

# LOCTITE® High Flex Gasket Maker

October 2019

## PRODUCT DESCRIPTION

LOCTITE® High Flex Gasket Maker provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Methacrylate ester
<b>Appearance (uncured)</b>	Blue paste <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Cure</b>	Anaerobic
<b>Application</b>	Sealing
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>Improves reliability</li> <li>Cost effective</li> <li>Easy application</li> </ul>

LOCTITE® High Flex Gasket Maker improves flange-sealing reliability by overcoming the shortcomings of pre-cut and other formed-in-place chemical gaskets. After curing between mating metal flanges and filling surface imperfections, it provides a tough, resilient, solvent and temperature resistant seal that flexes with flange movements caused by vibration, pressurization or thermal changes.

Typical applications include making gaskets for pumps, housings, axle covers, gear cases, split crankcases and other areas where conventional gaskets are used. LOCTITE® High Flex Gasket Maker can also be used to repair damaged conventional gaskets or as a coating/dressing for conventional gaskets.

## Product Benefits

- Improved Reliability**
  - Seals all surface gasket imperfections
  - Eliminates gasket compression set and bolt loosening
  - Seals most common industrial fluids
  - No cracking or shrinking during cure
- Cost Savings**
  - Reduces cut gasket inventory
  - Reduces machining operations
  - Eliminates costly re-torquing operations
  - No waste from cure in open containers
- Easy Application**
  - No migration, can be applied to vertical surfaces
  - No mixing required
  - No curing outside joint or in open containers
  - Can be applied via screen printing, roll coating and manual or robotic tracing

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.1

Flash Point - See SDS

Viscosity, Brookfield - HBT, 22°C, mPa·s (cP):

Spindle TC, speed 0.5 rpm, Helipath 225,000 to 575,000<sup>LMS</sup>

Spindle TC, speed 5 rpm, Helipath 65,000 to 175,000<sup>LMS</sup>

## TYPICAL CURING PERFORMANCE

### Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Fixture Time, ISO 4587, minutes:

Passivated aluminum:

0 gap	15 to 20
0.05 mm gap, 1 side activated with Activator 7649™	1 to 2
0.25 mm gap, 1 side activated with Activator 7649™	60 to

Passivated steel:

0 gap	>120
0.05 mm gap, 1 side activated with Activator 7649™	5 to 10
0.25 mm gap, 1 side activated with Activator 7649™	90 to 120

## TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 24 hours @ 200 °C

### Physical Properties:

Elongation, at break, ISO 527-3, %	64
Tensile Strength, ISO 527-3	N/mm² 1.7 (psi) (240)

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

Cured for 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel:

0 gap	N/mm² ≥2 <sup>LMS</sup> (psi) (≥290)
0.25 mm gap	N/mm² 2.1 (psi) (300)

Aluminum:

0.25 mm gap	N/mm² 1.2 (psi) (175)
-------------	--------------------------

Passivated steel:

0.05 mm gap, 1 side activated with Activator 7649™	N/mm² 0.7 (psi) (100)
--	--------------------------

0.25 mm gap, 1 side activated with Activator 7649™	N/mm <sup>2</sup> 1.8 (psi) (260)
--	--------------------------------------

## Passivated aluminum:

0.05 mm gap, 1 side activated with Activator 7649™	N/mm <sup>2</sup> 0.9 (psi) (130)
--	--------------------------------------

0.25 mm gap, 1 side activated with Activator 7649™	N/mm <sup>2</sup> 1.4 (psi) (210)
--	--------------------------------------

## Tensile Strength, ISO 6922:

Steel pin to Steel pin	N/mm <sup>2</sup> 0.8 (psi) (110)
------------------------	--------------------------------------

## 180° Peel Strength, ISO 8510-2:

Steel	N/mm 0.85 (lb/in) (4.9)
-------	----------------------------

## Cured for 24 hours @ 93 °C

## Lap Shear Strength, ISO 4587:

## Passivated steel:

0.05 mm gap, 1 side activated with Activator 7649™	N/mm <sup>2</sup> 3.1 (psi) (455)
--	--------------------------------------

0.25 mm gap, 1 side activated with Activator 7649™	N/mm <sup>2</sup> 2.4 (psi) (345)
--	--------------------------------------

## Passivated aluminum:

0.05 mm gap, 1 side activated with Activator 7649™	N/mm <sup>2</sup> 4.2 (psi) (605)
--	--------------------------------------

0.25 mm gap, 1 side activated with Activator 7649™	N/mm <sup>2</sup> 2.2 (psi) (325)
--	--------------------------------------

**GENERAL INFORMATION**

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

**For safe handling information on this product, consult the Safety Data Sheet (SDS).**

**Directions for use:**

1. For best performance part surfaces should be clean and free of grease.
2. The product is designed for close fitting flanged parts.
3. LOCTITE® automatic dispensing equipment is recommended for best results. Application by screen printing, roller coating or bead dispense can also be achieved manually.
4. To obtain best results, each application should be evaluated under the specific conditions anticipated for dispensing, performance and durability of the parts.
5. Low pressures (<0.05 MPa, psi) may be used when testing to confirm a complete seal immediately after assembly and before curing.
6. Flanges should be tightened as soon as possible after assembly to avoid shimming.

**Loctite Material Specification<sup>LMS</sup>**

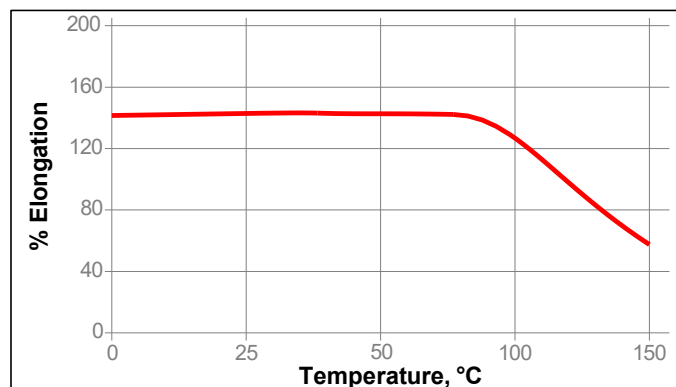
LMS dated June 25, 2007. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

**TYPICAL ENVIRONMENTAL RESISTANCE****Elongation after Heat Aging**

Type 4 Dog bones, UV cured (70,000 microwatts/cm<sup>2</sup>), 20 seconds/side. Conditioned 24 hours at temperature

NOTE: LOCTITE® High Flex Gasket Maker is not a UV-curable product.

The method for determining elongation at break involves adding a photo-initiator to the adhesive and curing with a UV lamp to provide a cured sheet of material. The dog bones used for testing are then cut from the sheet.

**Storage**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.** Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

**Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage:** [Except as otherwise noted] All trademarks in this document are trademarks and/or registered trademarks of Henkel and its affiliates in the U.S. and elsewhere.

Reference 1