



**HOLDIT®**

**Technical Datasheet  
HOLDIT G51**

*Revised Date: June 2011*

**Description**

HOLDIT G51 Gasket Maker is a single component medium strength, Thixotropic, anaerobic sealant which cures when confined between close fitting metal surfaces. G51 Gasket Maker provides an instant low pressure seal.

**Applications**

HOLDIT G51 seals joints between rigid metal faces and flanges such as valve covers and gearbox castings. This product can be used with or without pre-cut, pre-formed gaskets.

**Instructions for Use**

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. If the metal is inactive or the cure speed is too slow apply HOLDIT A471 Standard Anaerobic Activator. Please see table below for information on Active and Inactive metals.
3. Before application knead the product thoroughly.
4. Normally hand applied from bottle onto parts.
5. Assemble components, and tighten to require torque level.
6. Allow to fully cure before applying load.

**Properties of Uncured Material.**

Resin	Polyethylene Glycol Dimethacrylate
Colour	Pink paste
Viscosity @ 25°C	100,000-500,000 cps

**Performance of Cured Material**

Fixture Speed without Primer	90 Minutes @ 25°C
Full Cure	24 Hours @ 20°C
Shear Strength	6-10 N/mm <sup>2</sup>
Gap Fill	3.175mm
Temperature Range	-53°C to 148°C
Product Conformity	MIL-S-22473E

**Retained Strength**

100°C	50%
135°C	25%
150°C	20%

**Compatible Primers**

Primer such as HOLDIT A649 Accelerator and HOLDIT A471 Activator can be used to speed the fixture time of the adhesive. Fixtures times can improve by as much as 50%. The use of primers can result in lower strength and performance and should be tested after full cure.

**ACTIVE & INACTIVE METAL TABLE**

<b>Super Active</b> Very Fast Cure	<b>Active</b> Fast Cure	<b>Inactive</b> Slow Cure	<b>Passive</b> Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes



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**Storage**

HOLDIT G51 should be stored in a dry cool area, out of direct sunlight. Optimal Storage temperature: 8°C to 21°C.

**Presentation**

HOLDIT G51 is available in 50ml and 250ml Tubes.

**Note**

Where gap size is large or where the surface is uneven, apply primer to help cure the product through volume. G51 can be roller coated, screen printed or applied by pads.

**Health & Safety in Use**

**IRRITANT:** Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water.

**Conversions**

- $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
- $\text{N/mm} \times 5.71 = \text{lb/in}$
- $\text{MPa} \times 145 = \text{psi}$
- $\text{N/mm}^2 \times 145 = \text{psi}$
- $\text{N} \times 0.225 = \text{lb}$
- $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
- $\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$
- $\text{mPa}\cdot\text{s} = \text{cP}$

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