



DATA SHEET

Fortafix High Temperature Adhesives

AUTOSTIC ROCKSETT: HIGH TEMPERATURE THREAD-SEALANT

- Water based high temperature resistant thread-locking sealant.
- Designed for use in threads and cylindrical assemblies operating at high temperatures.
- A maximum continuous operating temperature of 700 - 800°C.

Typically Used For

- Thread-locking
- Sleeves
- Turbines
- Foundry equipment
- Calibration nuts
- Gas ignitor assembly

Principal Characteristics

- Suitable for Bonding, and Thin films/Coatings.
- **Maximum Continuous Service Temperature: 700-800°C.**
- Available as a clear liquid.
- Ready to use.

Softening Temperature	700°C	Melting Temperature	800°C	Wet Density	1.45 g/cm ⁻³
pH	13	Tensile Strength	1.4 N/mm ²	Tensile Strength	1.5 MPa
Volume Resistivity	>10 ⁹ Ωcm	Max. Shear Strength	3.0 MPa	Expansion	0
Oxidation Resistance	Excellent	Acid Resistance	Excellent – Except hydrofluoric	Dispensable	Yes
Gap filling	>0.15 mm	Packaging	70 g, 1 litre		

Health and Safety / Environmental Information

- **See separate MSDS sheet. (MSDS –Autostic Rocksett – High Temperature Thread Sealant).**
- **RoHS Compliant.**

Guidelines For Use

Application

- Stir/shake contents of the container prior to use, to ensure product is thoroughly mixed.
- Thoroughly clean and degrease all surfaces to be bonded or sealed.
- A light surface abrasion of the material to be bonded will increase the surface area available for adhesion and improve mechanical key.
- Apply the sealant as supplied to all surfaces to be bonded and complete tooling within 5-10 minutes.
- Apply moderate pressure to ensure even anchorage and solid contact of the surfaces to be bonded, so that all surfaces are fully wetted.
- Allow the product to set.

Curing Schedule

- As this product is water based, it is necessary to fully dry and dehydrate the adhesive.
- The curing of this product may vary depending on temperature, humidity, porosity of substrates, volume of adhesive and area etc.
- Curing may be accelerated by the application of gentle and progressive heat (do not exceed 100°C during curing as this may lead to product failure).
- The cured product may be removed using steam/ boiling water (high pH will also aid removal).

Storage

- Once opened this product is moisture sensitive, avoid continuous exposure to air.
- Product should be stored in original packaging between 5 - 30°C.
- Shelf life – 12 months.