EUROBASE (8 or 12 inch) and HPI base (8 inch)

Replace Studs On Site

Introduction

Replace M10 studs on **EUROBASE (8 or 12 in)** and **HPI base (8 in)** mounting bases already installed in the field, where access time is limited.

Tools

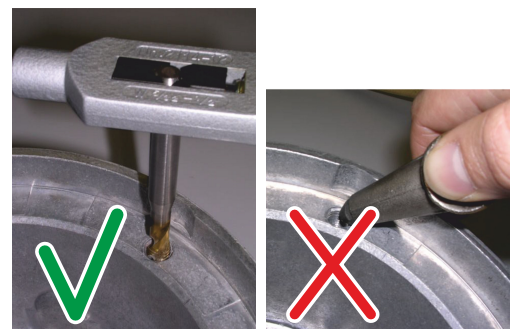| Tool	Product information	Part number
Thread cleaning device	M10	
Go/no-go thread gauge	M10	
Go/no-go height gauge (8-inch bases)	21 mm-0/+0.5 mm	SP.013183
Go/no-go height gauge (12-inch bases)	22.5 mm-0/+0.5 mm	SP.013186
M10 stud installation kit (60 studs)		SP.013184 (includes 60 studs and necessary Loctite 638 and Loctite 7649 Activator N)
Others: • screwdriver • pressurized air • dry, clean cloth		

Procedure

1. Turn the loose stud out of the threaded hole of the base using a screwdriver. If the unscrewing torque exceeds 60 Nm, heat up the base locally to release the studs.

   Note: For the highest torques, use the square section of the studs instead of the slotted top.
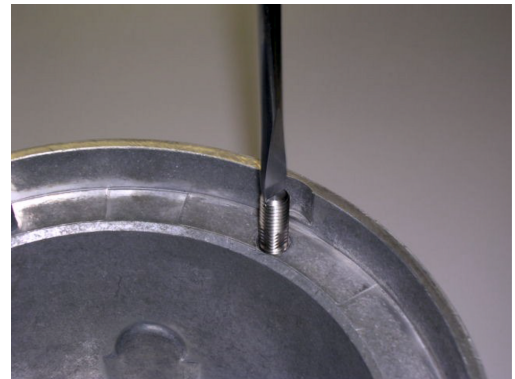

2. Remove old Loctite residues using a thread-cleaning device, size M10.
   Clean with pressurized air (for example) to make sure the threaded hole is dry and free of dirt.
   Ensure that the thread-cleaning device is correctly aligned with the thread hole. Clean the thread-cleaning device after use.

3. Check the thread inside the threaded hole for damage, by using a go/no-go M10 thread gauge.

GO   NO GO
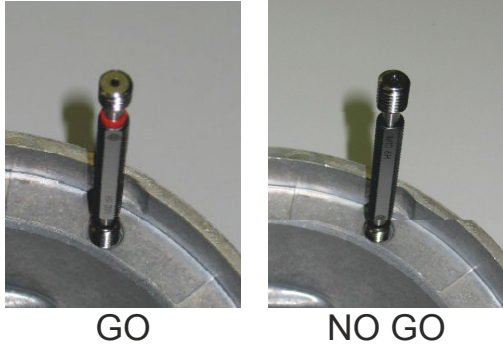
4. Take a new stud. Verify that the stud is dry and free of dirt. Spray Loctite 7649 Activator on the stud and inside the threaded hole. Clean the thread-cleaning device after use.

5. Apply Loctite 638 Blockpresse inside the threaded hole at four opposite points and on the first two or three threads of the stud.

6. Turn the stud in the threaded hole of the base using a screwdriver. Verify the height of the stud by using the specific 8 inch or 12 inch gauge. If necessary adjust the height by slightly turning the stud in and out using the screwdriver.

Note: Make the height adjustment within the first minute because the Loctite 638 is already curing.
Do not move the stud once it has been adjusted in height.

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7. Check if the Loctite 638 is sufficient to fill the void between the stud and the threaded hole. Remove excess Loctite 638 using a dry and clean cloth.

8. Allow the Loctite 638 to cure sufficiently, for about 5 to 10 minutes before installing the light/cover and snep-nut.

Note: See the Loctite 638 Blockpresse Data Sheet for curing times vs. temperature.

- Personnel performing this repair shall be trained and qualified. They shall observe the applicable safety regulations.
- Communicate MSDS information to personnel and ensure hands on training.
- Take into consideration the specific recommendations regarding safe handling and storage of Loctite 638 Blockpresse and Loctite 7649 Activator.
  See the Loctite 638 and Loctite 7649 Data Sheet available on the internet www.loctite.com.

www.adbsafegate.com

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