

GASKETING & PIPE SEALANTS







Technical Information

Lockfast® Gasket Makers and Pipe Sealants

Anaerobic adhesives cure in the absence of air between close fitting parts where metal ions are present.









Gasket Makers

Anaerobic liquid gasket makers create a reliable airtight seal, between close fitting metal parts.

	Viscosity Range (cP)	Shear Strength (N/mm ²)	Gap Fill (mm)	Service Temp (°C)	Fixture Time/ Full Cure	Scan QR Code for SDS
 G10 <small>Slow Cure High Temperature Chemical Resistant</small> GASKET MAKER	180,000-500,000 Thixotropic	>5	0.25	-54 to 204	<30min /24hr	
<p>A light red, heat and chemical resistant gasket maker that is ideal for use on rigid assemblies.</p>						
 G18 <small>Medium Strength Chemical Resistant</small> GASKET MAKER	800,000-3,750,000 Thixotropic	>5	3-7	-54 to 150	<30min /24hr	
<p>A red, fast cure, semi flexible, general purpose gasket maker that is ideal for casted iron, steel and aluminium assemblies.</p>						
 G74 <small>Instant Gasket Oil Tolerant</small> MULTI GASKET	175,000-525,000 Thixotropic	>6	5	-54 to 150	<1hr/24hr	
<p>An orange, fast cure, semi rigid, general purpose gasket maker that is ideal for rigid metal parts such as cast iron assemblies and pump housings.</p>						

Pipe Sealants

Prevent leaking and loosening caused by vibration and thermal expansion.

	Viscosity Range (cP)	Breakaway Torque (N.m)	Shear Strength (N/mm ²)	Compressive Strength (psi)	Service Temp (°C)	Fixture Time (min) by Substrate Reactivity			Scan QR Code for SDS
						Very Active	Active	Passive	
 H42 <small>Low-Medium Strength Oil Resistant</small> HYDRAULIC SEALANT	100-150	15	>6.5	10,000	-54 to 150	15	30	150	
<p>A brown, low to medium strength, oil resistant pipe sealant. Ideal for fine threaded hydraulic and pneumatic fittings.</p>									
 P65 <small>Instant Low Pressure Seal Fast Cure</small> PIPE SEALANT	175,000-525,000 Thixotropic	5	>1	10,000	-54 to 150	20	30	180	
<p>An off white, fast cure, instant low pressure pipe sealant. Ideal for coarse threads, due to its viscosity and lubricating properties.</p>									
 P72 <small>with P.T.F.E High Temperature</small> PIPE SEALANT	280,000-800,000 Thixotropic	2	>2	10,000	-54 to 200	150	180	360	
<p>An off white, slow cure, high temperature pipe sealant with PTFE. Suits coarse threads, allows user time for adjustments.</p>									
 P77 <small>General Purpose Fast Cure</small> PIPE SEALANT	16,000-33,000 Thixotropic	33	>5	10,000	-54 to 150	10	20	120	
<p>A yellow, general purpose, fast cure pipe sealant. Seals and locks threaded metal pipes and fittings.</p>									

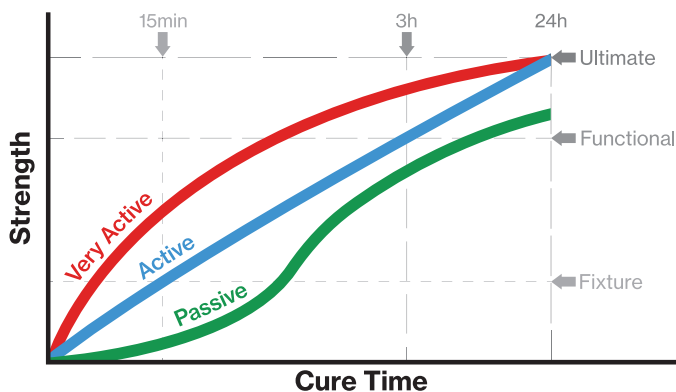
Directions For Use

1. For optimum performance surfaces should be clean and free of grease.
2. If the material is an inactive metal consider using activator.
3. Shake the product thoroughly before use. Apply several drops to the surfaces to be sealed.
4. Assemble and tighten as required.
5. To prevent the clogging of the nozzle, do not let the tip touch metal surface during application.

Fixture Time vs. Substrate

There may be a difference in fixture speed and strength based on the substrate. As opposed to passive materials such as stainless steel or zinc dichromate, anaerobic adhesives will reach full strength more rapidly with active materials such as mild steel and brass.

See the graph below for an example of how this may affect fixture and functional strength times, ultimate strength may be achieved in 24 hours, or occasionally longer.



The graph depicted is for illustrative purposes and is for guidance only.

Substrate Reactivity

The table below lists substrates by reactivity.

Very Active	Passive	
Brass	High-alloy Steel	Stainless Steel
Copper	Aluminium	Oxide Films
Active	Nickel	Chromate Films
Mild Steel	Zinc	Anodic Coatings
Bronze	Silver	Plastics
Iron	Gold	Ceramics

Fixture Time vs. Temperature

Fixture times will be longer at lower temperatures. It is possible to accelerate the fixture time of assembled parts by heating them or using an activator.

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Fixture Time vs. Bond Gap

Fixture speed of anaerobic adhesives is greatly affected by bond gap size. A larger gap between threads/parts can result in a prolonged fixture time.

Fixture Time vs. Activator

When the cure time is too slow or the bond gap is too large, activators can be used to accelerate the fixture time. Activators can reduce bond strength by up to 30%.

Chemical Resistance

The chemical resistance of anaerobic adhesives to various oils and solvents, including motor oil, leaded petroleum, brake fluids, acetone, ethanol, propanol, and water, is exceptional.

Disassembly and Clean-up

Remove with standard hand tools. In circumstances where hand tools do not work, use localised heat, disassemble while hot. To remove cured product use a combination of solvent and abrasion such as a wire brush.

Storage

Store in a cool area and out of direct sunlight. Keep product between 8°C and 21°C to give optimum storage stability.

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with chlorine or other strong oxidising materials. Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases these solutions can affect the cure and performance of the adhesive. This product is not recommended for use on certain plastics. **For information on safe handling of this product consult the Safety Data Sheet (SDS).**

SCAN FOR FULL LOCKFAST RANGE

