



GM30

GM 30 is an anaerobic curing adhesive for the gasketing and sealing of flanges. To replaces solid gaskets, gives flexible cured films. To seal against gases, water, LPG, hydrocarbons, oils and other chemicals. Thixotropic property prevents migration of the sealant before or during curing. Shocks and vibrations resistant are unaffected properties of sealing in the range of temperature from -55 to +180°C. GM 30 is designed to be used and cured at room temperature. Where cured speed is unacceptably long, or large gaps are present, applying activator to the surface will reduce the curing within few minutes.

| | |
|---------------------------|--|
| Technology / Base | Dimethacrylate Ester |
| Type of Product | Flange Sealant |
| Components | One Component |
| Curing | Anaerobic with Secondary Heat Cure or Accelerated with Activator |
| Appearance / Color | Red |
| Consistency | Thixotropic Gel |

Technical Data

| Property | Value | Method/Condition |
|--|--------------------------------------|---|
| Rheology | | |
| Viscosity | 1,125,000 +/- 375,000 cps @ 0.5 rpm | Brookfield at 20°C to 25°C (68°F to 77°F) |
| Density | | |
| Specific Gravity | 1.12 | |
| Uncured Materials Characteristics | | |
| Flash Point | > 93°C (200°F) | |
| Gap Fill | Primed-0.05 inch, Unprimed-0.01 inch | |
| Shelf Life | 12 months unopened | |
| Storage Condition | 20°C (68°F) | |
| Cured Material Characteristics | | |
| Full Cure Conditions | 24 hours at 25°C | |
| Cure Appearance | Red Solid | |
| RoHS Compliant | Yes | |
| Cured Mechanical Properties | | |
| Locking Strength | Medium | |
| Breakaway Torque | | to |
| Prevailing Torque | | to |
| Pin/Collar Shear Strength | >725 psi | |
| Service Temperature | -55°C to 150°C (-65°F to 300°F) | |

General Instructions

Surfaces to be bonded should be clean and dry and free of grease. Product should be applied in enough quantity to fill all engaged threads. The product performs best in thin bond gaps. Very large gaps may create gaps that will affect the cure speed and overall strength. Good contact is essential. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours. This product is not recommended for use in pure oxygen environments and/or oxygen-rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

Specifications and Approvals

Curing Performance

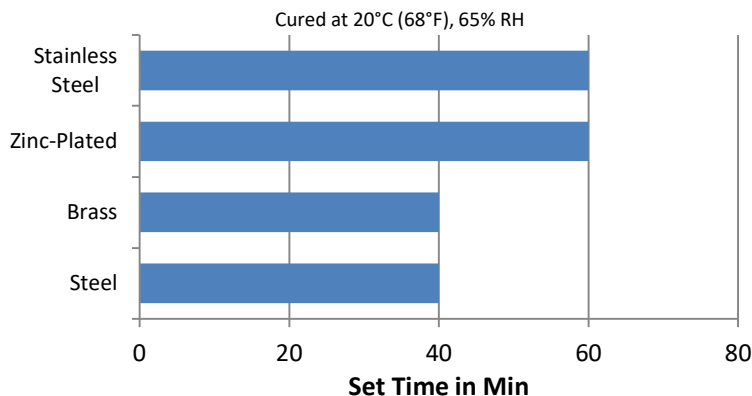
The rate of cure will depend on environmental conditions and the substrates used. The gap of the bond line will affect set speed. Smaller gaps tend to increase set speed. Activators may be applied to further improve set speed, but may also impair overall adhesive performance.

Storage

Products should be stored unopened in a cool, dry place out of direct sunlight. Products may be refrigerated for improved shelf life, but should be brought back to room temperature before use.

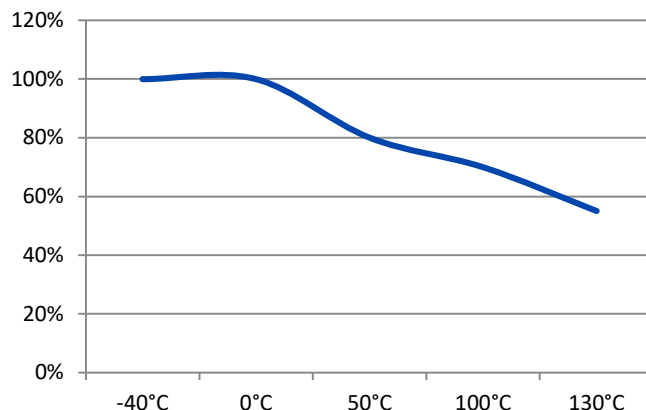


Set Time on Various Substrates

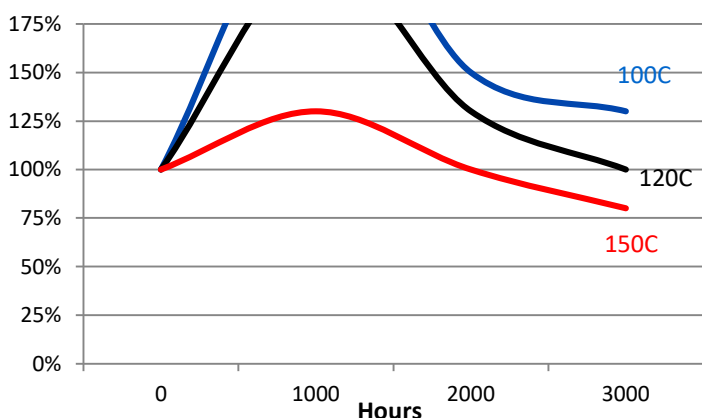


Test Conditions: 68°F / 20°C, 65% RH

Hot Strength (%RT strength, tested at temperature)



Heat Aging (aged at temp. indicated and tested @ 22°C)



Safety and Disposal Advice

For safe handling information on this product, consult the Safety Data Sheet (SDS)

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Solvent Resistance

| Solvent | Example | Resistance |
|---------------------------------|---|---------------------------|
| Alcohol | Ethanol, Methanol | +++ |
| Ester (aromatic) | Ethylacetate | --- |
| Ketone (aromatic) | Acetone, Benzophenone | --- |
| Aliphatic hydrocarbon (alkanes) | Petrol, Heptanes, Hexane | +- |
| Aromatic hydrocarbons | Benzyl, Toluol, Xylol | +- |
| Halogenated hydrocarbons | Methylenchloride, Chloroform, Chlorobenzol | --- |
| Weak aqueous acid | Nitrite, muriatic acid, sulphuric acid, phosphoric acid | +++ (--- if concentrated) |
| Weak aqueous base | sodium hydroxide solution, caustic potash | +++ (--- if concentrated) |

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