



PRODUCT DATA

MARWELD M-17 PIPE & FLANGE THREAD SEALANTS FOR POTABLE WATER SERVICE

DESCRIPTION

M-17 is a two-component liquid polymer system that cures at room temperature.

M-17 Standard Grade — viscosity: approx. 10,000 cps (similar to 90 wt. gear oil)

M-17 Type F — viscosity: approx. 12,000 cps (with resistance to flow, similar to heavy latex paint)

M-17 Type 2 — viscosity: approx. 8,000 cps (faster curing - lower temps. similar to 90 wt. gear oil)

M-17 Type F2 — viscosity: approx. 12,000 cps (faster curing - lower temps. resistance to flow, similar to heavy latex paint)

USES

M-17 is designed for sealing threads in all diameter properly threaded and fitted ductile iron, cast iron and steel pipe joints and flanges to produce a permanent pressure seal. M-17 has been used successfully for over 50 years in the industry. M-17 is designed as a sealant/lubricant for potable water service. M-17 seals most deformed threads providing for less "leakers". M-17 retains a degree of resilience allowing the seal to withstand stresses of handling, installation, and movement in the field and maintain a proper seal.

Tests among various users show M-17 to be superior to handling, application, and end results to any other seal material for this purpose. Tests are regularly performed with water pressure (500 psi) for a 24 hour period, results; no leakage. All types of M-17 are cleared by E.P.A. for drinking water contact. Copies of certificates available upon request.

PACKAGING

Packaging is available in 1, 2, & 4 gallon units/5, 30, & 55 gallon containers. The mix ratio is one part component A to one part component B, by volume for all grades.

SURFACE PREPARATION

If water-soluble thread cutting oil is used, washing the newly cut threads and drying immediately prior to sealing is recommended. However, if a non-water soluble oil is used it is recommended that the threads of both surfaces be cleaned with perchloroethylene prior to application.

MIXING AND APPLICATION

Surface must be dry and above 55°F.* Thoroughly mix the M-17 components in a ratio of one part A to one part B by volume until the system is uniform. Application may be made by brush, paint roller, plastic squeeze bottle, etc. Do not use any additives.

Apply directly to the threads insuring that all thread valleys are covered. Thread two parts together, remove any excess material, and allow to cure.

M-17 is water-soluble before initial set; clothes, tools may be

washed in warm water, otherwise with solvent mentioned.

CURING

WORKING TIME AFTER MIXING

cooler Standard Grade Type F warmer
more time approx 45-60 mins. @ 75°F (23°C) less time

cooler TYPE 2 TYPE F2 warmer
more time approx 30-45 mins. @ 75°F (23°C) less time

Initial set occurs after working time expires.

CURING TIME TO HANDLE/TEST

cooler Standard Grade Type F warmer
more time approx 8 to 12 hours @ 75°F (23°C) less time

cooler TYPE 2 TYPE F2 warmer
more time approx 4 to 8 hours @ 75°F (23°C) less time

Complete cure occurs in 72 hours.

NOTE: Curing time may be reduced considerably with the use of heat lamps or a drum heater band applied at the juncture of pipe and flange. Maximum temp on uncured sealant: 175°F (79°C).

NOTE: Working time is also dependent upon the amount of sealant mixed. Larger volumes of sealant will have less working time at any temp.

HANDLING

M-17 compounds A & B may be irritable to the skin of some persons. Avoid contact with skin or eyes. In case of contact, immediately flush skin well with soap & water; for eyes, flush with water for at least 15 minutes and get medical attention. Do not take internally. Avoid prolonged breathing of vapor. Use with adequate ventilation. Keep out of reach of children. See applicable SDS.

SHELF LIFE

Approx. two years in tightly closed containers. Some settling of contents over prolonged periods will require vigorous stirring of each component to re-suspend these particles prior to use.

SHIPPING

MARWELD M-17 (All types) are considered hazardous under O.S.H.A. and are regulated by D.O.T., I.M.O., & I.A.T.A. See SDS.

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PRODUCT DATA

MARWELD M-17 TYPE AC & AC2 THREAD SEALANTS FOR ACID SERVICE

DESCRIPTION

M-17 Type AC & AC2 are two component liquid thread sealants that cure in the threads at room temperature range. Type AC & AC2 are designed for Phosphoric and 98% Sulfuric Acid piping at a service temp. range of -30°F (-34°C) to 300°F (148°C). Type AC & AC2 are designed for all diameters of ductile iron and MONDI* piping. Type AC & AC2 will provide a permanent pressure seal when applied according to the following information on properly threaded and fitted connections. Type AC2 is an accelerated version providing a faster cure in lower temps.

PACKAGING

Type AC & AC2 are packaged in one, two, four and ten gallon units. Larger units are available upon request.

SURFACE PREPARATION

If water soluble thread cutting oil is used, washing and drying immediately prior to sealing is recommended. Otherwise, it is recommended that the threads of both surfaces be cleaned with perchloroethylene (non-flammable hydrocarbon solvent used widely in metal cleaning) prior to sealing.

MIXING & APPLICATION

Surfaces must be dry and should be above 55°F (12°C). Thoroughly mix the M-17 components A & B in a ratio of one part A to one part B by volume. The mixture will become an olive green color to indicate the proper mix ratio. Continue mixing, making certain to scrape the sides and bottom of the mixing vessel to ensure complete mixing of the two components to a homogeneous state. Application to the surfaces may be made by spatula or brush. Apply directly to the threads of both pipe and flange covering all thread valleys. Make up the parts and remove any excess sealant. Allow to cure. Types AC & AC2 are water soluble before initial set and clothes and tools may be cleaned in warm water, otherwise with the solvent mentioned.

CURING

WORKING TIME AFTER MIXING

cooler  approx 45-60 mins.  warmer
TYPE AC @ 75°F (23°C)
more time less time

cooler  approx 30-45 mins.  warmer
TYPE AC2 @ 75°F (23°C)
more time less time

Initial set occurs after working time expires.

CURING TIME TO HANDLE/TEST

cooler  approx 8 to 12 hours  warmer
TYPE AC @ 75°F (23°C)
more time less time

cooler  approx 4 to 8 hours  warmer
TYPE AC2 @ 75°F (23°C)
more time less time

Complete cure occurs in 72 hours.

NOTE: Curing time may be reduced considerably with the use of heat lamps or a drum heater band applied at the juncture of pipe and flange. Maximum temp on uncured sealant: 175°F (79°C).

NOTE: Working time is also dependent upon the amount of sealant mixed. Larger volumes of sealant will have less working time at any temp.

HANDLING

M-17 components A & B may be irritable to the skin of some persons. Avoid contact with skin and eyes. In case of contact, immediately flush skin with water; for eyes, flush with soap and water for at least 15 mins. and get medical attention. Do not take internally. Avoid prolonged breathing of vapor. Use with adequate ventilation. Keep out of reach of children. See applicable SDS.

SHELF LIFE

Approx. two years in tightly closed containers. Some settling of contents over prolonged periods will require vigorous stirring of each component to re-suspend these particles prior to use.

SHIPPING

MARWELD M-17 Types AC & AC2 are considered hazardous under O.S.H.A. Type AC & AC2 are regulated by D.O.T., I.M.O., & I.A.T.A. See SDS.

* A trademark of the Monsanto Company.

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PRODUCT DATA

MARWELD M-17 TYPES FG & FG2 LEAK REPAIR SEALANTS

DESCRIPTION

M-17 Types FG & FG2 are two component polymeric sealants in gel or paste form designed for non-sag application. They can be applied by various means including manual or powered caulking guns. Type FG operates in temperatures of 70°F(21°C) to 1200°F(480°C). Type FG2 operates in temperatures of 320°F(0°C) to 70°F(21°C). At temperatures above 750°F(23°C) Type FG2 will have a shortened working time after mixing. Type FG2 is an accelerated version of Type FG. Service temperature for Types FG & FG2 is 350°F(177°C).

USES

Types FG & FG2 are designed for making leak repairs on all types of piping except polyethylene or polypropylene. Types FG & FG2 can be used to repair damaged or leaking piping in place where it is impossible or impractical to remove or replace the piping. This includes repairs at joints where various types of joining or coupling devices are used. The pressure of the fluid in the piping must be reduced to zero psi prior to application and remain until curing is complete. Types FG & FG2 will bond to damp, oil free surfaces. The sealants may also be used to bond anchor flanges, wall rings, or wall collars to pipe.

PACKAGING

Repair kits are available in 1/4, 1, 2, 4, & 10 gallon sizes. The mix ratio is 1 part Component A to 1 part Component B by volume for both types.

SURFACE PREPARATION

Surfaces to receive sealant must be clean, dry as possible, and free of any contaminant that may inhibit a bond. This includes oil, grease, paint, coatings, and rust. It is recommended to final clean metal surfaces with a solvent that will remove any oil based film or grind surface to bare metal prior to application of the sealant.

MIXING AND APPLICATION

It is recommended that persons handling the sealant components wear protective gloves such as latex to preclude skin contact. Carefully and thoroughly mix equal parts by volume of components A&B in a clean container until a homogeneous mix is obtained. Apply by gloved hand, manual or power caulking gun or other means to completely cover and fill the damaged area. If sealing a leaking coupling device, form a continuous bead or fillet around the pipe filling any void between pipe and coupling. If the leak bleeds through, build a thicker layer of sealant until the flow is stopped. Pressure in the piping should be at zero psi during application and subsequent curing of the sealant. CAUTION: Mix only the amount of Type FG2 that will be used within the WORKING TIME. Mixed Type FG2 left in the mixing container beyond the WORKING TIME will generate considerable heat!

CURING

WORKING TIME AFTER MIXING

TYPE FG- lower temp.= approx. 45-60 mins. higher temp.=
more time @ 75°F(23°C) less time

TYPE FG2- lower temp.= approx. 60-70 mins. higher temp.=
more time @ 50°F(10°C) less time

CURING TIME TO HANDLE/TEST

TYPE FG lower temp.= approx. 12 hours higher temp.=
more time @ 75°F(23°C) less time

TYPE FG2 lower temp.= approx. 6 hours higher temp.=
more time @ 50°F(10°C) less time

Complete cure occurs in 72 hours.

NOTE: Curing time may be reduced considerably with the use of heat lamps or a drum heater band applied at the juncture of pipe and flange. Maximum temp on uncured sealant: 175°F (79°C).

NOTE: Working time is also dependent upon the amount of sealant mixed. Larger volumes of sealant will have less working time at any temp.

HANDLING

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