

TECHNICAL DATA

ThreeBond 1107D

Liquid Gasket

Three Bond 1107D is based on special synthetic resins and metallic colloid. It is a non-drying type. It is thermally and chemically stable within a wide range of temperature.

Features

- 1) Highly resistance to heat (400°C).
- 2) Grey permanent non-drying fluid gasket.

Applications

Suitable for use at high temperature.

Anti-corrosive treatment and fusing muffler to automobile and internal combustion engine.

Characteristics

Main Components	Synthetic Oil & Metallic Colloid
Diluent	Chlorinated Hydrocarbon
Appearance	Grey, Paste Form
Non-volatile matter	57%
Viscosity (at 25°C)	25 Pa·s
Specific Gravity (at 25°C)	1.80

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Chemical Test

Tests were made in accordance to specifications of JIS-K-6820. A glass panel with a recess filled with a coat of fluid sealant was air-dried for 24 hours, then baked at $100^{\circ}\text{C}\pm 5^{\circ}\text{C}$ for 3 hours. After this baking period, the panel was placed in a desiccator and allowed to cool to room temperature. Thereafter, the test piece was weighed and applied to the following tests.

- (1) Water Resistance Test.
The test piece was immersed in $90-95^{\circ}\text{C}$ water using distillation device with a recycle tower attached. It was then washed with methyl alcohol and dried at $65\pm 5^{\circ}\text{C}$ for 24 hours, and thereafter cooled to room temperature. The test piece was checked for change in weight.
- (2) Oil Resistance Test
The test piece was immersed in $95-100^{\circ}\text{C}$ rubber lubricants No.2 for 24 hours and subjected to the same testing procedures and described in Section (1) above.

Test Results:

	Change in weight (%)
Water Resistance	+ 1.2
Oil Resistance	+ 2.1

Physical Test

- (1) Pressure Resistance
The test was made in accordance with the following parameter:
Flange used: 90 mm outside diameter, 60 mm inside diameter, and 15 mm width.
Clamping bolts: W1/2 inch 6
Clamping force: 280 kg/cm surface pressure 160 kg/cm²
Surface finish: Turbine oil No.1 (JIS-K-2213)
Compression speed: 5 kg/cm²/min.
Temperature: Room temperature
- (2) Working pressure after a cool-heat cycle
The same apparatus is used in Pressure Resistance Test. The sample was applied onto the joint surfaces, which were tightened using the same torque as in Pressure Resistance Test. The flanges were subjected to cooling to $-45 \pm 5^{\circ}\text{C}$ for 2 hours and baked at $100 \pm 5^{\circ}\text{C}$ for 3 hours. Thereafter they were cooled down to room temperature.

Test Results:

Temperature ($^{\circ}\text{C}$)	Pressure (kg/cm ²)
Room temperature	95
Working pressure after cool-heat cycle	65

- (3) Corrosiveness
Coated the sample over the entire polished surface of copper plate, about 25 mm square and 3 mm thick in the thickness of about 3 mm, then the sample was subjected to room temperature for 24 hours. Removed the sample with suitable solvent and examined the surface of the plate for occurrence of pitching or etching.

Test Results: Corrosiveness: Nil

Handling Precautions

1. Do not inhale or ingest. In the event that this product is ingested, immediately consult physician.
2. Product may settle upon storage, stir well until uniform before using.
3. After use, close the lid tightly, then store. Do not return unused portion, if transferred, to original container.
4. Before use, clean the bonding area to remove grease or dust.
5. Apply with brush, oiler or Three Bond Flow Gun.
6. Tighten joints 2-4 minutes after application.
7. Keep away from children.
8. For industrial use only.

Shelf Life

12 months when stored at 5 ~ 35°C, unopened.

Packaging

Available in packing size of 1 kg (can).

Disclaimer

For Industrial Use Only

(Do not use for household purposes)

- The data contained in this report are obtained from experimental results, based on our test methods. We cannot assume absolute responsibility for accuracy and safety. Before using this product, use your own judgement to determine whether or not this product meets the requirements of the application and objectives. This includes the burden of responsibility and hazardous danger. The extent of the guarantee provides replacement for products, which are clearly unsatisfactory.
- We assume responsibility for neither injury nor property damages resulting from the misuse of this product.
- We do not assume responsibility without written notice or contract.