ISS-1543

Shop Manual

100,125 TD-7, 8 SERIES C, E

LOADER/ DOZER

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MODEL 100, 125 SERIES C and E
LOADERS;

TD-7, TD-8 SERIES C and E
DOZERS

CHASSIS
ISS-1543

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(Replaces GSS-1426-1, and Supplement)

Due to a continuous program of research and development, some procedures, specifications and parts may be altered in a constant effort to improve machines.

Periodic revisions may be made to this publication and mailed automatically to distributors. It is recommended that customers contact their distributor for information on the latest revision.

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(0375)

INTERNATIONAL

MODEL 100, 125 SERIES C AND E LOADERS;

TD-7, TD-8 SERIES C AND E DOZERS

CHASSIS

INDEX

This manual is divided into major sections covering various components of the machines listed above. These sections are also indexed by title with thumb index tabs as shown below and to the right. To use this manual, grasp the right-hand side of book between thumb and fingers. Bend book back and find the pages containing the corresponding section index tab. Section identification is also contained in the upper corner of each page.

SECTION

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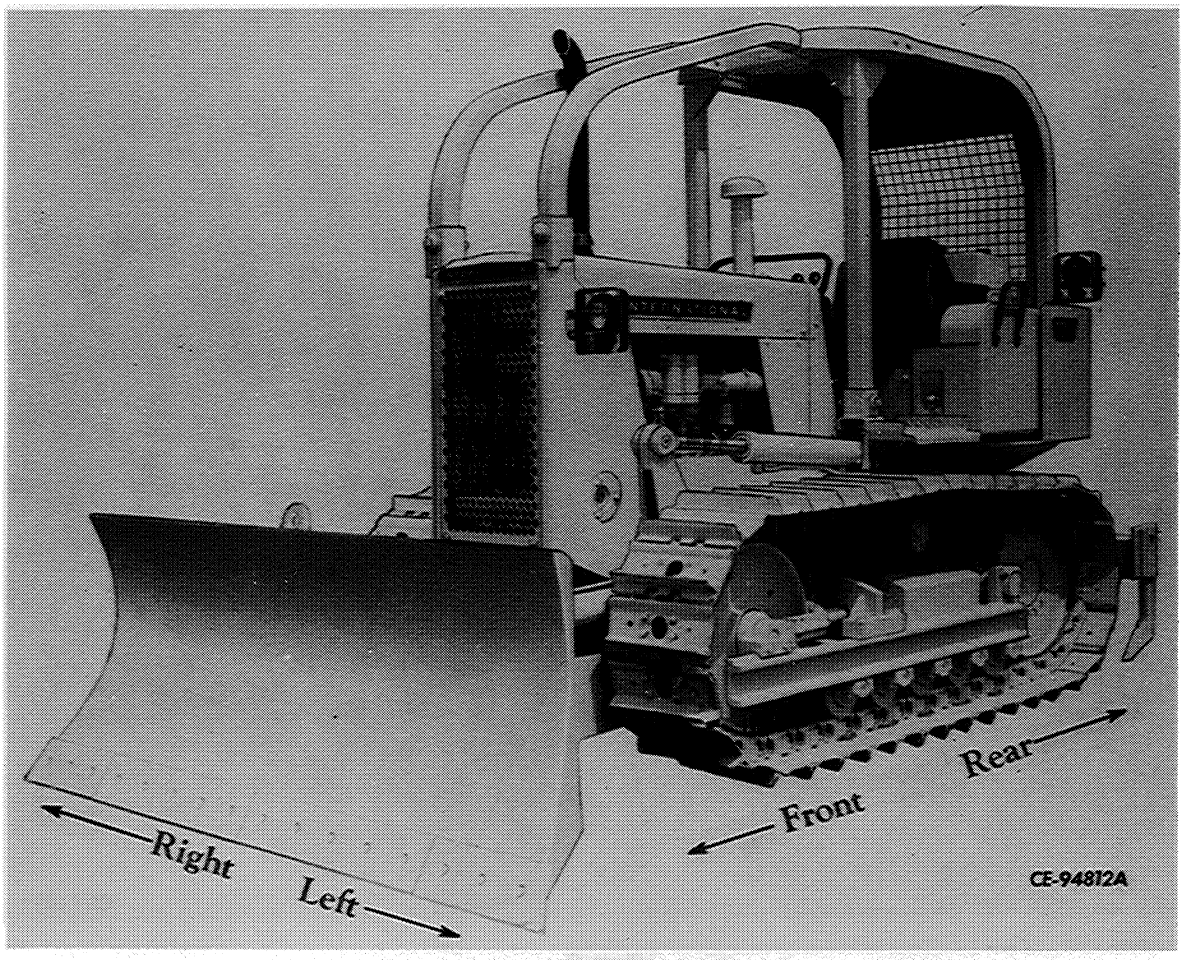
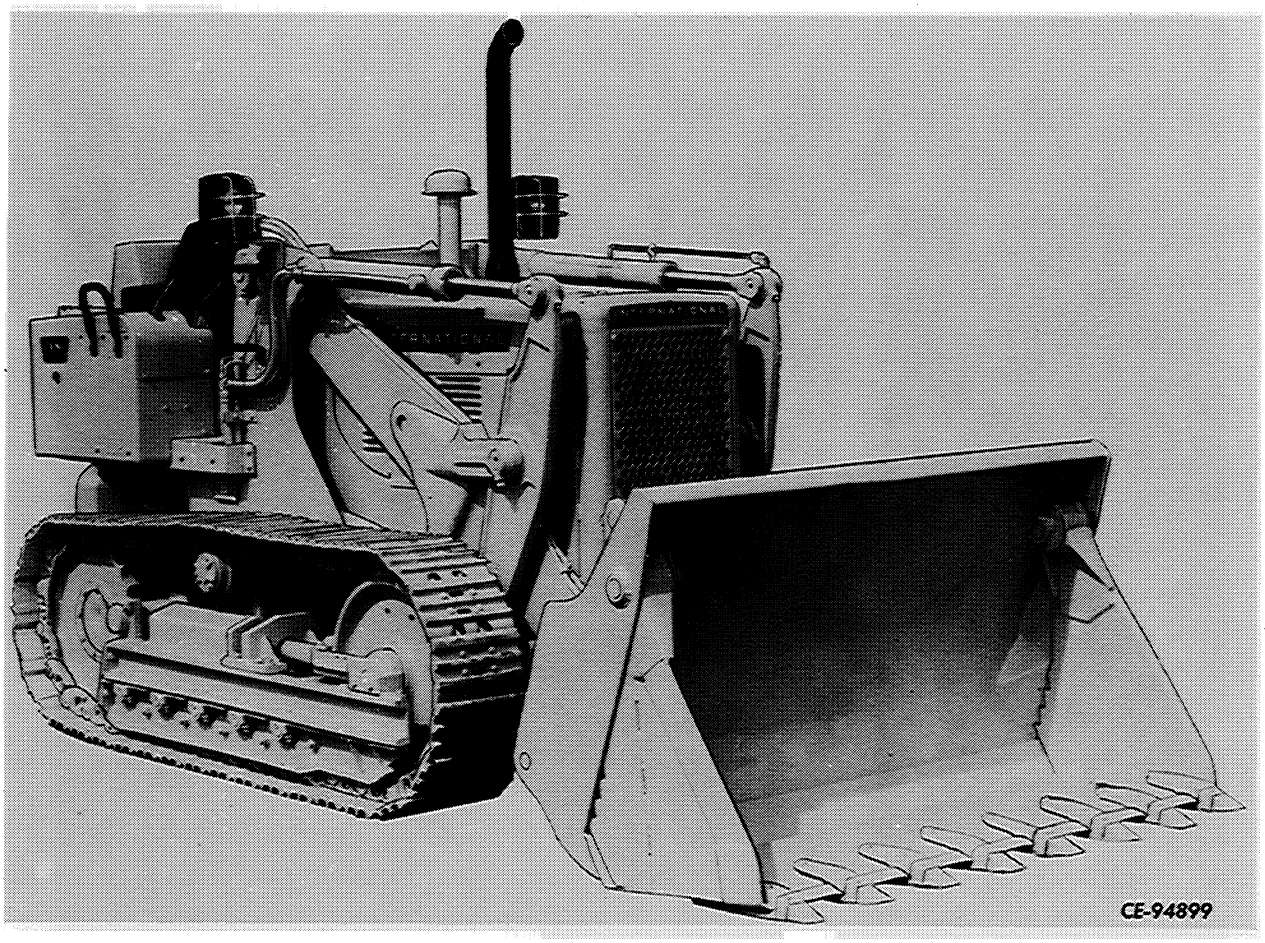


Illust. 1
TD-8 SERIES E Inside Arm Dozer with Ripper (TD-8 SERIES C, TD-7 SERIES C and E Similar)



Illust. 2
Model 100 SERIES E with Multi-Purpose Bucket (Model 100 SERIES C, Model 125 SERIES C and E Similar)

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SPECIFICATIONS

NOTE: Specifications listed apply to all machines except when otherwise indicated.

GENERAL DATA

TRACKS:

Tread (center-to-center of tracks)	52 in. - TD-7C,E and 100C,E
	54 in. - TD-8C,E and 125C,E
Length of tracks on ground	72 in. - TD-7C,E and 100C,E
	74.8 in. - TD-8C,E and 125C,E
Width of standard track shoe	12 in. - TD-7C,E and 100C,E
	13 in. - TD-8C,E and 125C,E

TRACK DIMENSIONS:

	TD-7C,E	100C,E	TD-8C,E	125C,E
Length (over-all) inches:				
Tractor only	107.4	--	111.7	--
Bucket flat on ground	--	154.5	--	166.3 (Std.) 172.8 (Multi-Purpose)
Width (over-all) inches:				
Tractor only (Std. shoes)	64	--	67	--
Standard bucket	--	68.5	--	71.7
Height (over-all) inches (less pipes and lights)	70	73.7	73	72
Ground clearance, inches	--	13.1	--	15
Drawbar height (to center line of clevis) inches	18.1	--	20.7	--

WEIGHTS (Approximate Pounds):*

TD-7C,E and TD-8C,E	Series C Gear Drive	Series C and E Power Shift
Tractor only (TD-7C,E)	9,350	9,430
(TD-8C,E)	11,300	11,350
Tractor with inside arm bullgrader:		
with backhoe (TD-7C,E)	16,550	16,650
(TD-8C,E)	19,540	19,640
without backhoe (TD-7C,E)	12,410	12,510
(TD-8C,E)	15,400	15,500
100C,E and 125C,E		
Standard bucket (100C,E)	13,761	13,872
(125C,E)	17,095	17,206
Multi-Purpose bucket (100C,E)	14,545	14,656
(125C,E)	17,905	18,016

*Weight includes basic tractor or loader with fuel and coolant, crankcase and transmission guards, track roller shields, drawbar and sprocket rock guards.

SPECIFICATIONS

ENGINE SPEEDS

Full load	2500 ± 10 rpm
Low idle	700 ± 50 rpm

ENGINE FLYWHEEL AND HOUSING

Flywheel pilot bore run-out (inch)	.005 max.
Flywheel housing bore I. D. run-out (inch)	.012 max.
Flywheel housing mounting face run-out (inch)	.008 max.

HYDRAULIC TORQUE CONVERTER

Make and size	Rockford (10" - TD-7C, E and 100C, E) (10-1/2" - TD-8C, E and 100C, E)
Type	Single stage with fixed stator
Transmission and torque converter supply pump:	
Make	Cessna
Rotation	Counterclockwise as viewed from drive shaft end
Flow (gpm at 1977 pump rpm (2500 engine rpm) and 160 psi)	27.4

TRANSMISSION (GEAR DRIVE)

Supply pump	
Make	Cessna
Rotation	Clockwise as viewed from drive shaft end
Flow (gpm at 1596 pump rpm (2500 engine rpm) and 160 psi)	19
Width of slot in shifter collar, inch	.245-.255
Width of gear shift fork fingers, inch	.230-.240

SPRINGS

Description	Free Length Inches	Test Length Inches	Test Load Pounds	Number of Coils
Clutch pack compression springs:				
Inner	5/16	3/16	2	7
Outer	1/4	3/16	11-13	4
Regulator valve:				
Transmission and steering valve	2-7/8	1-7/8	39	14
Oil cooler valve	2-5/8	1-7/8	15	13
Lubricating oil valve	2-9/16	1-7/8	3-1/2	16
Range selector valve:				
Selector valve spool detent	2-15/16	1-7/16	56	8
Dump valve	1-5/8	29/32	29-1/4	11

TRANSMISSION (POWER SHIFT)

Transmission and converter supply pump (refer to "Hydraulic Torque Converter" in this section).

Pilot control valve inlet flow:	
Fluid supply via hose 3/16" I.D. x 55" long at 150° F. and 150-170 psi	3.6 - 4.0 gpm
Separator plate dowel pin O. D., inches	.3710 - .3715
Separator plate dowel pin bore, inches	.372 - .373
Dowel pin clearance in bore, inches	.0005 - .002
Maximum allowable clearance, inches	.005

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TRANSMISSION (POWER SHIFT) - Continued

SPRINGS

Description	Free Length Inches	Test Length Inches	Test Load Pounds	Number of Coils
Regulator valve:				
Transmission and steering valve:				
Earlier Models	2.875	1.875	39	14
Later Models:				
Spool	2.218	1.375	86	10
Poppet	.917	.550	5.5	12
Converter by-pass valve	2.610	1.875	15	13
Lubricating oil valve	2.565	1.875	3.45	16
Range selector valve spool	2.563	1.375	52	15
Pilot control valve detent	2.813	1.375	29	8
Clutch pack compression springs:				
Inner	.313	.188	2	7
Outer	.250	.188	11-13	4

STEERING SYSTEM

Planet gear assembly:	
Earlier Series C Machines:	
Bore diameter, inch	.8132 - .8137
Shaft diameter, inch	.6248 - .6253
Thrust washer thickness, inch	.025 - .031
Series E Machines and Later Series C Machines:	
Bore diameter, inch	.9251 - .9256
Shaft diameter, inch	.6743 - .6748
Thrust washer thickness, inch	.025 - .031
Clutch disc sun gear bushing diameter, inches	3.743 - 3.746
Bushing inside diameter, inches (assembled in bearing cage)	3.7500 - 3.7535
Clutch and brake shoe thrust washer thickness, inch	.187 - .189
Eccentric shaft bearing surfaces, inches:	
Shaft mounting bearings	1.6245 - 1.6250
Clutch and brake shoe bearings	2.1244 - 2.1250

SPRINGS

Description	Free Length Inches	Test Length Inches	Test Load Pounds	Number of Coils
Steering control valve:				
Inner	2-1/4	1-5/16	67	13
Outer	1	1/2	95-105	4-1/4
Clutch and piston lever return springs	6-3/8	9-1/8	20	68
Brake pedal return spring	9-7/8	12	118	48-1/4

SPECIFICATIONS

SPROCKET DRIVE

Description	TD-7 Series C 100 Series C	TD-7 Series E 100 Series E	TD-8 Series C 125 Series C	TD-8 Series E 125 Series E
Housing bearing bores (inches):				
Sprocket shaft outer	5.1148 - 5.1161		5.1148 - 5.1161	
Sprocket shaft inner	3.2635 - 3.2645		3.2480 - 3.2490	
Pinion shaft outer	3.2635 - 3.2645		3.2635-3.2645	3.4360-3.4370
Pinion shaft inner	3.8735 - 3.8745		4.3287 - 4.3297	
Shaft bearing mounting diameter (inches):				
Sprocket shaft outer	3.3480 - 3.3492		3.3480 - 3.3492	
Sprocket shaft inner	1.7510 - 1.7520		1.6885 - 1.6895	
Pinion shaft outer	1.7510 - 1.7520		1.7510 - 1.7520	
Pinion shaft inner	2.2510 - 2.2520		2.2510 - 2.2520	

TRACK ASSEMBLY

	TD-7 SERIES C,E 100 SERIES C, E	TD-8 SERIES C,E 125 SERIES C, E
Track link pin dia., inches	1.246 - 1.250	1.3710 - 1.3750
Track master pin dia., inches	1.237 - 1.239	1.367 - 1.368
Track link bushing, inches: ID	1.263 - 1.272	1.388 - 1.398
OD	1.7995 - 1.8035	2.049 - 2.053
Master bushing, inches: ID	1.263 - 1.272	1.388 - 1.398
OD	1.7995 - 1.8035	2.049 - 2.053

(Continued on next page)

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TRACK ASSEMBLY - Continued

	TD-7 SERIES C,E 100 SERIES C, E	TD-8 SERIES C,E 125 SERIES C, E
Master bushing spacer, inches: ID	1.255 - 1.285	1.380 - 1.410
OD	1.800 - 1.830	2.049 - 2.070
Track pitch length (dist. between pin centers), inches	6	6-1/2 (6.500)
Maximum permissible pitch length, inches	6-1/8 + (6.125)	6-5/8 + (6.625)
Maximum permissible track pin wear, inch	1/16 + (.0625)	1/16 + (.0625)
Maximum permissible track pin bushing wear, inch: ID	1/16 + (.0625)	1/16 + (.0625)
OD	1/8 + (.125)	1/8 + (.125)
Track link height, inches	3-3/16 (3.1875)	3-3/8 (3.375)
Maximum permissible track link wear, inch	1/4 (.250)	1/4 (.250)
Track shoe grouser height, inches (std. shoe)	2(TD-7C,E)11/16 (100C,E) (.6875)	2-1/8(TD-8C,E) (2.125) 3/4 (125C,E) (.750)
Maximum permissible grouser wear, inch (std. shoe)	7/8 (TD-7C,E) (.875)	1-1/8(TD-8C,E) (1.125)
Hydraulic track adjuster rod diameter, inches	1.7478 - 1.7516	1.8728 - 1.8766
Front idler fork cylinder inside diameter, inches	1.879 - 1.882	1.879 - 1.882
Front idler:		
Shaft diameter, inches	1.742 - 1.744	2.242 - 2.244
Bushing ID (assembled), inches	1.752 - 1.755	2.252 - 2.253
Body bore diameter, inches	1.873 - 1.875	2.373 - 2.375
Thrust washer thickness, inch	.083 - .087	.083 - .087
Flange height, inch	11/16 (.6875)	5/8 (.625)
Maximum permissible flange height, inch	15/16 (.9375)	7/8 (.875)
Rolling dia. (dia. at point of contact with track chain), inches	22	23-1/2
Maximum permissible wear of rolling dia., inch	1/2 (.500)	1/2 (.500)
Track idler:		
Body bore diameter, inches	1.749 - 1.751	1.749 - 1.751
Shaft diameter, inches	1.742 - 1.744	1.742 - 1.744
Thrust plate thickness, inch	.230 - .240	.230 - .240
Body flange height, inch	3/8 (.375)	7/16 (.4375)
Maximum permissible flange height, inch	9/16 (.5625)	5/8 (.625)
Rolling dia. (dia. at point of contact with track chain), inches	6	6
Maximum permissible wear of rolling dia., inch	3/8 (.375)	3/8 (.375)
Track roller:		
Shaft diameter, inch	1.742 - 1.744	1.992 - 1.994
Thrust washer thickness, inch	.083 - .087	.083 - .087
Width of roller body (distance between thrust washer mating surfaces)	6.703 - 6.713	7.185 - 7.195
Body bore diameter, inches	1.873 - 1.875	2.123 - 2.125
Bushing ID (assembled), inches	1.752 - 1.755	2.002 - 2.005
Body flange height, inch	1/2 (.500)	9/16 (.5625)
Maximum permissible flange height, inch	11/16 (.6875)	13/16 (.8125)

+ - Pitch increase (caused by track pin wear and bushing internal wear) and bushing external wear of 1/8 (.125) inch is permissible for all applications. However, on less severe operations, wear of 3/16 (.1875) inch is allowed. The type of operation and soil in which the unit is running determines which wear figure is acceptable. When in doubt, use 1/8 (.125) inch as the limit.

SPECIFICATIONS

TRACK ASSEMBLY - Continued

	TD-7 SERIES C, E 100 SERIES C, E	TD-8 SERIES C, E 125 SERIES C, E
Rolling dia. (dia. at point of contact with track chain), inches	6-7/8 (6.875)	7-3/8 (7.375)
Maximum permissible wear of rolling dia., inch	3/8 (.375)	1/2 (.500)
Track spring:		
Free length, inches	22-9/16 (22.5625)	20-7/8 (20.875)
Test length, inches	18-1/4 (18.250)	17-13/16 (17.8125)
Test load, lbs.	12,100	14,700
Number of coils	13-1/4 (13.250)	10-3/4 (10.750)

HYDRAULIC CYLINDERS

Make . . . . . IH
Type . . . . . Double acting
Bore, inches:
- TD-7C, E (all cylinders) 3
- TD-8C, E (all cylinders) 3-1/2
- 100C, E Lift cylinder (general and multi-purpose bucket) 3-1/2
  - Tilt cylinder (general and multi-purpose bucket) 3
  - Clam cylinder (multi-purpose bucket) 3-1/2
- 125C, E Lift cylinder (general and multi-purpose bucket) 4
  - Tilt cylinder (general and multi-purpose bucket) 3-1/2
  - Clam cylinder (multi-purpose bucket) 4

Stroke, inches:
- TD-7C, E Lift cylinder 16
  - Tilt cylinder 4-3/4
  - Angle cylinder 13-3/4
- TD-8C, E Lift cylinder 17-5/8
  - Tilt cylinder 5-5/8
  - Angle cylinder 13-7/8
- 100C, E Lift cylinder (general and multi-purpose bucket) 31-1/4
  - Tilt cylinder (general and multi-purpose bucket) 18-5/8
  - Clam cylinder (multi-purpose bucket) 9-3/8
- 125C, E Lift cylinder (general and multi-purpose bucket) 32-1/4
  - Tilt cylinder (general and multi-purpose bucket) 18-5/8
  - Clam cylinder (multi-purpose bucket) 10-3/8

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HYDRAULIC CONTROL VALVE (GRESEN)

Type	Open center, series - parallel
Main relief valve opening pressure, psi	
(TD-7 C and E, TD-8 C and E, 100 C and 125 C)	2000 + 50
(100 E and 125 E)	2150 + 50
Circuit relief valve opening pressures, psi (100 C and E, 125 C and E Only)	
Inlet section (one used)	3300 + 100
Mid section	
Bonnet side	3300 + 100
Lever side	3300 + 100
Outlet section	
Used on two spool valve	
Bonnet side	3300 + 100
Lever side	3300 + 100
Used on three spool valve	
Bonnet side	2300 + 100
Lever side	3300 + 100
Spools:	
Inlet section	Four position, detented and spring centered
Mid section	Three position, spring centered
Outlet section	Three position, spring centered
Section with "Bucket Self Leveling"	Three position, electric release detent, spring centered
Check valve (each section)	One
Anti-cavitation valve	
TD-7 C and E, TD-8 C and E	One in inlet section
100 C and E, 125 C and E	
(with two spool valve)	One in inlet section and one in outlet section
(with three spool valve)	One in inlet section and one in middle section
Centering spring	
Inlet Section	
Free length, inches	3-5/32 - 3-7/32
Test length, inches	1-7/16
Test load, lbs.	45 - 55
Number of coils	6 - 7
Middle and outlet sections	
Free length, inches	2-21/32 - 2-23/32
Test length, inches	1-3/8
Test load, lbs.	46-3/4 - 57-1/4
Number of coils	7 - 8
Section with "Bucket Self Leveling"	
Free length inches	2-21/32 - 2-23/32
Test length, inches	1-3/8
Test, load, lbs.	46-3/4 - 57-1/4
Number of coils	7 - 8

SPECIFICATIONS

EQUIPMENT HYDRAULIC PUMP

Make	Cessna
Type	Gear (positive displacement)
Rotation (viewed from drive shaft end):	
Gear drive machines	Clockwise
Power shift machines	Counterclockwise
Capacities (plus or minus 15% when using IH Flo-Rater):	
TD-7C, E	13.6 gpm @ 2027 pump rpm (2500 engine rpm) and 2000 psi
TD-7C, E and 100C, E with backhoe:	
Front section	15.5 gpm @ 2027 pump rpm (2500 engine rpm) and 2000 psi
Rear section	8.7 gpm @ 2027 pump rpm (2500 engine rpm) and 2000 psi
100C, E and TD-8C, E	22.4 gpm @ 2027 pump rpm (2500 engine rpm) and 2000 psi
TD-8C, E and 125C, E with backhoe:	
Front section	18.9 gpm @ 2027 pump rpm (2500 engine rpm) and 2000 psi
Rear section	9 gpm @ 2027 pump rpm (2500 engine rpm) and 2000 psi
125C, E	29 gpm @ 2027 pump rpm (2500 engine rpm) and 2000 psi

SPECIAL TORQUE DATA FOR NUTS AND BOLTS (FOOT-POUNDS)

(Torque values are for nuts and bolts lubricated with engine oil unless otherwise stated.)

Engine rear mounting block bolts	33 - 37
Transmission and torque converter supply pump body bolts	40 - 45
Gear drive transmission pump	40 - 45
Gear drive transmission:	
Reverse idler shaft nut (Molykote applied)	245 - 280
Pinion shaft bevel pinion bolt	360 - 405
Pinion shaft front bearing plate bolt	400 - 450
Suction filter cap screw	33 - 37
Power shift transmission:	
Reverse idler shaft nut (Molykote applied)	245 - 280
Range clutch shaft bevel pinion bolt	360 - 405
Range clutch shaft front bearing nut (Molykote applied)	300 - 350
Pressure filter hold-down bolt	40 - 50
Suction strainer cover cap screws	33 - 37
Bevel gear-to-gear carrier mounting bolts (steering system)	68 - 75
Bevel gear carrier bearing cage mounting bolts (steering system)	53 - 60
Brake back-up shoe adjusting screw jam nut (steering system)	100 - 150
Track assembly:	
Hydraulic track adjuster check valve	45 - 55
Hydraulic track adjuster pressure relief valve	45 - 55
Track idler, front idler and track roller lubrication plugs (Permatex No. 2 applied)	15 - 25
Track shoe bolt	115 - 130
Carrying frame tie rod mounting nuts:	
(Backhoe and winch applications):	
Plain	1100 - 1150
Phosphate coated	900
(All other applications):	
Plain	580 - 620
Phosphate coated	480
Rear main frame cover mounting bolts	33 - 37
Front frame - to - rear frame mounting bolts:	
Plain	420 - 470
Phosphate coated	400
Carrying frame clamp bolts:	
TD-7C and E	690
TD-8C and E	1030

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SPECIAL TORQUE DATA FOR NUTS AND BOLTS (FOOT-POUNDS)
(Torque values are for nuts and bolts lubricated with engine oil unless otherwise stated.)

Front frame-to-rear main frame lower mounting bolts (100C and 125C) (Secure lock nut after torquing bolt	10 - 15
Electrical system:	
Light switch nut	10 - 15
Safety switch nut	15 - 20
Starting switch nut	15 - 20
Dash light mounting nut	15 - 20

Equipment hydraulic system:	Type 8, phe coated	Type 5, cad. coated
Lift, tilt and angle cylinder piston nut (TD-7C and E).	330 - 370	450 - 500
(TD-8C and E).	440 - 480	600 - 650
Lift cylinder piston nut (100C and E)	400 - 450	540 - 580
(125C and E)	600 - 650	750
Bucket tilt cylinder piston nut (100C and E)	330 - 370	450 - 500
(125C and E)	600 - 650	900 - 950
Clam cylinder piston nut (100C and E)	380 - 430	600 - 650
(125C and E)	430 - 480	700 - 750

Lift, tilt and angle cylinder retaining ring (TD-7C and E)	450 - 500
(TD-8C and E)	600 - 650
Lift cylinder retaining ring (100C and E)	600 - 650
(125C and E)	800 - 1000
Bucket tilt cylinder retaining ring (100C and E)	450 - 500
(125C and E)	600 - 650
Clam cylinder retaining ring (100C and E)	600 - 650
(125C and E)	800 - 850
Hydraulic pump body bolts	60 - 70

NOTE: Except for the special torques shown, all bolts and nuts are to be given a standard torque. Refer to the "STANDARD TORQUE DATA CHART" in this section.

SPECIFICATIONS

TORQUE VALUES FOR STANDARD FASTENERS

This chart provides tightening torque for general purpose applications using original equipment standard hardware as listed in the Parts Catalog for the machine involved. DO NOT SUBSTITUTE. Original equipment standard hardware is defined as IH Type 8, coarse thread bolts and nuts and thru hardened flat washers (Rockwell "C" 38-45), all phosphate coated and assembled without supplemental lubrication (as received condition).

The torques shown below also apply to the following.

1. Phosphate coated bolts used in tapped holes in steel or gray iron.
2. Phosphate coated bolts used with phosphate coated prevailing torque nuts (nuts with distorted threads or plastic inserts).
3. Phosphate coated bolts used with copper plated weld nuts.

Markings on bolt heads or nuts indicate material grade ONLY and are NOT to be used to determine required torque.

NOMINAL THREAD DIAMETER	STANDARD TORQUE ± 10%	
	FOOT LBS.	NEWTON METERS
1/4	7	10
5/16	14	19
3/8	24	32
7/16	38	51
1/2	60	80
9/16	80	110
5/8	115	155
3/4	200	270
7/8	320	440
1	480	650
1-1/8	590	800
1-1/4	830	1100
1-3/8	1100	1500
1-1/2	1400	1900
1-3/4	2300	3100
2	3400	4600

SPECIAL TORQUES

Each machine has some non-standard torques which are necessary for proper component function. These are listed under "SPECIAL TORQUES" shown elsewhere in this manual. Typical examples are hose clamps, non-rigid joints (gaskets), non-ferrous fasteners or tapped holes, spanner nuts, fine thread fasteners, jam nuts, and cases where loading or distortion are critical factors.

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TORQUE VALUES FOR HOSE CLAMPS

The following chart provides the tightening torques for hose clamps used in all rubber applications (radiator, air cleaner, operating lever boots, hydraulic system, etc.)

Clamp Type & Size	Torque Plus or Minus 5 in. lbs. (0.6 N.m.)			
	Radiator, Air Cleaner, Boots, etc.		Hydraulic System	
	Inch Lbs.	Newton Meters	Inch Lbs.	Newton Meters
"T" Bolt (any diameter)	60	6.8	45	5.1
Worm Drive - 1-3/4" Open Diameter & Under	25	2.8	45	5.1
Worm Drive - Over 1-3/4" Open Diameter	45	5.1	45	5.1

TORQUE VALUES FOR SPLIT FLANGE CONNECTIONS

The following chart provides the tightening torques for split flange connections used in hydraulic systems. Split flanges and fitting shoulders should fit squarely. Install all bolts, finger tight and then torque evenly.

NOTE: Overtorquing bolts will damage the flanges and/or bolts, which may cause leakage.

Flange Size (*)	Bolt Size	Bolt Torque	
		Foot Lbs.	Newton Meters
1/2	5/16	15 - 18	20 - 24
3/4	3/8	22 - 27	30 - 37
1	3/8	27 - 35	37 - 47
1-1/4	7/16	35 - 45	47 - 61
1-1/2	1/2	46 - 58	62 - 79
2	1/2	55 - 65	75 - 88
2-1/2	1/2	79 - 91	107 - 123
3	5/8	138 - 150	187 - 203
3-1/2	5/8	105 - 115	142 - 156

(*) - Inside diameter of hydraulic tube or hose fitting.

LOCTITE RETAINING AND SEALING COMPOUNDS

(Special Loctite data, if any, is shown in the specific section of this manual that is affected.)

GENERAL

Compound Description

These products are single component, self-curing, polyester compounds which remain liquid while exposed to air, and harden by chemical action into tough structural solids when confined between closely mated metal parts. These compounds will resist solvents, heat, shock and vibration and are intended to provide a positive seal against leakage, and shear strength resistance to loosening when used in the assembly of threaded, slip fit, or press fitted parts.

Loctite Grades (General Usage)

DO NOT substitute grades or usage unless specified.

1. GRADE B (YELLOW) - Straight threaded fasteners.

2. GRADE "AVV" or 277 (RED) - Straight threaded fasteners, higher strength for studs, etc.

3. PLASTIC GASKET (RED) - Use as seal between mating surfaces (face sealant).

4. HVV (UNFILLED PIPE SEALANT) (BROWN) or *PIPE SEALANT WITH TEFLON (WHITE) - Use on tapered pipe threads.

   * - PIPE SEALANT WITH TEFLON is limited to systems without filters or filters with a mesh larger than 40 microns. Apply to male threads only.

5. HYDRAULIC SEALANT (BROWN) - Fuel fittings, straight pipe threads.

6. REFRIGERANT SEALTANT - All air conditioning fittings.

7. R/C 35 - Cylindrical applications. Maximum gap filled at maximum strength .003"; 80% strength at .010" maximum gap. Normally used with PRIMER "T".

8. R/C 601 - Maximum strength for press fit application.

9. IS-12 - Fast setting cyanoacrylate adhesive for bonding metals, plastics, ceramics, rubber, etc.

10. PRIMER "T" - Provides fast curing and highest cure strength for above materials except R/C 35.

11. PRIMER "N" - Provides maximum strength for R/C 35 (approx. 50% more strength) but at a slower rate of cure than with PRIMER "T".

Temperature Range

Once cured, these compounds have an operating temperature range of -65 to 300° F., and will resist attack by oils, chemicals, hydraulic fluids and solvents.

Exceptions - DO NOT use Loctite:

1. Where other means of retaining the assembly are provided such as, prevailing torque fasteners (fasteners with distorted threads or plastic inserts), lock washers, lock plates and lock wires.

2. On items requiring frequent servicing.

3. When the operating temperature exceeds 300° F. (Example: Engine exhaust systems.)

4. On brass fittings and plugs.

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