

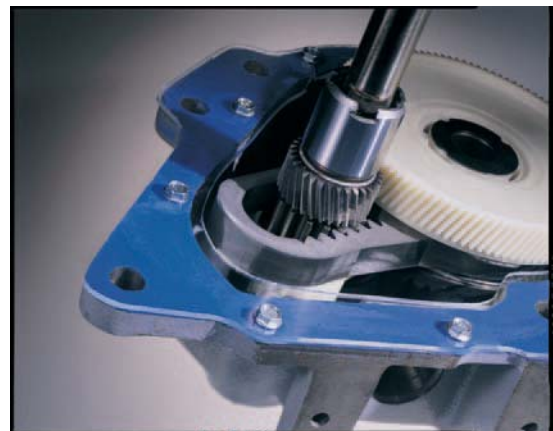
Polymeric Flange Sealant - Flexible Blue

GENERAL INFORMATION: *SAF-T-LOK* anaerobic adhesive/sealants are a specialized series of single component, solvent free compounds that are individually formulated for locking, sealing, retaining and bonding metal parts and assemblies. Stable in the presence of air, these products cure when placed between mating metal parts, forming a resilient, vibration-proof polymer shim. *SAF-T-LOK* adhesive/sealants provide the user with additional performance characteristics, including resistance to corrosion or galvanic attack, as well as solvent resistance; while allowing disassembly with normal tools, if necessary.

PRODUCT DESCRIPTION: *SAF-T-LOK PFS Blue* conforms to the surface imperfections and tool marks on flanged surfaces, thus allowing a metal-to-metal fit of the parts and eliminating the need to retorque compressible mechanical gaskets. This improves the sealing integrity of the joint. The rheology of *SAF-T-LOK Polymeric Flange Sealant* facilitates screening or pressure feed for robotic application. *PFS Blue* is designed to cure on aluminum as well as steel surfaces. The relatively low bond strength permits convenient field disassembly. While uncured product is compatible with fuels, solvents, hydraulic fluids, and oils, cured joints are chemically resistant.

PRODUCT CHARACTERISTICS: (Uncured)

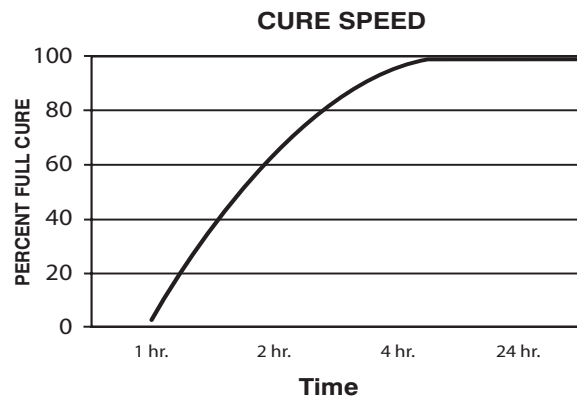
Chemical Type	Methacrylate Ester
Color	Blue
Specific Gravity	1.03 gm/cc
Viscosity@ 25°C	
Brookfield RVF (Helipath)	
Spindle #7 @ 2.0 rpm	200,000 cps
20 rpm	45,000 cps
Flash Point (TCC)	(>250°F) >120°C
Temperature Range	-65°F to +300°F (-18°C to 150°C)



PERFORMANCE CHARACTERISTICS: (Cured)

The rate of cure is dependant on substrate. The graph show the percent of strength with time on grit blasted lap shear samples tested per ASTM 1002.

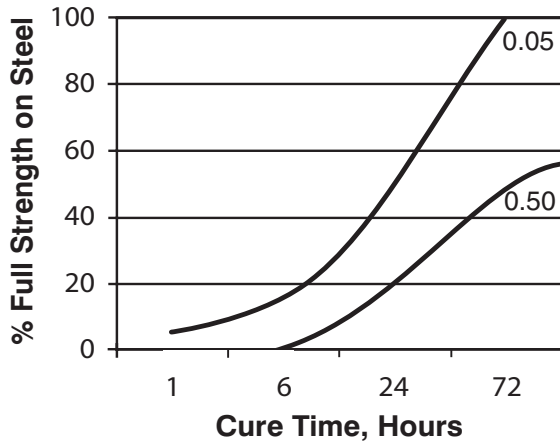
Locking Shear ASTM 1002	800 psi (5.7Nm)
Cure Speed	
Without Primer	6 Hours, 10 mil gap
With Primer	30 Minutes
Gap Filling	.001 - .050 in.
Instant Sealing	2 psig, 10mil gap
Chemical Resistance	Excellent



IMPORTANT NOTICE: All statements and technical data contained herein are based on tests we believe to be reliable, but the accuracy of completeness thereof is not guaranteed. It is recommended that the buyer test this product to determine its suitability for his application before use. **SAF-T-LOK Chemical Corporation** is not responsible for loss, claim or damages resulting from use of its products.

CURE SPEED vs. BOND GAP

The rate of cure varies with the bond gap between gasket surfaces. The graph below shows the effect bond gap has on the development of lap shear strength. Samples were grit blasted and tested in accordance with ASTM 1002.

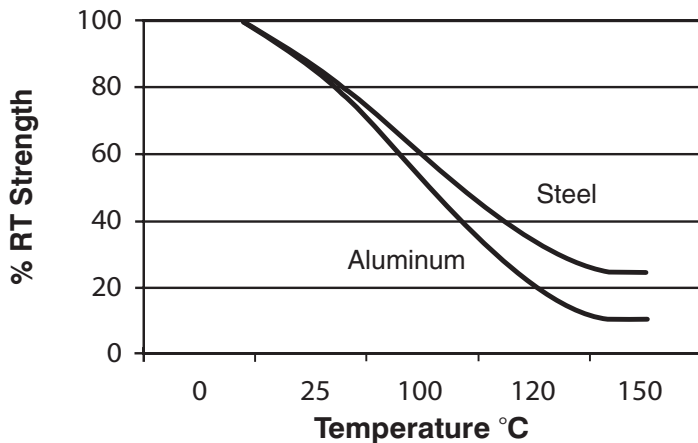


TYPICAL ENVIRONMENTAL RESISTANCE

The test data summarized below shows the effects of environment upon strength. This is not a measure of sealing performance.

HOT STRENGTH

Test were conducted on grit blasted steel and aluminum substrates in accordance to ASTM D1002.



CHEMICAL/SOLVENT RESISTANCE

Aging under conditions indicated and tested at 23°C (74°F)

Solvent	Temp.	% Strength retained @	
		100 hr	1000 hr
Motor Oil	125°C	75	65
Unleaded Petroleum	22°C	100	115
Water/Glycol	87°C	84	65

GENERAL INFORMATION

This product is not recommended for use in pure oxygen service and should not be used for chlorine or other strong oxidizing agent applications.

Refer to the Material Safety Data Sheet (MSDS) for safe handling information.

If surfaces are cleaned with aqueous washing systems, check for compatibility of washing solution. Some washes can affect cure and performance of this adhesive.

PFS Sealant is not normally recommended for use on plastics. Users should confirm compatibility with such substrates.

Directions for use

For best performance, surfaces should be clean and free of grease. The product is designed for close fitting flanged parts with gaps up to 0.05mm. Apply manually as a continuous bead or by screen printing. Low pressures (<0.5bar) may be used to test and confirm complete seal immediately. Flanges should be tightened as soon as possible.

Storage

Store in a cool, dry location in unopened containers between 46°F to 82°F. Optimum storage is at the lower half of the range. To prevent contamination, do not return any unused material to its original container.

Data Ranges

The data contained herein may be reported as a typical value based on mean value with standard deviations. Values are based on actual test data.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. SAF-T-LOK specifically disclaims all warranties expressed or implied arising from sale or use of its products.