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THERMINOL® 77 HIGH-TEMPERATURE HEAT TRANSFER FLUID

TECHNICAL BULLETIN T-77

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FUNCTIONAL FLUIDS Monsanto®

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Therminol 77 is a *liquid-phase* heat transfer fluid particularly suitable for continuous use for temperatures up to 700°F. It has been used for several years in commercial scale and pilot plant systems in a diversity of applications; e.g., paint and resin manufacture, high-temperature plastic extrusion, lamination of plastics, chemical processing, laboratory baths, and thermostatic devices.

Unlike Monsanto's Therminol FR line of fire-resistant heat transfer fluids (chlorinated hydrocarbons), Therminol 77 does not contain halogen and is not fire resistant. The recommended design considerations described in the Therminol FR Engineering Manual, such as flow rate, $\triangle T$, heat-flux density, etc., are also applicable to Therminol 77.

Although Therminol 77 does thermally degrade at temperatures above 700°F, it has been used in commercial heat transfer systems up to its atmospheric boiling point of 830°F. Degradation rate is very low at 700°F and increases progressively at increasing temperatures. Therminol 77 degradation products are predominantly polymers which are completely soluble in the bulk fluid and, therefore, do not form insulating deposits in the system. Degraded fluid is, however, more viscous than fresh fluid but can be reclaimed economically to essentially new-fluid condition.

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THERMINOL® 77 FLUID PROPERTIES

Temp °F	Vapor Pressure (mm Hg)	Viscosity (cs)	Viscosity (Lbs Ft-Hr)	Density (GMS cc)	Density (Lbs Gal)
100	-	181	505	1.152	9.60
210	-	7.78	20.8	1.106	9.26
300	0.27	2.65	-	1.070	8.94
400	1.03	1.50	3.74	1.029	8.58
500	9.2	0.96	2.28	0.981	8.16
600	44	0.66	1.49	0.931	7.76
700	168	0.46*	0.99	0.885	7.38
800	530	-	-	-	-

*Extrapolation

THERMAL CONDUCTIVITY

Temp °F	Specific Heat (BTU Lb)	(Cal cm, °C, sec)	(BTU °F, Ft-Hr)	Thermal Expansion, (cc °F)
100	0.350	32.25×10^{-4}	0.0781	0.00034
200	0.375	31.40×10^{-4}	0.0760	-
300	0.420	30.50×10^{-4}	0.0739	0.00037
400	0.455	29.65×10^{-4}	0.0719	-
500	0.495	28.80×10^{-4}	0.0698	0.00049
600	0.530	-	-	-
700	0.565	-	-	0.00062
800	0.600	-	-	-

Pour Point	+45°F	Fire Point	540°F
Flash Point	460°F	A. I. T.	1115°F
		Thermal Decomposition**	800°F

**Thermal decomposition was determined by the isoteniscope method as described in the "Journal of Chemical and Engineering Data," January 1961, Vol. 6, No. 1. It is defined as the temperature at which decomposition rate is 0.014 mm Hg per second, or 500 mm Hg per 10 hours.

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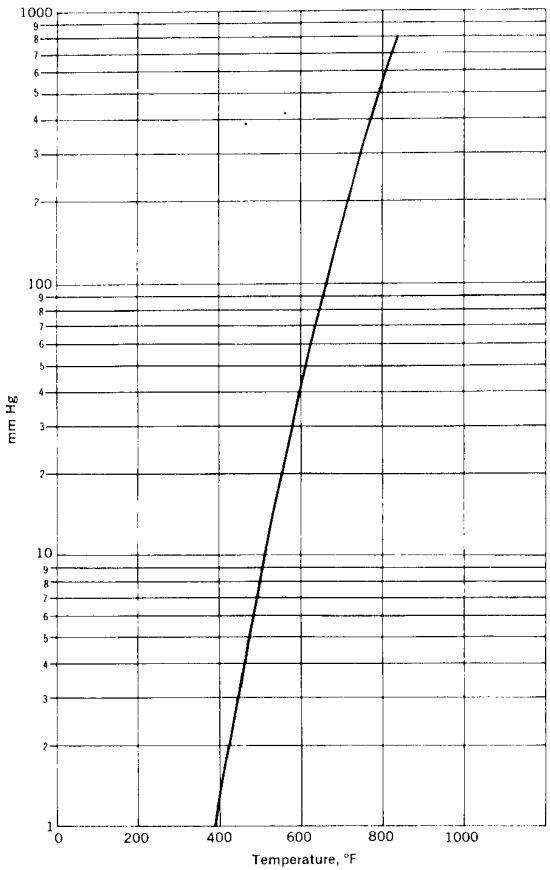
VAPOR PRESSURE



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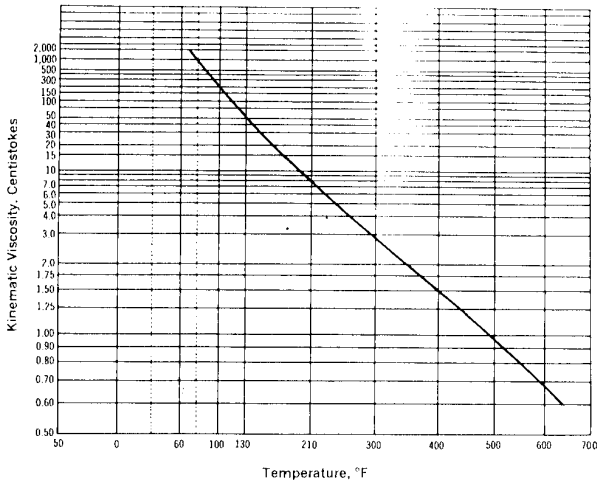
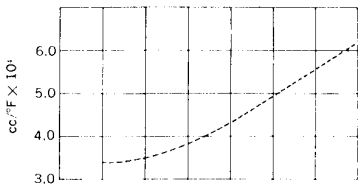
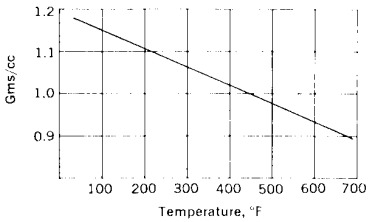
KINEMATIC VISCOSITIES



COEFFICIENT OF THERMAL EXPANSION



DENSITY



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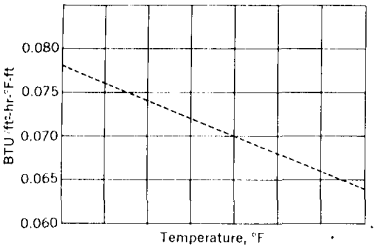
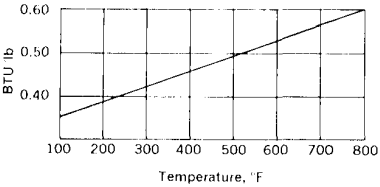
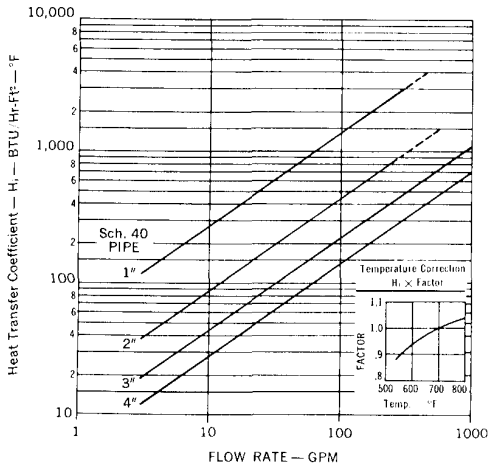
THERMAL CONDUCTIVITY



SPECIFIC HEAT



Inside Film Heat Transfer Coefficient versus Flow Rate at 700°F



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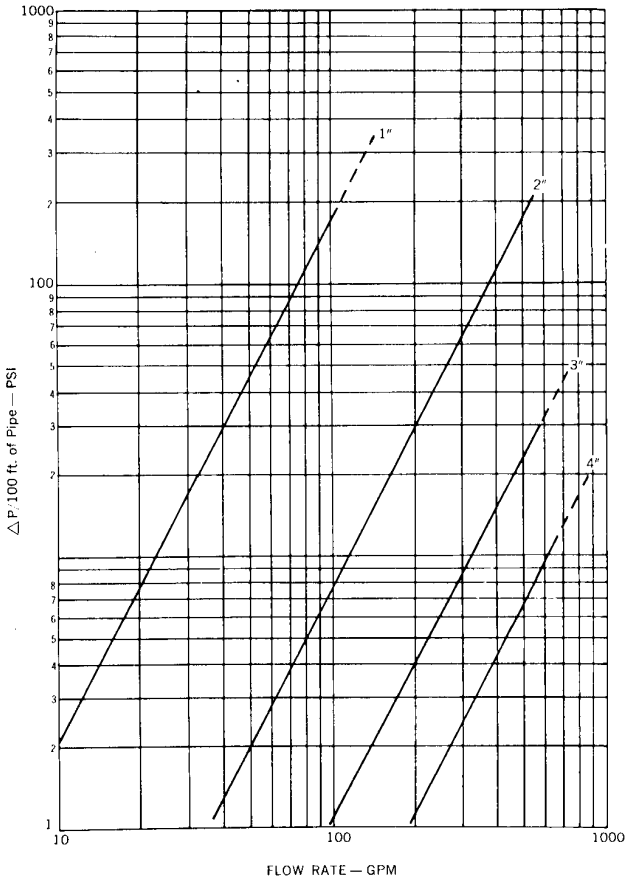
Pressure Drop Per 100 Ft. of Pipe

versus

Flow Rate at 700°F



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