	Liquid	Dry Powder
Base	Synthetic Resin	Synthetic Resin	Synthetic Resin
Base Solvent	Toluene	Toluene	Toluene
Flashpoint	40F TCC	40F TCC	N/A
Net Weight	8.6 ± 0.2 lbs./gal	8.6 ± 0.2 lbs./gal	
Viscosity	1600 - 2000 cPs	1600 - 2500 cPs	300-2000 cPs*****
Solids Content	59.5 ± 2.5%	59.5 ± 2.5%	
Shelf Life	1 Year**	1 Year**	1 Year**
As Applied Properties			
Primary Usage	Heavy Duty Lock	Heavy Duty Lock	Heavy Duty Lock
Reusability	Limited (Approx. 3 Times)	Limited (Approx. 3 Times)	Limited (Approx. 3 Times)
Installation (on) Torque	Minimal****	Minimal****	Minimal****
Breakaway Torque*	Exceeds IFI 125 & IFI 525****	Exceeds IFI 125 & IFI 525****	Exceeds IFI 125 & IFI 525****
Prevailing (off) Torque*	Exceeds IFI 125 & IFI 525*	Exceeds IFI 125 & IFI 525*	Exceeds IFI 125 & IFI 525*
Typical Lead Threads (note 2)	1 to 3	1 to 3	1 to 3
Typical Coating Length (note 2)	1.5 x Diameter	1.5 x Diameter	1.5 x Diameter
Service Temp Range	-65°F to +300°F	-65°F to +300°F (intermittently 400°F)	-65°F to + 300°F (on bolt after applied)
Competes With	3M Scotch-Grip 2353 & 4844	3M Scotch-Grip 2451 & 2510	
Shelf Life	2 years**	2 years**	2 years**

Note1: Other colors available upon request. Note 2: Customer may specify location & coating length.

* Data provided is for Liquid Slurry utilizing Toluene as solvent. DPC (Dry Powder Concentrate) version is available to applicators... contact ND Industries for more information.

** When stored in dry, cool environment.

*** 3M and Scotch-Grip are registered trademarks of Minnesota Mining and Manufacturing Co.

**** On clean, dry or dry phosphated surfaces.

***** Depending on machine, temperature, humidity, fastener size, fastener surface and pretreatments, such as oil.

For more information on ND Microspheres Epoxy, or any of ND Industries' other quality fastening products, contact your nearest ND Service Center:

ND Western Fastener
Processing Division
13929 Dinard Avenue
Santa Fe Springs, California 90670
Phone: 562-926-3321
FAX: 562-926-4266

ND Midwestern Fastener Processing
Division/Detroit
1000 North Crooks Road
Clawson, Michigan 48017
Phone: 248-655-2529
FAX: 248-655-2562

ND Eastern Fastener
Processing Division
128-2 Bauer Drive
Oakland, New Jersey 07436
Phone: 201-651-1500
FAX: 201-651-1400

ND Southwestern Fastener
Processing Division
3611 Dalworth Street
Arlington, Texas 76011
Phone: 817-633-2788
FAX: 817-649-7730

ND Midwestern Fastener Processing
Division/Cleveland
9051 Dutton Drive
Twinsburg, Ohio 44087
Phone: 330-425-3167
FAX: 330-425-3065

ND Industries Asia, Inc./Taiwan
4-5 Lane 832 An-Jau Road
Yen-Chou
Kaohsiung, Taiwan
Phone: 886-7616-7733
Fax: 886-7616-6611

ND Midwestern Fastener
Processing Division/Chicago
1840 Raymond Drive
Northbrook, Illinois 60062
Phone: 847-498-3600
FAX: 847-498-1582

ND Southeastern Fastener
Processing Division
2220-C Center Park Drive
Charlotte, North Carolina 28217
Phone: 704-329-0033
FAX: 704-329-0975

ND Electronics (Kunshan) Co., Ltd.
395 Ye Cheng Zhong Road
Kunshan City, China 215300
Phone: 86-512-57765335
Fax: 86-512-57755353

ND Midwestern Fastener Processing
Division/Rockford
3954 South Central Avenue
Rockford, Illinois 61102
Phone: 815-963-3600
FAX: 815-963-4195



Corporate Offices

1000 North Crooks Road · Clawson, Michigan 48017 USA · Phone: 248-288-0000 · Fax: 248-288-0022
Visit our web site at www.ndindustries.com · e-mail: info@ndindustries.com

Los Angeles · Dallas · Chicago · Rockford · Detroit · Cleveland · Charlotte
New York · Orlando · Kaohsiung, Taiwan · Kunshan City, China