



ANTI-SEIZE TECHNOLOGY
A.S.T. Industries, Inc.

POLY-TEMP® PTFE Tapes

How to Apply PTFE Tape on Pipe Threads

PTFE tape is considered an effective sealant for tapered pipe joints in most applications. It is also a very safe sealant because it is resistant to most chemicals and temperatures and suitable for oxygen service. POLY-TEMP® tapes are effective as a thread sealant at: -400° to +500°F (-240° to +260°C). The full density (xhd) tapes to +550°f (288°C).

The following procedures should be utilized when applying tape to threads:

- 1) Lay the end of the PTFE tape on threads two threads back from the end of the fitting to begin your wrap.
- 2) Wrap the tape in the direction of the thread spiral (going away from the lead thread) to ensure that the tape does not unwrap during assembly.
- 3) During the wrapping, pull and stretch the tape enough so it pulls down into the threads. Press on and hold tape and pull to break.
- 4) Under no circumstances should the tape extend beyond the first thread.
- 5) Joints should be snug but does not require complete tightness as with a non-PTFE pipe dope. Over tightening can result in the destruction of the integrity of the thread design. When using PTFE tape there is a rule of thumb: reduce assembly torque approximately 45%.
- 6) The tape width and number of wraps can vary because of several factors: size of threads, condition of the threads, thickness of tape, and density of tape, to name a few. When using a medium density grade tape the general rule for wraps is:
 - 1 to 2 wraps of 1/4" wide tape on 1/4" To 3/8" npt,
 - 2 to 3 wraps of 1/2" wide tape on 1/2" to 3/4" npt,
 - 3 to 4 wraps of 1/2" wide tape on 1" to 1-1/4" npt,
 - 3 to 4 wraps of 3/4" wide tape on 1-1/2" npt & larger
- 7) When a fitting, sealed with PTFE tape, is removed, thoroughly clean old PTFE from the fitting (male & female threads) before reinstalling.



It always necessary for the user to test each proposed application prior to incorporating the product into use and we recommend and assume that the user will conduct such testing. Anti-Seize Technology can neither guarantee nor assume responsibility for the results obtained by others.

Anti-Seize Technology has all the varieties of PTFE tapes available, from low density to full density (XHD): POLY-TEMP® standard, HD, XHD which include Yellow Gas Line Tape, Stainless Steel Grade, Pink Plumbers, and three Anti-Seize Tapes, POLY-TEMP® Copper, Nickel, and Food Grade Ceramic and economical Low Density.

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