



RITE-LOK™ Pipe Sealant PS65

Product Data Sheet

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Product Description RITE-LOK PS65 is a single component, low strength, anaerobic pipe sealant. PS65 is a very high viscosity, thixotropic pipe sealing paste possessing high lubricity. PS65 cures when confined in the absence of air between close-fitting metal surfaces.

Key Features RITE-LOK PS65 is formulated to lock and seal medium to coarse straight and tapered pipe threads on pipes of diameter from 15mm to 80mm. PS65 prevents vibration loosening and leakage through the pipe threads. PS65 gives low strength break and prevail torque on assembled joints, thus enabling easier disassembly and servicing, which is further helped by the lubricity of PS65. PS65 will give a rapid low pressure seal (after 20 mins).

Physical Properties	Chemical Type	Dimethacrylate
	Appearance	White Paste
	Specific Gravity	1.17
	Viscosity cPs (Brookfield RVT 'T'-spindle D, 2.5rpm)	Range 150,000 – 450,000
	Viscosity cPs (Brookfield RVT 'T'-spindle D, 20rpm)	Range 30,000 – 85,000

Performance Characteristics	Maximum Gap Fill	0.50mm
	Fixture Time	≤120 mins
	Full Cure	24hrs
	Strength Build Up	≥120 mins = Finger tight 6 hours = ~35% strength 24hours = 100% strength
	Breakaway Torque N.m (ISO 10964)	Range 2 – 10 Typical 3.5
	Prevail Torque N.m (ISO 10964)	Range 0.5 – 4 Typical 1.5
	Service Temperature Range	-50 to +150°C

Additional Product Information Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.
PS65 is suitable for most straight and tapered pipe threads of medium to coarse pitch, for pipe diameters from 15mm to 80mm. PS65 will not cure outside the joint and is virtually non-fouling in most types of pipe systems. PS65 is not recommended on certain plastics as stress cracking can sometimes result. Some anti-corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of parts is necessary. AC64 Activator may be required on plated parts.

Application Techniques Apply adhesive to all engaged threads, although to minimise excess adhesive inside the joint, apply adhesive only to the male part, leaving the first two threads clear. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint.
Product is normally hand applied from the bottle. Dispensing systems are available for high volume assembly applications.
Heating the assembled parts accelerates the curing process.
AC64 Activator may be used to accelerate cure and should be used if the application temperature is below 5°C. The use of an accelerator may reduce the final bond strength by up to 30%

Storage Conditions Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months.
Refrigeration to 5°C gives optimum storage stability.

Shelf Life 12 months from date of despatch by 3M when stored in the original carton at 21°C

Precautionary Information Refer to product label and material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com

For Additional Information To request additional information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA

Product Use All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable the user's method or application.

Note Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendation

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