

YORK INTERNATIONAL CORPORATION  
P. O. BOX 1592  
YORK, PA. 17405-1592

M-355-94

(717) 771-7890

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INTER-OFFICE MEMO

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DATE: March 24, 1994  
TO: A. S. Service  
FROM: D. C. Bull - 36BE  
SUBJECT: PIPE THREAD SEALANTS

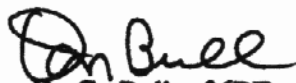
In our ongoing effort to further reduce Warranty expenses we will be standardizing on pipe thread sealants used throughout YORK International Corporation.

Three (3) Loctite products will be used corporation wide to accomplish our goal of reducing thread joint leaks. They are:

1. All pipe threads up to and including 1" will use Loctite 554, YORK P/N 013-02894-000.
2. All pipe threads above 1" will use Loctite 567 (PST), YORK P/N 013-02280-000.
3. The 2" and 2 1/2" pipe threads, (Oil Drain Down Lines) on the YT's and YK's will use Loctite 086 (AVV), YORK P/N 013-01671-000.

Remember that bad flare's, pipe fittings or tubing that leaks should be removed and returned to me for presentation to our Warranty Task Force.

**NOTE:** This procedure **DOES NOT** apply to ParaFlow Absorption Units. Refer to Form 155.17-NM1 (SB-3) for proper pipe thread sealant procedures for ParaFlow units.

  
D. C. Bull - 36BE  
SERVICE ENGINEER

UNCONTROLLED COPY  
Effective Date 6/1/94

**LOCTITE**

**York** Applied Systems  
YORK INTERNATIONAL



**AVV 086**

013-01671-000

Very high strength locking of coarse threads. Color: Red



**565**

013-02023-000

Pipe sealant for removable metal tapered pipe thread fittings (except stainless steel). Color: white.



**AV 087**

013-01046-000

High strength locking of coarse threads. Sealing of rolled-in tubes in shell & tube heat exchangers (See ASO Standard M-339). Color: Red



**567**

013-02280-000

Pipe sealant for removable stainless steel tapered pipe thread fittings. Color: White



**290**

013-02887-000

Formulated especially for pre-assembled fasteners by capillary action. Color: Green



**675**

013-01752-000

Retaining bushings and sleeves. Color: Green



**242**

013-01678-000

Medium strength locking of threads when hand tool removal is required. Color: Blue



**680**

013-02886-000

Medium viscosity retaining compound. Color: Green



**515**

013-02827-000

Making gaskets, coating gaskets to improve sealing, repairing damaged conventional gaskets. Color: Red



**N 7649**

013-01753-000 1.75 oz.  
013-02982-000 1 gallon

General purpose primer used after cleaning. Use prior to application of any Loctite product. Not a cleaner. Replaced Primers T & NF. Color: Clear



**554**

013-02894-000

Refrigerant pipe sealant up to 1" dia. Diameters over 1" will require heat to disassemble. Color: Red



**7070**

013-02899-000

Cleaner to be used on male and female threads prior to application of Loctite primer and Loctite adhesive. Color: Green



\* Consult Loctite Technical Data Sheets for curing specifications, strength, effect of temperature, gap filled, chemical resistance, etc.  
AC is a TM; Gasket Eliminator, 242, PST, and Loctite are Reg. TMs of Loctite Corporation, Hartford, CT 06106.

Containers shall be marked with a date code as the first two digits of a six digit alpha-numeric marking. Bottles are ink stamped on the direction label. Cans are ink stamped on the bottom. Tubes are ink stamped in the crimp at the bottom of the tube.

Year of manufacture (1994) ——— Example: 4KP270  
Month of manufacture A-L for January - December  
Example: 8KP270  
Year of manufacture (1994) ——— Example: 8KP270  
Month of manufacture A-L for January - December

Shelf life for all compounds is 1 year from date of shipment or 2 years from date of manufacture. Vendor shall provide a Certificate of Conformance insuring that 1 year of life remains on all shipments. Primer N has a life of 1 year from date of manufacture.