



Technical Datasheet HOLDIT G55

Revised Date: June 2011

Description

HOLDIT G55 Designer Gasket is a smooth thick purple paste. The anaerobic chemistry of this product creates a tough flexible formed-in-place gasket. Once confined between 2 components, G55 Designer Gasket provides an instant low pressure seal.

Applications

HOLDIT G55 is used for fuel and water pumps, engine thermostats, air compressor end caps, chainsaws, lawn mowers etc. 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 Activator or HOLDIT A649 Accelerator. Please see table below for information on Active and Inactive metals.
3. Before application shake the product thoroughly.
4. Apply the adhesive to the fixing position of the fastener or onto the internal threads of a blind hole.
5. Assemble components, and tighten to require torque level.
6. Allow to fully cure before applying load.

Properties of Uncured Material.

Resin	Modified Urethane Acrylate
Colour	Purple
Viscosity (Thixotropic)	275,000/950,000 cps

Performance of Cured Material

Fixture speed w/Activator	<10 minutes
Fixture Speed W/out Activator	20 mins
Full Cure	24 hrs @ 20°C
Gap Fill	0.01"
Temperature Range	-53°C to 148°C
Shear Strength	3Nm / 13Nm
Product Conformity	MIL-S-22473E

Environmental and Fluid Resistance (Shear Strength Values)

Heat Age	100%
Engine oil @ 150°C	100%
Brake Fluid @ 150°C	80%
ATF @ 150°C	85%
50/50 water / ethylene glycol @ 120°C	80%
Water @ 100°C	80%
Gasoline @ 25°C	95%
Diesel Fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	90%

Compatible Primers

Primer such as A649 Accelerator and 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

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



HOLDIT
Technical Datasheet
HOLDIT G55
Revised Date: June 2011

Storage

HOLDIT G55 should be stored in a dry cool area, out of direct sunlight in temperatures between -10°C and 30°C. Optimal Storage temperature is 22±4°C. This product has a 18 month shelf life from manufacture when stored at 22±4°C.

Presentation

HOLDIT G55 is available in 50ml and 250ml Tubes.

Note

Where gap size is large or where the surface is uneven, apply a HOLDIT Primer to assist curing the product. G55 Designer Gasket can be roller coated, screen printed or pad applied.

Health & Safety in Use

IRRITANT: Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

Conversions

- (°C x 1.8)+32 = °F
- N/mm x 5.71 = lb/in
- MPa x 145 = psi
- N/mm² x 145 = psi
- N x 0.225 = lb
- N·m x 8.851 = lb·in
- N·mm x 0.738 = lb·ft
- mPa·s = cP

ACTIVE & INACTIVE METAL TABLE

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

The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Holdtite Australia and its agents cannot assume liability or responsibility for results obtained in the use of its products by persons whose methods are outside or beyond our control. It is the users 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 users responsibility to observe and adopt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.