



BOSS[®] 220 Gasketing Compound

TYPICAL PROPERTIES

Monomer (Liquid)

Base Compound Dimethacrylate Ester
Appearance Red Paste
Viscosity (cP @ 68°F) 110,000 cP
Specific Gravity (g/cc) 1.12
Gap Fill016"
Flash Point (TCC) >200°F
Shelf Life @ 40°F 1 Year Unopened

Polymer (Cured)

Appearance Red Solid
Hardness 47(JIS D)
Elongation 100%
Service Temperature Range -58°F - 302°F
Full Cure Time 24 Hours
Tensile Strength 18.6 Mpa (190Kgf/cm2)
Shear Strength 6.1 Mpa (62Kgf/cm2)

*Information on this data sheet is subject to change without notice and should not be used for writing specifications.
For additional information on specific applications, contact Accumetric, LLC



PERFORMANCE OF CURED MATERIALS PRESSURE RESISTANCE

Specification JIS-K-6820
Bolt Type M10 Number Samples 8
Fastening Force 150Kgf-cm
Blow Out Test 5 Minutes Post Assembly
Heat Cycle -30°C x 1 Hr. → 25°C x 30 min. → 130°C x 1 Hr. (Cycle Repeated 100 Times)
Pressure Conditions 0.98 Mpa/min.
Blow out, 6.0 Kgf/cm2 Flange JIS-K-6820-Fe/Al
Blow out after heat cycle, 6.0 Kgf/cm2	... Flange JIS-K-6820-Fe/Al

DESCRIPTION

BOSS[®] 220 Gasketing Compound is a single component, thixotropic anaerobic sealant which develops medium strength. The product cures between close fitting metal parts where there is an absence of air.

CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

FEATURES

- Seals close fitting joints between rigid metal assemblies such as differential cases, transmissions and oil pans
- Offers superior chemical and heat resistance while maintaining flexibility for proper gasketing

SETTING TIME (68°F, 65% RH)

Substrate Set Time / Full Cure
Steel 30-60 minutes / 24 hours
Aluminum 30-60 minutes / 24 hours

HOW TO USE

Surfaces to be bonded should be clean, dry and free of grease.

Product should be applied in enough quantity to fill all engaged threads. The product performs best in thin bond gaps. Very large gaps may create gaps which will affect the cure speed and overall strength. Good contact is essential. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

CHEMICAL RESISTANCE

Shear strength on steel after 500 hours

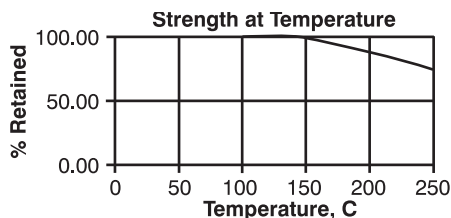
Solvent	% Strength Retained
Motor Oil	100
Unleaded Gasoline	95
Brake Fluid	100
Ethanol	100
Acetone	95
Water/Glycol Mix	80

OIL RESISTANCE

Lap Shear(Kgf/cm2)	Conditions
ATF	96.4 120°C x 240h D-III
Engine Oil ...	119.1 150°C x 240 h 5W-30SH
Gear Oil	75.7 120°C x 240h 75W-90

TEMPERATURE RESISTANCE

% Retained strength when tested at temperature



PACKAGING

BOSS® 220 is available in 50ml tubes.

SHIPPING LIMITATIONS

None.
Reactive VOC 143 g/l

STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), **BOSS® 220** Gasketing Compound has a shelf life of 12 months from date of shipment. In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity.

Products can be refrigerated for improved shelf life but should be brought back to room temperature before use.

CAUTION

DIRECT CONTACT OF UNCURED PRODUCT IRRITATES EYES AND MAY IRRITATE SKIN. OVEREXPOSURE TO VAPOR MAY IRRITATE EYES, NOSE, AND THROAT. Avoid eye and skin contact. Use with adequate ventilation. Do not handle contact lenses with sealant on hands. IN CASE OF EYE CONTACT, flush eyes with water for 15 minutes. Obtain medical attention. IN CASE OF SKIN CONTACT, remove from skin and flush with water. KEEP OUT OF THE REACH OF CHILDREN. For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

The supplier warrants only that its products will meet its specifications. There is no warranty of merchantability or fitness for use, nor any other express or implied warranty. The users exclusive remedy and the suppliers sole liability is limited to refund of the purchase price or replacement of any product shown to be otherwise than as warranted. The supplier will not be liable for incidental or consequential damages of any kind.

Suggestions of uses should not be taken as inducements to infringe any patents.

MADE IN U.S.A.

BOSS® PRODUCTS

Accumetric, LLC
350 Ring Road
 Elizabethtown,
 Kentucky 42701 USA
 800-928-BOSS(2677)
 TEL (270)769-3385
 FAX (270)765-2412
 Outside U.S.
 TEL +1(270)769-3385
 FAX +1(270)765-2412

Accumetric Asia Pacific, LTD
18 Kitpanit Bldg, 5th Floor
#502 Patpong Road
Suriyawong, Bangrak
Bangkok, 10500 Thailand
TEL (662)634-3060
FAX (662)634-3066

www.bossproducts.com