



**Directions for use****1. For assembly as form-in-place gasket**

1. Remove all previous material from mating surfaces.
2. For best results, clean and dry all surfaces with a residue-free solvent.
3. Cut nozzle to desired bead size, 1.5 to 6.5 mm. A bead size of 3 mm is usually sufficient for most applications.
4. Remove cap, puncture tube or cartridge seal and attach extension nozzle.
5. Apply a continuous and even bead of LOCTITE® Instant Gasket to one surface, first tracing the internal areas of the gasket configuration, then all surrounding bolt holes.
6. Assemble parts with 5 minutes while LOCTITE® Instant Gasket is still wet. Secure or tighten to recommended torque specs.
7. Re-torque will not be necessary after the product has cured.

**2. Clean up**

1. Allow excess material to extend beyond the extension nozzle or aerosol tip to cure, seal and protect the remaining product from moisture. For reuse, simply remove the cured product from the tip.
2. Remove uncured product from parts and hand-tools with a dry cloth. If skinned over, break film with a dry cloth to remove as much as possible and remove the remaining material.
3. Clean hands with a dry cloth or hand cleaner.

**Loctite Material Specification<sup>LMS</sup>**

LMS dated August 19, 2004. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

**Storage**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

**Note**

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Reference 1.0