

PERMATEX SUPRA BLACK GASKET MAKER

DESCRIPTION

Permatex Supra Black Gasket Maker is a single component, room temperature, vulcanizing, gasketing compound designed to provide reliable "formed-in-place" gaskets for mechanical assemblies. This material cures on exposure to moisture in the air to form a tough, flexible, silicone rubber gasket. The product resists aging, weathering and thermal cycling without hardening, shrinking or cracking. Designed to provide increased oil resistance and complies with extended warranty requirements.

DIRECTIONS FOR USE

For assembly as a form-in-place gasket

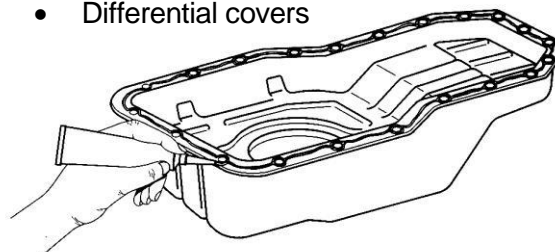
1. Remove all previous material from mating surfaces.
2. For best results, clean and dry all surfaces with a residue-free solvent.
3. Cut nozzle to desired bead size.
4. Remove cap, puncture tube or cartridge seal and attach extension nozzle.
5. Apply a continuous and even bead of silicone to one surface.

PRODUCT BENEFITS

- Improved oil resistance
- Sensor safe, non-corrosive
- Good adhesion and flexibility
- Replaces most cut gaskets
- Can be used as a gasket maker or dressing
- Non-flammable, Non-toxic
- Low odor

TYPICAL APPLICATIONS

- Oil pans
- Transmission pans
- Valve covers
- Valves and guides
- Timing gear covers
- Differential covers



TECHNICAL CHARACTERISTICS

Before use:	METHODS	SPECIFICATIONS		
		MIN.	TYPICAL	MAX
Appearance			Black thixotropic paste	
Temperature resistance			-70°C up to +350°C	
Continuous working temp.			-60°C up to +240°C	
Application temperatures ¹			+5 °C up to +45°C	
Extrusion speed (s)	20 gr, 2 mm nozzle, 2.75 bar	75	120	180
Slag (inch)	ASTM D 2202	0	0.1	0.3
Tack free time (min.)	K30027		60	
Curing rate, at 23°C, 50% RH				
(mm): 24 hr			4	
48 hr			6	
Density (g/cc)	ASTM D-1475		1.05	

¹ Due to condensations that might occur and affect adhesion, it is recommended against sealing on substrates at <5 ° C temperatures.

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Totally Cured product		SPECIFICATIONS		
7 days at 23°C and 50% RH	METHODS	MIN.	TYP.	MAX.
Hardness (Shore A)	ISO 868-2003	31	36	41
Tensile strength (MPa)	ISO 37-2005	0.9	1.5	1.9
E modulus at 100% elongation (MPa)	ISO 37-2005	0.55	0.8	0.85
Elongation at break (%)	ISO 37-2005	170	220	290

HEAT RESISTANCE: characteristics		SPECIFICATIONS		
after 1 week at 300°C	METHODS	MIN.	TYP.	MAX.
Hardness (Shore A) (%)	ISO 868-2003		41	
Tensile strength (%)	ISO 37-2005		0.9	
Elongation at break (%)	ISO 37-2005		75	

The information herein is offered in good faith based on KRAFFT's research and it is believed to be accurate. KRAFFT keeps the right to modify the specification without previous notice.