

<b>Product</b>	<b>Protac® 5818 Gasket Sealant</b>	
<b>Description</b>	Protac® 5818 is a single component, medium strength, anaerobic gasketing compound. It is a very high viscosity, thixotropic product which cures when confined in the absence of air between close-fitting flat metal surfaces.	
<b>Applications</b>	Protac® 5818 is a 'form-in-place' gasketing product designed for use on rigid metal flanges and surfaces, e.g. gearbox casings, machinery covers, pump housings, etc. It is a slightly slower curing grade which develops medium strength and will give an almost instant low-pressure seal (up to 0.5 bar after 20 mins.) to allow on-line pressure testing.	
<b>Physical Properties</b>	Chemical type	Dimethacrylate Ester
	Appearance	Red
	Specific Gravity	1.09
	Viscosity cPs at 25°C	75,000-150,000
	Brookfield RVT Spindle 4 @ 25 rpm	
	Gap fill	>0.5mm
	Flash Point	>100°C
	Shelf Life	24 months
	Temperature Range	-50°C to 150°C
<b>Curing Properties</b>	Typical cure speeds as percentage of final strength	
	30 mins	5-10%
	3 hours	30-40%
	24 hours	100%
<b>Shear Strength (after 24 hours at 22°C)</b>		
<b>Comprehensive (ISO 10123)</b>	Steel Pins & Collars	>5 N/mm <sup>2</sup>
<b>Lap (ISO 4587)</b>	Steel (Grit blasted)	7.5 N/mm <sup>2</sup>
<b>Tensile (ISO 6922)</b>	Steel (Grit blasted)	8.5 N/mm <sup>2</sup>
<b>Cure speed</b>	Cure speed will vary according to the substrates. When used with active surfaces such as mild steel and brass components anaerobic adhesives will reach full cure faster than more inert materials such as stainless steel. Protac® AC3049 activator may be used to accelerate cure speed.	
<b>Chemical / Solvent Resistance</b>	Protac® anaerobics exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives are not recommended for use in pure oxygen or chlorine lines.	

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<b>Bond gap</b>	Bond line width will greatly affect the speed of cure of anaerobic adhesives. The larger the gap between parts, the slower the cure speed.
<b>Temperature</b>	Cure speed is tested at 22°C. Lower temperatures will result in slower cure. Higher temperatures will offer faster cure speeds. AC3049 activator should be used when the temperature is less than 5°C.
<b>General Information</b>	<p>Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.</p> <p>Anaerobic adhesives are not recommended for certain plastics as stress cracking can sometimes result. Some anti-corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary. Protac<sup>®</sup> AC3049 activator may be required on plated parts.</p>
<b>Directions for use</b>	Ensure parts are clean, dry and free from oil and grease. Apply adhesive to all engaged threads. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint.
<b>Storage</b>	Store in a cool area out of direct sunlight. Optimal storage conditions are between 8° and 21°C.
<b>Packaging</b>	Bottles: 50ml and 250ml. Available in bulk for use with dispensing systems.
<b>Health &amp; Safety</b>	For safe handling of this product consult the Material Safety Data Sheet.
<b>Data ranges</b>	Data contained in this data sheet may be reported as typical value and/or range. Values are based on actual test data and are verified on a regular basis.
<b>Notes</b>	The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Novachem Corporation Limited and its agents cannot assume liability or responsibility for results obtained in the use of its product by persons whose methods are outside or beyond our control. It is the user's responsibility to determine the suitability of any of the products and methods of use or preparation prior to use mentioned in our literature, and furthermore the user's responsibility to observe and adapt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.