









## LOCKING

- **Locking by bonding**

Both components of the assembly adhere together after curing of the micro-encapsulated adhesive applied on the threads.

- **Polyamide or mechanical locking**

Locking is achieved by elastic deformation of a product applied on the threads. The product used is most often polyamide (nylon) applied locally or over the entire circumference of the threads.

## TORQUES

- **Braking torque (Cfv)**

Maximum torque measured when the assembly is stressed.

- **Tightening torque (Cser)**

Torque required to tighten a screw to a level of stress.

- **Loosening torque (Cdes)**

Torque measured after the breakaway point when unscrewing adhesive-coated screws. We can talk about a break loose torque when the assembly is bonded.

- **Locking torque on unscrewing (Cfd)**

Maximum residual locking torque after release on a single turn of the screw.

For reusable locking, Cfd1 is used for the first turn of the screw and Cfd 5 for the fifth turn of the screw after five successive assemblies.

## THREAD M AND S

- The thread M is defined by the ISO standard whilst the thread S is defined by the NIHS standard of the Swiss watch-making industry.