ADHESIVE R&D

iPipe 65 SEALANT

Description

Anaerobic adhesive for sealing of metal thread pipe joints. Suitable for gas, LP gas, compressed air, gasoline and oil, industrial fluids, CFC, potable water and several chemicals. Low friction coefficient will assure easy assembly. Thixotropic property prevents migration from thread of the sealant before or during curing. Replaces P.T.F.E. tape and yarn. Cured product provides elastic film. Shocks and vibrations resistance are uneffected properties of sealing in the range of temperature from -55 to +150°C. Easy dismantling is assured even after years.

Directions of use

Clean and degrease parts for best results. Apply sealant to male threads only, use enough product to fill the joint completely. Assemble parts, avoid overtighting due to lubricating effect of product. llow time to cure as function of room temperature, gap of threads and type of metal, usually ready to use after 1-3 hrs. For instant sealing and or in the case of low temperatures or large gaps apply a small amount of Activator 11 on female threads and proceed as above. Loxeal 18-10 is not recommended for use on plastics.

Properties of uncured material

* Composition	: anaerobic methacrylate
* Colour	: off – white to avory
* Viscosity (25°C - mPa.s)	: 17.000 - 50.000 thixotropic
* Specific weight (25°C - gr/ml)	: 1,05
* Friction coefficient μ	: about 0,10
* Max diameter of thread/gap filling	: 2” / 0,30 mm
* Flash point	: about 100°C
* Solvent content	: none
* Shelf life 23°C (T max <28°C)	: 1 year

Curing properties and performance of cured material

(Zinc plated bolt M 10 x 20 - quality 8.8 - nut h = 0,8.d)

* Handling cure time	: 20 - 40 minutes
* Functional cure time	: 1 - 3 hours
* Full cure time	: 5 - 10 hours
* Shear strength (ASTM D-1002)	: 4 - 6 N/mm²
* Tensile strength (ASTM D-2095)	: 3 - 5 N/mm²
* Elongation at break	: over 100%
* Locking torque	: (ISO 10964 not preloaded)
- breakaway	: 7 - 10 N.m
- prevailing	: 2 - 4 N.m
* Temperature range	: -55 +150°C

note: several tests indicate that product can bear temperature of 180-200°C for short periods, keeping the sealing effects.

Handling and safety properties

Refer to Material Safety Data Sheet.