



## TECHNICAL INFORMATION

### 977 PIPE SEALANT WITH P.T.F.E

#### DESCRIPTION

977 Pipe sealant with P.T.F.E is a high viscosity thixotropic gel paste which cures rapidly, sealing instantly to 10 bar through its Anaerobic cure system in contact with Metals in the absence of air (oxygen). When fully cured it resists pressure up to 350 bar.

977 also has WRAS approval, BSEN 751-1 approval.

#### APPLICATIONS

Typical applications are in sealing all types of threaded connections against water, oil, gases and most common materials conveyed by pipes. 977 is not recommended for oxygen rich systems under pressure.

#### USEFUL HINTS/NOTES

Where cure speed is extended due to low temperatures or inactive surfaces, activator can be used. Best results are found if 977 Pipe sealant is applied to 2<sup>nd</sup> or 3<sup>rd</sup> threadform. Excess can be wiped away - any migration into lines will not solidify and can be flushed away during commissioning.

#### PROPERTIES

977 exhibits excellent adhesion to brass and copper and can resist the effects of expansion and contraction without leakage.

Fast Cure to fixture usually <15 minutes @ 20C

Temperature Range: -50°C to + 150°C

Typical Strength: 6 N /mm(2) prevailing

Typical Breakloose 12N/m.

Recommended Thread sizes 6mm up to 75mm (coarse)

Increase of gap size or fit extends the cure time.

#### DIRECTIONS FOR USE

- Parts should be clean, dry and dust free.
- Degreased parts will assist results.
- Apply sufficient product to fill joint.
- Assemble parts in traditional manner.
- To achieve handling strength allow product to cure (approximately 30 minutes).
- Store in cool conditions.
- Keep out of direct sunlight

#### COMPATIBLE ACTIVATORS

7800 Standard Anaerobic Activator can be used

However, up to 30% strength loss can occur when using accelerators.

#### TECHNICAL FEATURES

##### Physical Properties (liquid product)

Chemical base: Methacrylate Diester Di-Ester

Colour: Yellow / Fluorescent

Viscosity:

25°C Brookfield DVII

60000-85000mPas Spindle 6 @2.5rpm

25000-35000mPas Spindle 6 @20rpm

Density: 1.10 25°C

Max.thread diameter: 3 inches

Max. gap filling: 0.50mm

Flash point: >100°C

##### Physical Properties (cured product) @ 23°C

Measured on M10 x 20 bolt – grade 8.8 zinc galvanised – nut 0.8d loose free running

1. Initial strength after: 15 – 30 minutes
2. Functional strength after: 1 – 3 hours
3. Final strength 3 – 6 hours
5. Loose-break torque 15-20Nm (M10)
6. Prevailing torque: 10-15Nm (M10)
7. Shear Strength: 6-13 N/mm<sup>2</sup> DIN54452
8. Thermal range: -55°C up to +150°C

#### STORAGE

Shelf Life:12 months @ 20C

#### PACKAGING

Bottles: 50ml , 65ml & 250ml and Bulk up to 20Kg.

#### HEALTH & SAFETY IN USE

Please refer to MSDS

IRRITANT: R43 - R36/37/38 - S23 - S24/25 - S37/39 - S51

Contains Methacrylate Esters

TDS 977-01  
09-06-08



Portobello Industrial Estate, Birtley, County Durham, United Kingdom, DH3 2RE Tel: +44 (0)191 411 3191 Fax: +44 (0)191 411 3192

E-mail: info@holdtite.com Web: www.holdtite.com

The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Holdtite and its agents cannot assume liability or responsibility for results obtained in the use of its products by persons whose methods are outside or beyond our control. It is the users responsibility to determine the suitability of any of the products and methods of use or preparation prior to use mentioned in our literature and furthermore the users responsibility to observe and adopt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.