

TECHNICAL DATA SHEET – Gasket Maker 15

Gasket Maker 15 is a one component, gel-like anaerobic flange sealant that cures at room temperature and seals close fitting joints between metal faces and flanges. Replaces solid gaskets, provides flexible cured films, seals gas and LP gas, gasoline, oils, water and industrial fluids. Typically used as a liquid gasket for pumps, thermostats, compressor, transmission, housing and axle covers.

Properties of Uncured Product:

Composition Methacrylate Ester
Appearance Dark Purple Fluorescent Gel
Specific Gravity (77°F/25°C g/ml) 1.1
Viscosity, Brookfield (77°F/25°C mPa.s)
Spindle 2 - 5 rpm 200000 to 350000 mPa.s
Flash Point, TCC >93°C
Shelf life at 20°C 1 year
Storage temperature 8° - 28°C

CURING PERFORMANCE

Gasket Maker 15 is designed to be used and cured at room temperature. Where a faster cured speed is desired, or where large gaps are present, applying activator to the surface will reduce the curing to a few minutes.

HEAT CURE: Heat can be used to effect or accelerate cure when surface priming operations are undesirable. Typical heat cure conditions consist of heating and maintaining bondline temperature at 45°C. Full cure strength is achieved in one to two hours.

CURE SPEED VS. SUBSTRATE

%	Full strength	Steel/Aluminum
25	1 hrs	1 hrs
50	3 hrs	3 hrs
100	24 hrs	48 – 72 hrs

CURE SPEED VS. JOINT GAP

%	Full strength	Gap 0,0mm	Gap 0,25mm
25		1 hrs	24 hrs
50		3 hrs	48 – 72 hrs
100		24 hrs	48 – 72 hrs

CURE SPEED VS. TEMPERATURE

%	Full strength	Temperature	
		5°C	40°C
25		2 hrs	15 min
50		4 hrs	30 min
100		24 – 48 hrs	12 hrs

MOREAU MARKETING & SALES
410 LORI LANE
WINSTON-SALEM, NC 27127
336-764-5232 FAX: 336-764-0941
WWW.RMOREAU.COM

PROPERTIES OF CURED PRODUCT:

Functional strength at 24 hrs at 20°C on steel:
Shear strength (ASTM D1002) 3 - 9 N/mm²
Tensile strength (DIN 53288) 7 - 21 N/mm²
Coefficient of thermal expansion (ASTM D696) 80 X 10⁻⁶ 1/K
Thermal conductivity(ASTM C177) 0.1 W/Mk
Specific heat 0.3 Kj.Kg-1 K-1
Temperature range -55° +150°C

ENVIRONMENTAL RESISTANCE

Hot strength at temperature

Test.Temp. °C	% retained strength
20°	100%
50°	75%
100°	50%
150°	25%

HEAT AGING

Samples aged 1000 hours at indicated temperature and tested at room temperature.

Test temp. °C	% retained strength
100°	110%
120°	75%
150°	50%

CHEMICAL / SOLVENT RESISTANCE

Specimens immersed for 1000 days at indicated temperature and tested at room temperature.

	Test Temp. ° C	% retained strength
50/50 Water/Glycol	87	80
Unleaded Gasoline	22	15
Motor Oil	125	165

Gasket Maker products are available in sizes of 50ml and 250ml tubes. Special sizes available upon request.