



Advanced Fastening and Sealing Technologies

## PRE-APPLIED ND PELL-IT®

ND Pell-it is a pre-applied process which makes either male or female threaded fasteners of virtually any size, material or finish, self-locking. ND Pell-it delivers outstanding performance in both high and low temperature extremes. Due to its compressibility, resilience and resistance to deformation, fasteners utilizing ND Pell-it processing can be repeatedly removed and adjusted.



### PRE-APPLIED PROCESS INFORMATION

#### How It Works

Customer fasteners are first sent to ND for processing. Using custom equipment we drill a hole into the fastener threads, deburr any edges, then have the part sent out for replating if necessary. Next a tough plug or pellet typically made of nylon is inserted into the hole. Completed parts are shipped back to the customer.

When assembled with a mating part the resilient pellet is compressed. This compression exerts a force 180° opposite, increasing metal to metal contact and holding the fastener in place without adhesives or thread distortion. The engineered plastic pellet provides locking action in the thread instead of at the bearing surface.



#### Dependable Positive Lock

Resistant to vibration or reversal of stress. As long as the nylon pellet has been engaged, processed fasteners lock whether seated or unseated.



#### Resists Heat & Cold

ND Pell-it processed fasteners meet or exceeds IFI Specifications 124, 524, and military Specification MIL-DTL-18240F Type N for temperatures up to +250°F (up to + 120°C).



#### Resists Chemicals

Nylon is virtually impervious to a wide range of chemicals, water, and motor fluids. Will not dry, shrink, or lose resiliency when exposed to commercial solvents, alcohol, gasoline, oil, caustic soda, jet fuel, and many other chemicals.



#### Outstanding Reusability

Due to its resilience, nylon pellet inserts can be adjusted and removed several times without substantially decreasing the fasteners locking ability.



#### Internally Threaded Parts

Any female part can be Pell-itized by the "twist" method of spinning the Pell-it into a tapped hole from the O.D. of the part. ND Pell-it processing is particularly suitable for bearing retainer nuts.



#### Press-Fit Applications

Press-Fit fasteners with pellet inserts provide a close fit without expensive close tolerances. Replaces the need for extra parts, special grooves, clips, or retaining rings.

### CONTACT US

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PRE-APPLIED

# ND PELL-IT®



## PRE-APPLIED BENEFITS

**Saves Time:** ND Pell-it processed fasteners can be automatically fed through standard feeding devices – speeding up your workflow and improving productivity.

**Saves Money:** ND Pell-it processing eliminates the need for costly lock washers, cotter pins, or castelated nuts. You get a close fit without expensive close tolerances.

**Quality Control:** Locking elements are installed with automated equipment, insuring consistent performance unlike bottled products.

**Saves Effort:** ND Pell-it processing greatly reduces the need for retightening.

**Won't work Loose:** Under most operating conditions, pellets are unaffected by vibration or reversal of stress. Locks whether your fasteners are seated or unseated, making it ideal for use with gasketed joints, plastic, or glass.

## ND PELL-IT APPLICATIONS

Military fasteners, Aerospace fasteners

## APPROVED SPECIFICATIONS

Meets or exceeds the performance requirements of the following specifications and/or standards:

- U.S. Military: MIL-DTL-18240F, MIL-F-18240E, MIL-N-25027
- Chrysler: PF-5144, PF-6157, PF-6158
- Ford: ES-382101-S100, ES-378813-S100

## PROCESSING NOTES

- ND Pell-it processing is available with Neoflon™ and Vespel® materials for higher temperature applications.
- Pellets are normally positioned one to three threads back from the end of a fastener to assure ease of starting. Special positioning can be specified for specific applications. Pellet location and diameter can be tailored to fit your needs.
- Indefinite on part life under ideal storage conditions [+40°F (+4°C) to +90°F (+32°C)], but re-certification must occur once a year.

## PRE-APPLIED SERVICE

**Step 1 - Process Selection:** Our sales and R&D staff will help you find the right process to meet your performance specifications.

**Step 2 - Shipping:** Once a selection has been made, have your fasteners shipped to one of our worldwide processing centers.

**Step 3 - Processing:** Utilizing custom, high-speed equipment, we apply the necessary materials to your exact specification.

**Step 4 - Delivery:** Once processing is complete, parts are shipped back ready for distribution or assembly.