



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 LV — viscosity: approx. 4,000 cps (similar to 40 wt. motor 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 35 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
Standard Grade Type LV, Type F
cooler more time < approx 45-60 mins. @ 75°F (23°C) > warmer less time

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

Initial set occurs after working time expires.

CURING TIME TO HANDLE/TEST
Standard Grade Type LV, Type F
cooler more time < approx 8 to 12 hours @ 75°F (23°C) > warmer less time

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

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 not considered hazardous under O.S.H.A. and are not regulated by D.O.T., I.M.O., or I.A.T.A.

TECHNI-SEAL INTERNATIONAL • P.O. BOX 120274 • SAN ANTONIO, TX 78212 USA • 210-733-9925 • FAX: 210-733-0918

IMPORTANT NOTICE & WARRANTY: All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed, and the following is made in lieu of all warranties, express or implied. Seller's and manufacturer's only obligation shall be to replace such quantity of the product proved to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith. No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY
WASHINGTON, D.C. 20460

MAY 17 1983

Mr. John B. Martin
Techni-Seal International
(formerly RJ Manufacturing, Inc.)
P.O. Box 120274
San Antonio, Texas 78212-9474

RE: File Number 11-1AEB82

Dear Mr. Martin:

Based on information submitted, the product listed below is acceptable for use as a pipe and flange thread sealant for potable water applications when used within the conditions stated below:

Product: Marweld M-17 Pipe and Flange Thread Sealant

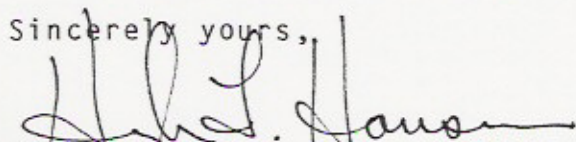
- Conditions:
1. The product is properly applied according to the manufacturer's specifications.
 2. The product continues to meet the specifications of good manufacturing practices.
 3. After complete curing, the pipe and flange thread assembly is thoroughly rinsed with potable water prior to being placed in service.

We would not anticipate any adverse health effects resulting from such use of this product assuming the product continues to meet the supplied specifications.

We are currently in the process of revising our evaluation procedures as outlined in the Federal Register, Vol. 44, No. 141, 42775-8, Friday, July 20, 1979. When these revisions are completed and the interim procedures are in place, all existing advisories will be periodically reviewed.

Our opinion concerning the safety of the product does not constitute an endorsement, nor does it relate to its effectiveness for the intended use. If this letter is to be used in any way, we require that it be quoted in its entirety.

Sincerely yours,

A handwritten signature in black ink, appearing to read "Hugh F. Hanson". The signature is fluid and cursive, written over the typed name.

Hugh F. Hanson, P.E., Acting Chief
Additives Evaluation Branch
Criteria and Standards Division
Office of Drinking Water (WH-550)

cc: Regional Drinking Water Representatives
Holders of the Water Supply Guidance Series
Mr. John Trax, State Programs Division, ODW