

## BOSS<sup>®</sup> 323 Hi-Temp Blue Gasket Maker

### TYPICAL PROPERTIES

#### *As supplied*

Color..... Blue  
Flow/Slump .....NIL  
Extrusion Rate (1/8" orifice, 90 psi)..... 335 g/min.

#### *Cure Characteristics – exposed to air, 77°F (25°C) and 50% RH*

Skin-over time ..... 6 min.  
Tack-free time..... 15 min.  
Cure time (1/8" thickness)..... 24 hrs.

#### *As Cured –after 72 hours at 77°F (25°C) and 50% RH*

Durometer, shore A..... 32 points  
Tensile strength .....350 psi  
Elongation .....500%  
Unprimed adhesion (most substrates\*)..... good  
Special Properties ..... performs at temperatures  
ranging from -85°F to 400°F (-65°C to 204°C)  
Service Temperature.....-85°F to 400°F  
Application Temperature .....-35°F to 140°F

\*Optimum adhesion is obtained in 7 to 10 days curing time.

Use A-120 prime coat if increased adhesion is required.

\*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



### USES

- Valve covers
- Transmission pans
- Oil pump flanges
- Intermittent use to 550°F
- Insulates thermally
- Insulates electrically
- Waterproof seal
- Weatherproof seal
- Forms an even bead
- Oxygen sensor safe
- Other critical bonding, sealing, potting, encapsulating and protective coating where parts must perform at high temps

### DESCRIPTION

**BOSS<sup>®</sup> 323** Hi-Temp Blue Gasket Maker is a one-part, non-slumping paste that cures to a tough, rubbery solid at room temperature on exposure to vapor in the air. This silicone was formulated to perform at temperatures ranging from -85°F to 400°F (-65°C to 204°C). **BOSS<sup>®</sup> 323** is non-corrosive and oxygen-sensor safe.

## SPECIFICATIONS

**BOSS® 323** Hi-Temp Blue Gasket Maker meets requirements of the following specifications:

- TT-S-001543A (silicone building sealant)
- TT-S-00230C (one component building sealant)
- ASTM C-920

## HOW TO USE

### Applying the Material: Tack-Free Time

**BOSS® 323** Hi-Temp Blue Gasket Maker is supplied ready-to-use. Under pressure it flows readily from its container. The paste-like consistency makes it easy to work; a spatula or wooden paddle can be used for tooling the surface. The cure progresses inward from the surface. At conditions of at least 77°F (25°C) and 50% relative humidity, the sealant forms a tack-free skin within 20 minutes. Tooling is not practical after this skin begins forming and should be completed within 5 to 10 minutes of application, even though this may require alternate periods of applying and tooling. Likewise, if masking tape has been used to mark off the area, it should be removed before the tack-free skin forms.

### Cure Time

Cure time is affected by relative humidity, degree of confinement and cross-sectional thickness of the sealant. Sections up to 1/8" thick become rubbery solids in about 24 hours at room temperature and 50 percent relative humidity. Less moisture content reduces it slightly.

In applications where **BOSS® 323** may be partly or totally confined during cure, the time required for proper cure is generally lengthened by the degree of confinement. Metal-to-metal bonds should not overlap more than one inch. Every application involving confinement during cure should be thoroughly tested before commercialization.

The odor given off during cure is due to the liberation of acetic acid. This odor disappears as the cure progresses, and is not detectable after the cure is complete.

### Bonding

1. Thoroughly clean and degrease metal and plastic surfaces, then rinse all surfaces, except plastic, with acetone. Rubber surfaces should be roughened with sandpaper, then wiped with acetone. Follow the precautions given on solvent container label.
2. For stronger, more uniform bonds, apply a thin film of A-120 prime coat to all surfaces except rubber and silicone rubber. Allow to air-dry for 30 to 45 minutes at room temperature. (Full instructions are provided with the prime coat.)

**CAUTION:** A-120 prime coat is flammable and has no **BOSS®** FDA status. Keep away from heat and open flames. Use only with adequate ventilation.

### Sealing

Using **BOSS® 323** Hi-Temp Blue Gasket Maker in sealing applications follows approximately the same step-by-step procedures outlined for bonding applications. After preparing the surface and priming where required, the sealant is applied by forcing it in the joint or seam to obtain full contact between sealant and surfaces.

## CLEAN UP

Uncured sealant can be easily removed using a solvent such as alcohol or acetone. For an environmental and health friendlier choice use **BOSS®** Biggie Wipes. If the sealant is cured it must be removed mechanically by cutting and scraping.

## PACKAGING

**BOSS® 323** Hi-Temp Blue Gasket Maker is available in standard caulking cartridges, 3 Oz. tubes and 4.5 gallon pails. Other sizes available upon request.

## SHIPPING LIMITATIONS

None.

Reactive VOC 29 g/l (<3% wt)

## STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), **BOSS® 323** Hi-Temp Blue 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 with the nozzle tip pointed upwards. 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.

## CAUTION

DIRECT CONTACT OF UNCURED SEALANT 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. Sealant releases acetic acid (vinegar-like odor) during cure. **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.

**Non-warranty:** Because the storage, handling and application of the material is beyond Accumetric's control, we can accept no liability for the results obtained. Accumetric's sole limited warranty is the product meets the manufacturing specifications in effect at time of shipment. There is no warranty of merchantability or fitness for use, nor any other express or implied warranty. Accumetric will not be liable for incidental or consequential damages of any kind. The exclusive remedy for breach of such limited warranty is a refund of purchase price or replacement of any product shown to be other than as warranted.

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](http://www.bossproducts.com)