

Bolt Cleaning & Thread Treatment

We've previously discussed how important it is to correctly torque bolts so they don't loosen and break. To obtain correct torque, however, bolts must be clean and have proper thread treatment.

Bolt Cleaning

Clean and degrease all internal and external threads prior to applying threadlocker, anti-seize or primer and installing hardware. If the threads are not properly cleaned, the threadlocker, primer, and/or anti-seize will not properly cure or perform.

Make sure the internal and external threads are free of dirt or debris.

Use brake cleaner or a similar cleaning solvent on all threads to remove any grease or oil.

Allow the threads to dry.

Threadlocker

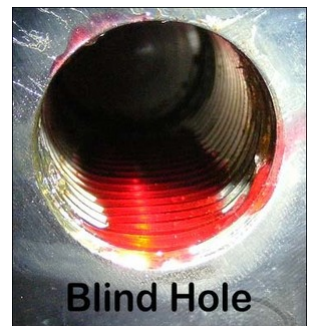
For bolted connections requiring threadlocker, apply Loctite 263 or primerless equivalent using the following procedure:

Clean and degrease all threads.

For thru holes or nuts, apply threadlocker to bolt threads.

For blind holes, apply a stripe of threadlocker along the length of the hole. Do not apply to the bolt as doing so can cause escaping air to remove the threadlocker as the bolt is inserted.

Torque the bolt to the Wet Torque Value specified in the [Genesis Fastener Manual](#).



For threaded hydraulic fitting connections, apply Loctite 5452 or equivalent thread sealant in conjunction with Loctite 7471 primer using the following procedure:

Clean and degrease all threads.

Apply Loctite 7471 primer to the external and internal threads and allow to dry.

Apply threadlocker to 360 degrees of the threads on the male fitting, ensuring adequate coverage.

Assemble the fitting according to the directions in the [Safety & Operator's Manual](#) for your specific attachment.

For O-ring boss and flat face O-ring connections, torque the fittings to the values specified in the [Fastener Manual](#).



Anti-Seize

For bolted connections requiring anti-seize lubrication, apply Loctite LB8008 or equivalent using the following procedure:

Clean and degrease all threads.

Apply a thin coat of anti-seize to the internal and external threads and under the bolt head and/or nut, ensuring complete coverage.

Torque the bolt to the Wet Torque Value specified in the [Fastener Manual](#).



No Thread Treatment

Clean and degrease all threads.

Torque the bolt to the Dry Torque Value specified in the [Fastener Manual](#).

Proper bolt cleaning and maintenance extends bolt and overall attachment life. If you have torque or thread treatment questions, contact Tim at 218-349-5755, talseth@genesisattachments.com.