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
- Turbines
- Sleeves
- 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.

<table>
<thead>
<tr>
<th>Softening Temperature</th>
<th>700°C</th>
<th>Melting Temperature</th>
<th>800°C</th>
<th>Wet Density</th>
<th>1.45 g/cm³</th>
</tr>
</thead>
<tbody>
<tr>
<td>pH</td>
<td>13</td>
<td>Tensile Strength</td>
<td>1.4 N/mm²</td>
<td>Tensile Strength</td>
<td>1.5 MPa</td>
</tr>
<tr>
<td>Volume Resistivity</td>
<td>&gt;10⁹ Ωcm</td>
<td>Max. Shear Strength</td>
<td>3.0 MPa</td>
<td>Expansion</td>
<td>0</td>
</tr>
<tr>
<td>Oxidation Resistance</td>
<td>Excellent</td>
<td>Acid Resistance</td>
<td>Excellent – Except hydrofluoric</td>
<td>Dispensable</td>
<td>Yes</td>
</tr>
<tr>
<td>Gap filling</td>
<td>&gt;0.15 mm</td>
<td>Packaging</td>
<td>70 g, 1 litre</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
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.