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Technical Data Sheet

Permatex® High Temperature Cut Gasket Coating

Revised 03/25

PRODUCT DESCRIPTION

Permatex Cut Gasket Coating protects and extends the life of paper, cork, composite and rubber cut gaskets by reducing cut gasket deterioration and blow outs. Proprietary Black, Grey and Red formulations developed for specific cut gasket applications. This material cures with exposure to moisture in the air to form a tough, flexible, silicone coating. This product will resist aging, weathering, and thermal cycling without shrinking or cracking.

PRODUCT BENEFITS

- High Temperature Resistance
- Sensor safe, non-corrosive
- Extends the life of cut gaskets
- Can be used as a positioner
- Non-flammable, Non-toxic
- Low odor

TYPICAL APPLICATIONS

- Exhaust Manifolds
- Exhaust Header and Gaskets
- Turbo charger gaskets
- Compressors

DIRECTIONS FOR USE

For assembly as Conditioner

1. For best results, the cut gasket and installation surfaces should be clean and dry.
2. Apply a continuous and even bead of silicone to one surface of the cut gasket, first tracing the internal areas of the cut gasket configuration, then all surrounding bolt holes.
3. Press the coated surface of the cut gasket to the assembly and repeat step 2 on the mating surface.
4. Assemble all parts immediately while silicone is still wet.
5. Finger tighten flange bolts until material begins to squeeze out around the flange.
6. Tighten to torque specifications after 1 hour.

For assembly as Positioner

1. For best results, the cut gasket and installation surfaces should be clean and dry.
2. Apply a continuous and even bead of silicone to one surface of the cut gasket, first tracing the internal areas of the cut gasket configuration, then all surrounding bolt holes.
3. Press the coated surface of the cut gasket to the assembly.
4. Assemble all parts immediately while silicone is still wet.
5. Finger tighten flange bolts until material begins to squeeze out around the flange.
6. Tighten to torque specifications after 1 hour.

NOTE: Not recommended for use on head gasket or parts in contact with gasoline.

For Cleanup

1. Remove uncured product from parts and hand-tools with Permatex® Fast Orange® Wipes or Fast Orange® Hand Cleaners. If skinned over, break film with a dry cloth to remove as much as possible. Remove the remaining material with Permatex® Safer Scraper.
2. Clean hands with a dry cloth or Permatex® Fast Orange® Hand Cleaner.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Oxime silicone rubber
Appearance	Red Paste
Odor	Low odor
Specific Gravity	1.18
Extrusion rate @ 25°C, (grams/min)	>100
Flash Point °C (°F)	>93 (>200)

TYPICAL CURING PERFORMANCE

Permatex® High Temperature Cut Gasket Coating cures on exposure to moisture in the air. The product dries tack free in one hour and fully cures in 24 hours. Cure times will vary with temperature, humidity and gap.

PERFORMANCE OF CURED MATERIAL

After 7 days at 25°C (77°F), 50% Relative Humidity

	Typical Values
Hardness (Shore A)	>15
Elongation, %*	>200
Tensile Strength, N/mm ² (psi) **	>0.7 (>100)

*Material will stretch 1.5 times its original length before breaking.

**Amount of force required to break material.

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance Typical Values

Continuous, °C (°F)	-54 to 287	(-65 to 550)
Intermittent, °C (°F)	-54 to 315	(-65 to 600)

Chemical / Solvent Resistance

The product retains effective properties in contact with most shop fluids, automotive fluids, such as motor oil, transmission fluids, alcohol and antifreeze solutions. Note: Not recommended for parts in contact with gasoline.

GENERAL INFORMATION

NOT FOR PRODUCT SPECIFICATIONS.
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.
PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.
PERMATEX, INC., 6875 PARKLAND BOULEVARD SOLON, OHIO 44139 PHONE - (1-877)PERMATEX)

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size	Units per case
80014	2 oz. (57g) tube, carded	12

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

NOTE

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