

## INSTRUCTION FOR USE OF THREAD LOCKING KITS (TAK-LOK)



Picture for illustration only

- 1- Remove coupling before the casing is run. Thoroughly clean the male and female threads. All threads dope, oil, grease, paint, water, and lacquer **MUST** be removed to permit **THREAD LOCKING COMPOUND** to develop the maximum resistance to breakout. Solvent and brush are recommended for removing thread dope, oil and grease.
- 2- Dry threads before applying **THREAD LOCKING COMPOUND**.
- 3- Thoroughly mix contents of can, then pour the full content of accompanying bottle of catalyst into can of compound and mix thoroughly by stirring.

Apply **THREAD LOCKING COMPOUND** to male threads with a suitable paddle or with the included putty knife. Apply a thin layer of **THREAD LOCKING COMPOUND** around the first two-thirds of the PIN thread only. Do not use thread dope. **THREAD LOCKING COMPOUND** is an efficient lubricant.

Make up the joint to recommended API torque values multiplied by 1.25 friction factor. **THREAD LOCKING COMPOUND** will attain maximum breakout strength before drilling-out operations are commenced. If bottom-hole temperature is 100°F. (38° C.), maximum strength is reached in 16 to 24 hours; if temperature is 150.8 F. (66° C.), or higher, maximum strength is attained in 4 to 6 hours following the application of **THREAD LOCKING COMPOUND**. Joints locked with **THREAD LOCKING COMPOUND** can be broken out by heating the joint to 500 to 600° F. (260 to 320° C.) and immediately applying torque.

**NOTE:** the pot life of the mixture will remain in workable consistency for 30 minutes to 90 minutes under average conditions. Curing time may be reduced by elevating the temperature.

### CAUTIONS:

- Don't inhale vapors. This material is dangerous to skin and eyes.
- Mix in well ventilated area. Use rubber or plastic gloves and goggles in handling this product.
- Wash hands and face with soap and water after completion of job.
- If any material enters eyes, wash immediately at eye foundation and report to medical department.

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