

Product	Protac® 5874 Multi Gasket	
Description	Protac® 5874 is a single component, low-medium strength, anaerobic gasketing compound. It is a thixotropic product that cures quickly on steel surfaces. Protac® 5874 cures when confined in the absence of air between close-fitting flat metal surfaces.	
Applications	Protac® 5874 is a 'form-in-place' gasketing product designed for multi-purpose applications on rigid metal flanges and surfaces, e.g. gearbox casings, machinery covers, pump housings, compressor end caps, etc. It cures quickly on steel surfaces and develops low-medium strength. It will give an almost instant low pressure seal (up to 0.5 bar after 20mins.) to allow on-line pressure testing.	
Physical Properties	Chemical type	Dimethacrylate Ester
	Appearance	Orange
	Specific Gravity	1.1
	Viscosity cPs at 25°C	30,000 – 100,000
	Brookfield RVT Spindle 4 @ 25 rpm	
	Gap fill	>0.3mm
	Flash Point	>100°C
	Shelf Life	24 months
	Temperature Range	-50°C to 150°C
Curing Properties	Typical cure speeds as percentage of final strength	
	18-20 mins	5-10%
	1 hours	30-40%
	24 hours	100%
Shear Strength (after 24 hours at 22°C)		
Comprehensive (ISO 10123)	Steel Pins & Collars	>6 N/mm ²
Lap (ISO 4587)	Steel (Grit blasted)	8.5 N/mm ²
Tensile (ISO 6922)	Steel (Grit blasted)	5 N/mm ²
Cure speed	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.	
Chemical / Solvent Resistance	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.	

Bond gap	Bond line width will greatly affect the speed of cure of anaerobic adhesives. The larger the gap between parts, the slower the cure speed.
Temperature	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.
General Information	<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® AC3049 activator may be required on plated parts.</p>
Directions for use	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.
Storage	Store in a cool area out of direct sunlight. Optimal storage conditions are between 8° and 21°C.
Packaging	Bottles: 50ml and 250ml. Available in bulk for use with dispensing systems.
Health & Safety	For safe handling of this product consult the Material Safety Data Sheet.
Data ranges	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.
Notes	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.