



Technical Data Sheet

3M™ Scotch-Weld™ Pipe Sealant Anaerobic Adhesive PS67

Product Description

3M™ Scotch-Weld™ Pipe Sealant Anaerobic Adhesives are one-component anaerobic sealants that cure and seal hydraulic and pneumatic pipes and fittings to withstand high temperatures and pressures

Product Features

3M™ Scotch-Weld™ Stainless Steel High Temperature Pipe Sealant PS67 is a fast cure, low breakaway torque strength, high temperature paste pipe sealant for metal connections in applications such as pressure vessels, air compressors, hydraulic, and pneumatic systems. It works on inactive surfaces (such as stainless steel) and provides an almost instant low pressure seal. A high pressure seal results when the bond is fully cured.

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Uncured Physical Properties

Property	Values	Additional Information
Color	Off-White	View

Notes: Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

Chemistry	Dimethacrylate	
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Viscosity	150,000-400,000 cP	View
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Notes: Brookfield Viscometer spindle T-E at 2.5 rpm

Fixture Time	25min (avg time) (<15-30 min range)	View
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Notes: Reference ISO 10964. To convert to (N.m) divide (in.lb) by 8.851.

Typical Physical Properties

Property	Values	Additional Information
Color	White	View

Test Name: Cured

Appearance	Paste	
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Typical Mixed Physical Properties

Property	Values	Additional Information
Time to Full Cure	24 hr	View
Temp C: 23C Temp F: 73F		
Cure Speed		

Typical Cured Characteristics

Property	Values	Additional Information
Temperature Range	-54 - 204 °C	
Max Pipe Diameter	3 in	

Typical Performance Characteristics

Property	Values	Additional Information
Long Term Temperature Resistance	204 °C	
Minimum Long Term Temperature Resistance	-54 °C	
Long Term Temperature Resistance	400 °F	
Minimum Long Term Temperature Resistance	-65 °F	
Breakaway Torque	40in-lb - typical value (20 - 45in-lb range)	View

Notes: Reference ISO 10964. To convert to (N.m) divide (in.lb) by 8.851.

Prevailing Torque	30in-lb - typical value (12 - 40in-lb range)	View
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Notes: Reference ISO 10964. To convert to (N.m) divide (in.lb) by 8.851.

Hot Strength % Retention		
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Storage and Shelf Life

Store product in cool, dry area out of direct sunlight

3MTM Scotch-Weld™ Threadlocker Anaerobic Adhesives have a shelf life of 18 months when stored at 60° to 80°F (16° to 27°C) in the original unopened container.

Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M's Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer's use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

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Bottom Matter

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Trademarks

3M and Scotch-Weld are trademarks of 3M Company.

Handling/Application Information

Directions for Use

3MTM Scotch-Weld™ Pipe Sealant Anaerobic Adhesives are not recommended for use on most plastics due to potential cracking of plastic parts. Also, they are not recommended for use in piping systems that contain pure oxygen or an oxygen-rich environment, chlorine, or strong oxidizing substances.

For Assembly:

1. Ensure parts are clean, dry and free from oil, grease and dirt. For best results, clean and dry parts with solvent or 3MTM Scotch-Weld™ Activator. (Activator can also be used on inactive surfaces or to accelerate the cure on active surfaces.) Note: Use of 3MTM Scotch-Weld™ Activator may reduce bond strength depending on substrates and gap. Testing is recommended to evaluate the effect.
2. If not sure of surface type, always use activator. Refer to Material surface Activity and Cure Speed section for more information.
3. Apply sealant onto the second and third threads (not the first thread) of the male fitting so as to avoid introducing uncured sealant into the system. (However, should uncured sealant get into the piping system, it will not cure or cause blockage and can be slushed out.) Avoid touching the metal surfaces with the bottle tip since the metal ions may react with the adhesive upon contact and eventually may clog the bottle tip.
4. Spread adhesive evenly around the male fitting.

For Assembly:

5. Assemble parts and tighten as required.

6. Allow assemblies to set for sufficient time so that handling strength or full cure will occur before further processing or testing.

For Disassembly:

1. Loosen or remove with regular hand tools.

2. If hand tools do not work due to the assembled parts being well tightened, apply localized heat (approximately 490oF / 254oC) to the nut or bolt and disassemble while parts are still hot. Use extreme caution when working with heat sources (e.g. heat gun, flames, etc.)

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40069330/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=PS67

Family Group

Link Tags:

- PS65
- PS67
- PS77

Products	Color	Time to Full Cure	Minimum Long Term Temperature Resistance	Long Term Temperature Resistance
PS77	Fluorescent Yellow	24 hr	-54 °C	300 °F
PS67	N/A	24 hr	-54 °C	204 °C
PS65	White	24 hr	N/A	400 °F

ISO Statement

This product was manufactured under a quality system registered to ISO 9001 standards.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Information

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