Technical Bulletin

Performance you can trust

To whom it may concern

Please find below a guide to best practice for making joints using ROCOL sealants

- The thread on the pipe must be of a good quality and made using sharp dies and a cutting lubricant such as ROCOL RTD Compound, Liquid or Spray.
- Rough threads, both male and female, can cause the sealant to be scraped off during assembly.
- Threads need to be cut square i.e. Dies and Die Chasers need to be set square to the pipe and set to the correct dimensions.
- Cutting lubricants should be cleaned from the thread using a solvent based degreasing agent that does not leave any residue such as ROCOL INDUSTRIAL CLEANER Rapid Dry Spray or ROCOL ELECTRA CLEAN Spray.
- When threads are clean and dry it is preferable to apply sealant to both male and female threads to ensure good adhesion.
- Hemp or Hemp substitute may be used as filler, but must be applied after the sealant is applied to the pipe, with a further coating of sealant over the hemp, i.e. sealant/hemp/sealant.
- Hemp or Hemp substitute should not be in direct contact with the pipe surface as this could leave a potential for leakage particularly in the long term as the hemp dries out.
- PTFE pipe tape should NOT be used in conjunction with the sealant, as the sealant will not adhere to the PTFE which may result in leaks occurring over time.
- When the joint is assembled, all surplus sealant should be removed, a fillet between the pipe and the fitting should NOT be left as this slows down the curing process of the sealant which dries out by capillary action. The skin that forms on any remaining fillet can drastically slow down, or even stop, the curing process leaving the sealant soft and prone to leakage.
- The curing process of STEAMSEAL occurs by capillary action in 2 stages. By solvent release, over approximately one hour, then by air curing of the linseed/veg oil base by capillary action over 24 hours+ at temps between +20°C & 25°C, longer at lower temperatures. Although a tightened fitting may resist low pressures after the initial solvent evaporation, the pipework should not be disturbed or pressure tested for 24 hours after the joint is made.
- The curing process of OILSEAL, FUELSEAL & PIPESEAL occurs by solvent evaporation over over 24 hours+ at temps between +20°C & 25°C, longer at lower temperatures.
- The joints can be left open for up to 30 minutes before assembly which will aid the solvent evaporation.
- If the joints need to be put back into service immediately ROCOL Twineflon Dynamic Universal PTFE Thread Sealant may be used as this product requires no curing time.
- NB. Twineflon should be used independently and NOT in conjunction with any other sealant.

ROCOL Technical Department 2014

T +44 (0) 113 232 2600
F +44 (0) 113 232 2740
E customer-service@rocol.com
www.rocol.com
ROCOL House, Swillington, Leeds LS26 8BS

Registered Company No. 559693 VAT No. 742 0531 67
Registered Office: Admiral House, St Leonard's Road, Windsor, Berkshire SL4 3BL

ROCOL A division of ITW Ltd

FM 12448 EMS 67596 OHS 78173

INVESTORS IN PEOPLE