

### RED ANAEROBIC GASKET MAKER PART NO. 49477

#### PHYSICAL PROPERTIES

##### Monomer (Liquid)

Base Compound .....	Dimethacrylate Ester
Appearance.....	Red Paste
Viscosity (cP @ 68°F).....	110,000 cP
Specific Gravity (g/cc).....	1.12
Gap Fill .....	.016"
Flash Point (TCC) .....	>200°F
Shelf Life @ 40°F.....	1 year unopened
Military Specifications .....	None

##### Polymer (Cured)

Appearance.....	Red Solid
Hardness .....	47 (JIS D)
Elongation .....	100%
Service Temperature Range .....	-58°F to 302°F
Full Cure Time.....	24 Hours
Tensile Strength.....	18.6 Mpa (190Kgf/cm <sup>2</sup> )
Shear Strength.....	6.1 Mpa (62Kgf/cm <sup>2</sup> ) (A2024P 25°Cx725h)



#### DESCRIPTION

**Dynatex® Anaerobic Gasket Maker** is a single component, medium strength thixotropic anaerobic sealant, which develops medium strength. The product cures between close fitting metal parts where there is an absence of air. It provides a tough, resilient, solvent and temperature resistant seal that flexes with flange movement caused by vibration, pressurization or thermal changes.

#### FEATURES

- No mixing
- No curing outside of joint
- Non-corrosive to aluminum or cast iron parts
- Eliminates need to re-torque compressible mechanical gaskets

#### TYPICAL APPLICATIONS

- Vacuum pump flanges
- Fuel pumps
- Water pumps
- Gearbox covers
- Automotive and truck axle covers
- Split crankcases
- Thermostats

#### CURING PROPERTIES

The rate of cure will depend on environmental conditions and the substrates used. **Dynatex® Anaerobic Gasket Maker** will offer an instant seal while still uncured when subjected to a low on-line pressure test.

#### 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.

## PERFORMANCE OF CURED MATERIALS

### PRESSURE RESISTANCE

Specification: JIS-K-6820

Bolt Type: M10 Number Samples: 8

Fastening Force: 150 Kgf-cm

Blow Out Test: 5 Minutes after Assembly

Heat Cycle: -30°C x 1Hr. → 25°C x 30 min.

→ 130°C x 1Hr. Cycle repeated 100 times.

Pressure Conditions: 0.98 Mpa/min.

### SETTING TIME (68°F, 65% R.H.)

Substrate	Set time/Full cure
Steel	30-60 min/24 hrs
Aluminum	30-60 min/24 hrs

### Lap Shear at Varying Time and Temperature

	15 Min.	30 Min.	1 Hr	3 Hrs	8 Hrs
5°C	13.6	24.5	31.5	43.8	49.7
25°C	32.0	36.2	53.5	58.2	60.4

### 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/ cm <sup>2</sup> )	Conditions
ATF	96.4	120°C x 240h D-III
Engine Oil	119.1	150°C x 240h 5W-30SH
Gear Oil	75.7	120°C x 240h 75W-90

### GENERAL INSTRUCTIONS

Surfaces to be bonded should be clean and 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.

### STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), **Dynatex® Anaerobic Gasket Maker** 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. Cartons should always be stacked upright. DO NOT stack cartons on their side. **NEVER** stack cartons more than 8 high. DO NOT store within 1 meter (4 feet) of roofline of the warehouse or storage building.

### USERS PLEASE READ

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

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