



TECHNICAL INFORMATION

974 Gasket maker

DESCRIPTION

974 Orange Gasket Maker is a high viscosity thixotropic gel, which cures rapidly, sealing instantly to 10 bar through its Anaerobic cure system, in contact with Metals in the absence of air (oxygen). When fully cured it resists pressure up to 200 bar and up to 180°C. 974 is a form in place gasket maker with the additional benefit of being WRAS approved.

APPLICATIONS

Typical applications are in sealing all types of flat faced surfaces with close fits against water, oil, gases and most common materials conveyed by systems needing sealing.

USEFUL HINTS/NOTES

Where cure speed is extended due to low temperatures or inactive surfaces, activator can be used. Best results are found if 974 is applied in a continuous bead avoiding blind holes etc. Excess can be wiped away. Any migration into lines will not solidify and can be flushed away during commissioning.

PROPERTIES

Fast Cure to fixture usually <15 minutes @ 20°C
Temperature Range: -50°C to + 180°C
Typical Strength: 6 Nm prevailing on M10 s
Typical Break-loose: 12Nm. up to 18Nm
Recommended Thread sizes: 6mm up to 75mm coarse or fine.
Increase of gap size or fit extends the cure time.

DIRECTIONS FOR USE

- Parts should be clean, dry and dust free.
- Degreased parts will assist results.
- Apply sufficient product to fill joint.
- Assemble parts in traditional manner.
- To achieve handling strength allow product to cure (approximately 1 hour).
- Store in cool conditions.
- Keep out of direct sunlight.

COMPATIBLE ACTIVATORS

Activators such as 7800 Standard Activator. However, up

TECHNICAL FEATURES

Physical Properties (liquid product)

Chemical base: Methacrylate Diester Di-Methacrylate
Colour: Orange / Flourescent
Viscosity: 25°C Brookfield DVII
60000-85000mPas Spindle 6 @ 2.5rpm
25000-35000mPas Spindle 6 @ 20rpm
Density: 1.10 25°C
Max.thread diameter: 3 inches
Max. gap filling: 0.50mm
Flash point: >100°C

Physical Properties (cured product) @23°C

Measured on M10 x 20 bolt – grade 8.8 zinc galvanised – nut 0.8d loose free running

1. Initial strength: 20 – 30 minutes
2. Functional strength: 1 – 3 hours
3. Final strength: 12– 24 hours
4. Break-loose torque: 12-20Nm (M10)
5. Prevailing torque: 6-14 Nm (M10)
6. Shear Strength: 6-13 N/mm2
DIN5445
7. Thermal range: -55°C up to +180°C
Short term exposure up to 200°C

STORAGE

Shelf Life:12 months @ 20°C

PACKAGING

Bottles: 50ml & 65ml & 250ml Bulk up to 20kg

HEALTH & SAFETY IN USE

Please refer to MSDS

IRRITANT: R43 - R36/37/38 - S23 - S24/25 - S37/39 - S51

Contains Methacrylate Esters

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TDS 974-01

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to 30% strength loss can occur when using accelerators.

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