

3M

Scotch-Seal™

Duct Sealer

900

Technical Data

May, 2004

Description 3M™ Scotch-Seal™ Duct Sealer 900 is a knife or caulking grade sealant that cures to form a firm, rubbery seal. It is ideal for sealing medium and high pressure heating and air conditioning ducts.

- Features**
- Smooth, easy caulking characteristics.
 - Fast drying.
 - Gap-filling properties.
 - Dries to a firm rubbery seal.
 - Excellent adhesion to aluminum, cold rolled steel, painted and galvanized steel, plus many other surfaces.
 - Can be used for indoor and outdoor applications.

Typical Physical Properties

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

Base	Synthetic Rubber Oil Soluble Elastomer
Color	Gray
Solvent	Isohexanes
Net Weight	8.8 - 9.2 lbs. per gal.
Flash Point (Seta)	1.0°F (-17°C)
Solids Content	64-68% (by weight)
Consistency	Medium Paste
Viscosity	(Approx.) 200,000-300,000 cps.
Viscometer	Brookfield RVF, No. 7 sp. @ 10 rpm @ 80°F

Scotch-Seal™ Duct Sealer 900

Handling/Application Information

Surface Preparation: For optimum adhesion, surfaces to be sealed must be clean, dry and free from oil, grease or other foreign material.

Application: 3M™ Scotch-Seal™ Duct Sealer 900 can be applied by hand or pressure caulking equipment, trowel, or spatula. Sealed surfaces should be mated as soon after application of the sealer as possible, preferably before the sealant has “skinned” over. If the sealant develops a “surface skin” prior to joining the sealed surfaces, care must be taken when mating the surfaces to ensure that the sealant surface is broken or ruptured in order to form a good, serviceable seal.

Packaging: Scotch-Seal 900 is packaged in 1/10 gallon fiber cartridges.

Coverage: A 1/10 gallon cartridge in practice will provide approximately 135 lineal feet of 1/8 in. diameter wet bead.

Cleanup: Equipment and tools can be cleaned with 3M™ Citrus Base Industrial Cleaner, 3M™ Scotch-Grip™ Solvent No. 2 or aliphatic type solvents.* This can best be accomplished by cleaning before the sealant has dried.

***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer’s precautions and directions for use.

Typical Performance Characteristics

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

Adhesion: Exhibits good adhesion to aluminum, cold rolled steel, and painted and galvanized steel.

Drying: At 75°F (24°C), 40 mil wet films of Scotch-Seal 900 skin over or are tack free to the touch in approximately 15 minutes. The time required for thorough drying will vary with environmental conditions and sealant thickness. At 75°F (24°C), 40 mil wet films require about 48 hours to set to a firm rubber.

Caulk Rate: Scotch-Seal 900 has a caulk rate of 250 grams/min. Through a 1/8 inch orifice with 50 psi pressure at 75°F (24°C). At 40°F (4°C) the caulk rate is less than 100 grams/min.

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Reference Information

Material Temperature: 40°F (4°C) – Flow Gun with 1/4 in. orifice.

Hose Assembly	Material Pressure	Output Lb./Min.	Material Pressure	Output Lb./Min.
10 ft. length 3/4 I.D. hose	1150 psi	2.5	–	–
20 ft. length 3/4 I.D. hose	1150 psi	2.1	2300 psi	2.9
20 ft. length 3/4 I.D. hose plus 10 ft. length 1/2 I.D. hose	1150 psi	0.80	2300 psi	2.5
20 ft. length 1/2 I.D. hose	1150 psi	0.5	2300 psi	1.8
10 ft. length 1/2 I.D. hose	1150 psi	1.3	2300 psi	2.8

Note: Material Pressure – Operating air pressure x pump ratio.

Storage

Store product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.

Shelf Life

When stored at recommended temperatures in original unopened container, this product has a shelf life of 15 months from the date 3M ships the product to a customer or distributor.

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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.

Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

Warranty and Limited Remedy

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Limitation of Liability

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