



## TECHNICAL DATA

# INOX SEAL

## Anaerobic Adhesive

### (Pipe Bonder & Thread Locking Compound)

INOX SEAL is a high-strength adhesive, especially developed for use on passive materials, such as: stainless steel, aluminium, nickel, gold and chromate layers.

INOX SEAL cures in the absence of air between tightly fitting metal surfaces, protects metal threads from oxidation or corrosion and prevents automatic loosening and leaks.

INOX SEAL is highly resistant to heat, vibration, water, gases, oils, hydrocarbons and many chemicals.

INOX SEAL shortens assembly and repair time enormously. Time-consuming sanding work is eliminated and blue discoloration as occurs in the welding process is prevented.

### APPLICATIONS:

- Ideal for bonding stainless steel push-in fittings and pipes.
- For securing threads which are exposed to high stresses, such as: studs, nuts, screws, pipe and drive fittings.
- For sealing pipe and screw connections in the gas, water, and heating sectors.
- For food sectors, waterworks, sewage treatment plants, marine, mechanical engineering, etc.

### Adhesive Properties:

Composition:	Dimethacrylate Ester
Colour:	Red
Viscosity: (Brookfield RVT Spindle 3 @ 20 rpm)	1.250 to 4.250 cps @ 77°F / 25°C
Specific Gravity:	1.15
Diameter Ø of Thread:	1½" (M36)
Gap Filling:	0.20 mm
Flash Point:	> 210°F / 100°C

### Aushärteeigenschaften:

Handling Cure Time:	4 - 6 minutes	
Functional Cure Time:	1 - 3 hours	
Full Cure Time:	24 hours	
Breakaway Torque: (3/8 x 16 steel nuts and bolts)	11 N.m. / 100 lb.in	ISO 10964
Prevail Torque: (3/8 x 16 steel nuts and bolts)	14 N.m. / 125 lb.in	ISO 10964
Temperature Range:	-65°F to 300°F / -55 to 150°C	

### Physical Properties:

Coefficient of Thermal Expansion:	$80 \times 10^{-6}$	ASTM D 696, K-1
Coefficient of Thermal Conductivity:	0.10	ASTM C 177.W/(m·K)
Specific Heat, kJ/(kg·K):	0.30	



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### Chemical Resistance:

Material	Temperature	% Initial Strength Retained	
		500 hrs	1000 hrs
Acetone:	22°C	100	85
Ethanol:	22°C	100	100
Motor Oil:	125°C	100	95
Petrol/Gasoline:	22°C	100	100
Brake Fluid:	22°C	100	100
Water/Glycol:	87°C	90	80

### Instructions for use:

The surface must be clean, dry and free of contaminants such as oil or grease. If the material consists of passive metal, or if the cure is too slow, an activator should be used. Shake thoroughly before use.

Pipes and Fittings: Abrade the parts to be bonded (pipe, fitting) with grit sanding paper in order to provide an optimal bonding surface. Cover the surface of the pipe on the area to be bonded thickly.

Threaded Pipes: Apply the product ensuring that the spacing between the threads is sufficiently filled.

For through-holes: Apply the product to the screw in the area where the nut will sit. For blind holes: Apply the product to the lower third of the inner thread or to the bottom of the bore. Disassembly: Low and medium strength anaerobic adhesives can be disassembled using standard hand tools. High strength anaerobic adhesives must be heated to 250°C - 300°C.

Cleaning: Insert the cured product in solvent and then mechanically remove.

For maximum pressure and solvent resistance, allow the product to harden for at least 24 hours.

### Storage

Anaerobic adhesives should be stored in a cool, dry place at a room temperature between 8°C to 28°C. The shelf life is at least 1 to 2 years (depending upon storage conditions). Product residue should not be returned to the original container, in order to preserve the original properties.

**Additional Information:** 1.) Permanently installed connections may not be realigned. Should it be necessary to remove the thread, it must be completely removed and cleaned, then the fitting can be sealed again using a fresh product application. As a realignment of pre-assembled threaded connections is not possible, this product, along with other liquid or anaerobic sealants is not to be used for gas installations according to DVGW-TRGI. 2.) This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Stress cracking can occur when used on thermoplastic. It is recommended to test compatibility on plastics before use.

**General information:** The information contained herein serves merely as an indication and is given to the best of knowledge. The users must test the suitability of the product for her/its/their respective application independently however. All products purchased from or supplied by Nohtec are subject to terms and conditions set out in the contract. Nohtec warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Nohtec is considered accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Nohtec makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will infringe any patent.