



AST GASKET MAKER™

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Product Description

AST GASKET MAKER™ is an anaerobic gasket product designed to replace pre-cut gaskets, or can be used with pre-cut gaskets to enhance their sealing ability. The anaerobic chemistry allows the product to cure and polymerize in the absence of air and the presence of metal to form a strong leak proof seal and still allows for minor movement of the flange or face of the joint.

AST GASKET MAKER™ works on close fitting flanges and joints with or without using a pre-formed gasket. It can fill imperfections in the surfaces up to 0.01" and provides an instant low pressure seal.

Cleaning and Use

For best results make sure the bond surface areas are clean of all foreign materials and free of grease or other lubricants or cleaning solvents.

The product is intended for close fitting parts and designed to fill gaps up to 0.01". It is not recommended for parts that are highly warped or have dented surfaces.

Apply a continuous bead of **AST Gasket Maker™** onto one surface of the flange or joint.

Tighten the flanges using the recommended torque and torque pattern as soon as possible after assembly.

This product is not recommended for use on plastics, especially thermoplastics such as polyethylene, polypropylene, where stress cracking can occur.

Cure Time

Once assembled **AST Gasket Maker™** will begin to cure and will seal low pressures immediately.

The product will fully cure within 24 hours at 70°F.

Colder temperatures may require a longer time to achieve a fully cured state.

Cure times at 68°F:

25% 30 minutes

50% 1 hour

80% 4 hours

100% 24 hours

Typical Properties

Property	Value
Resin	Modified Urethane Acrylate
Color	Purple
Fixture Speed w/Activator	<10 minutes
Fixture Speed w/out Activator	20 minutes
Viscosity (Thixotropic)	275,000-950,000 cps
Gap fill	0.01"
Shelf Life	12 months at 70°F
Operating Temperatures	-65°F to +300°F
Full Cure Time	24 hrs @ 68°F
Shear Strength	500-2000 psi.

Fluid Resistance,

Engine oil @ 300°F (150°C) 100%

Brake Fluid @ 300°F (150°C) 100%

ATF @ 300°F (150°C) 80%

50/50 water/ethylene glycol 85%

Water @ 212°F (100°C) 80%

Gasoline @ 77°F (25°C) 95%

Diesel Fuel @ 77°F (25°C) 100%

Ethyl Alcohol @ 77°F (25°C) 90%

Primers

A Primer will accelerate the cure speed and is recommended for stainless steel , titanium and other hard metal alloys. A primer is normally not required for steel, copper, brass or other active metals. Primer T is fast acting and Primer N is long lasting so it can be applied up to 7 days prior to assembly.

Cautions

This product is not recommended for use in an oxygen system and not as a sealant for chlorine or other strong oxidizing materials. **Read all information on labels and Safety Data Sheets prior to use.** All products should be tested and evaluated for a particular purpose prior to use.

GHS compliant

This product requires GHS pictograms on labels.

Refer to Label and SDS for GHS information.

ANTI-SEIZE TECHNOLOGY

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Storage

Product should be stored in a cool dry location at a temperature between -10°F to 85°F. Shelf Life is 18 months from Date of Manufacture when stored properly

Product Limited Warranty

This information is based on information we believe to be reliable and accurate, but no guarantee of its accuracy is made for a particular application. We urge and recommend that Users pretest their application prior to incorporating the product into use and assume that the User will conduct such testing. Also see warranty statement on website.

Available In:

SIZE: 50ml Tube

P/N: 50152