



ITW Performance Polymers  
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## Technical Data Sheet

# Permatex® Anaerobic Gasket Maker

AAM Revised 05/08

### PRODUCT DESCRIPTION

Permatex® Anaerobic Gasket Maker is a single component, medium strength, thixotropic, anaerobic sealant that cures rapidly. The product cures when confined in the absence of air between close fitting aluminum surfaces. It provides a tough, resilient, solvent and temperature resistant seal that flexes with flange movement caused by vibration, pressurization or thermal changes. OEM specified. NSF White Book registered.



Nonfood Compounds  
Program Listed (P1)  
(134205)

### PRODUCT BENEFITS

- No mixing
- No curing outside of joint
- Non-corrosive to aluminum or cast iron parts

### TYPICAL APPLICATIONS

- For use on machined aluminum metal components
- Pumps
- Thermostats
- Housings
- Axle covers
- Gear cases
- Split crankcases

### DIRECTIONS FOR USE

1. Surfaces to be sealed should be free of grease, oil and dirt. Use Permatex® Brake and Parts Cleaner to remove oil. Use Permatex® Gasket Remover to remove old gaskets.
2. Apply manually to one side of flange, making sure a continuous bead is applied.
3. Assemble parts.
4. Torque to normal specifications.
5. Parts may be returned to service in one hour.

#### For Cleanup

1. Wipe off excess material with a clean cloth.
2. Clean hands with Permatex® Fast Orange® hand cleaner or soap and water.

#### For Disassembly

1. For smaller assembled parts, heat part to 400°F to 450°F.
2. Use cautious, light prying or tapping motion to loosen the parts. Repeat heating/prying sequence as needed.
3. For larger assembled parts use prying/cleaving tools in

combination with a light hammer and cautiously tap and pry the sides of the part to break the gasketed surfaces loose.

4. Once parts are disassembled, allow all surfaces to cool to room temperature.
5. Use Permatex® Gasket Remover to remove dried anaerobic material.

### PHYSICAL PROPERTIES

	Typical Value
Chemical Type	Dimethacrylate Ester
Appearance	Gel
Color	Red
Odor	Acrid
Specific Gravity	1.13
Viscosity cP	750,000/3,750,000 Thixotropic
Gap cure (inch)	0.010 diametral ( Unprimed) 0.050 diametral (Primed)
Cure Speed (Hours)	4 – 24 (Unprimed) 30 Minutes – 4 (Primed)
Flash Point (°F)	>200

### 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 Material Safety Data Sheet, (MSDS).**

### ORDERING INFORMATION

Part Number	Container Size
51813	50 ml. tube
51845	300 ml. cartridge

### STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C and 28°C (46°F and 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

### NOTE

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PLEASE CONTACT ITW PERFORMANCE POLYMERS TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.  
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