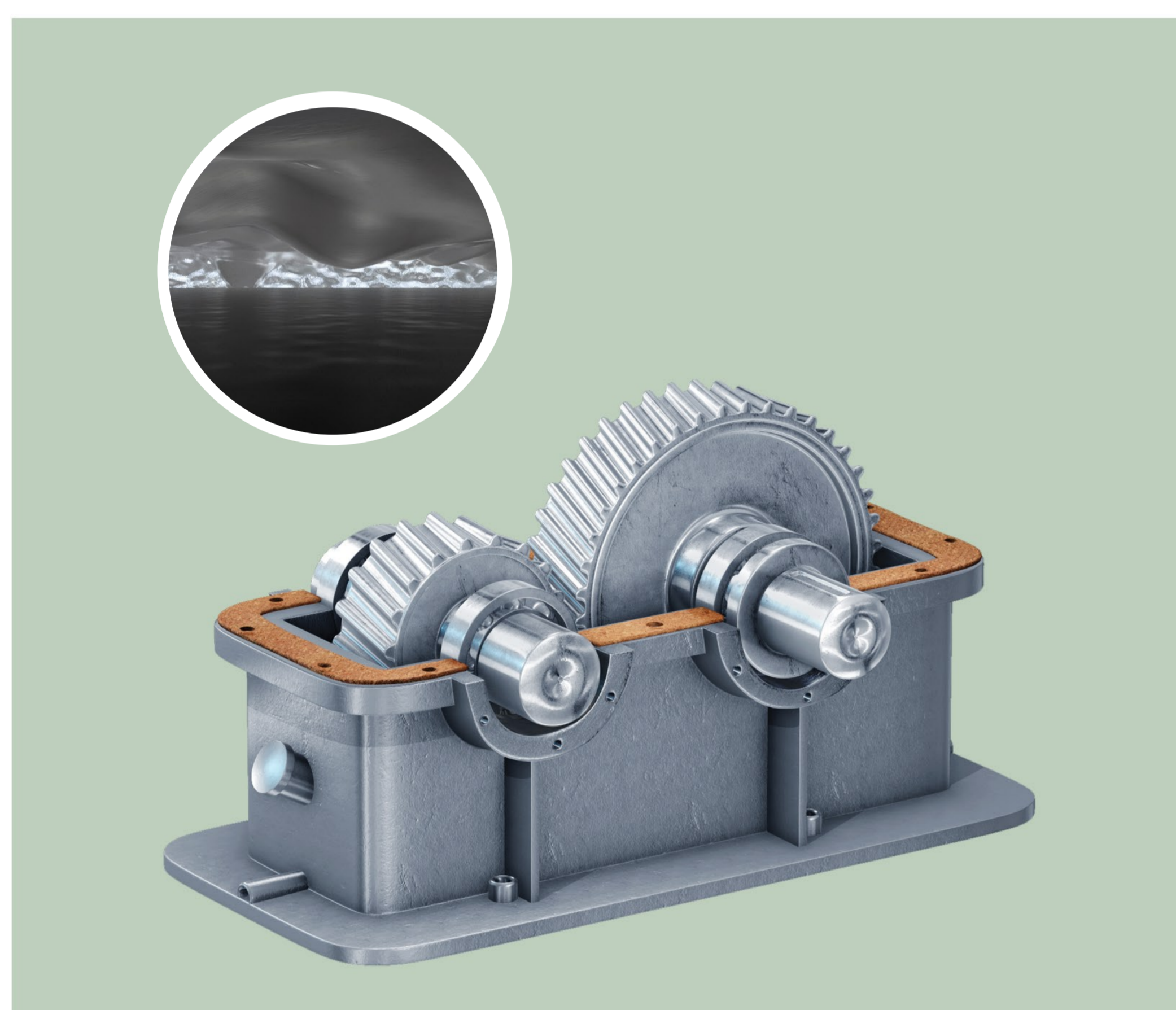




GASKETING **PRODUCT** **GUIDE**

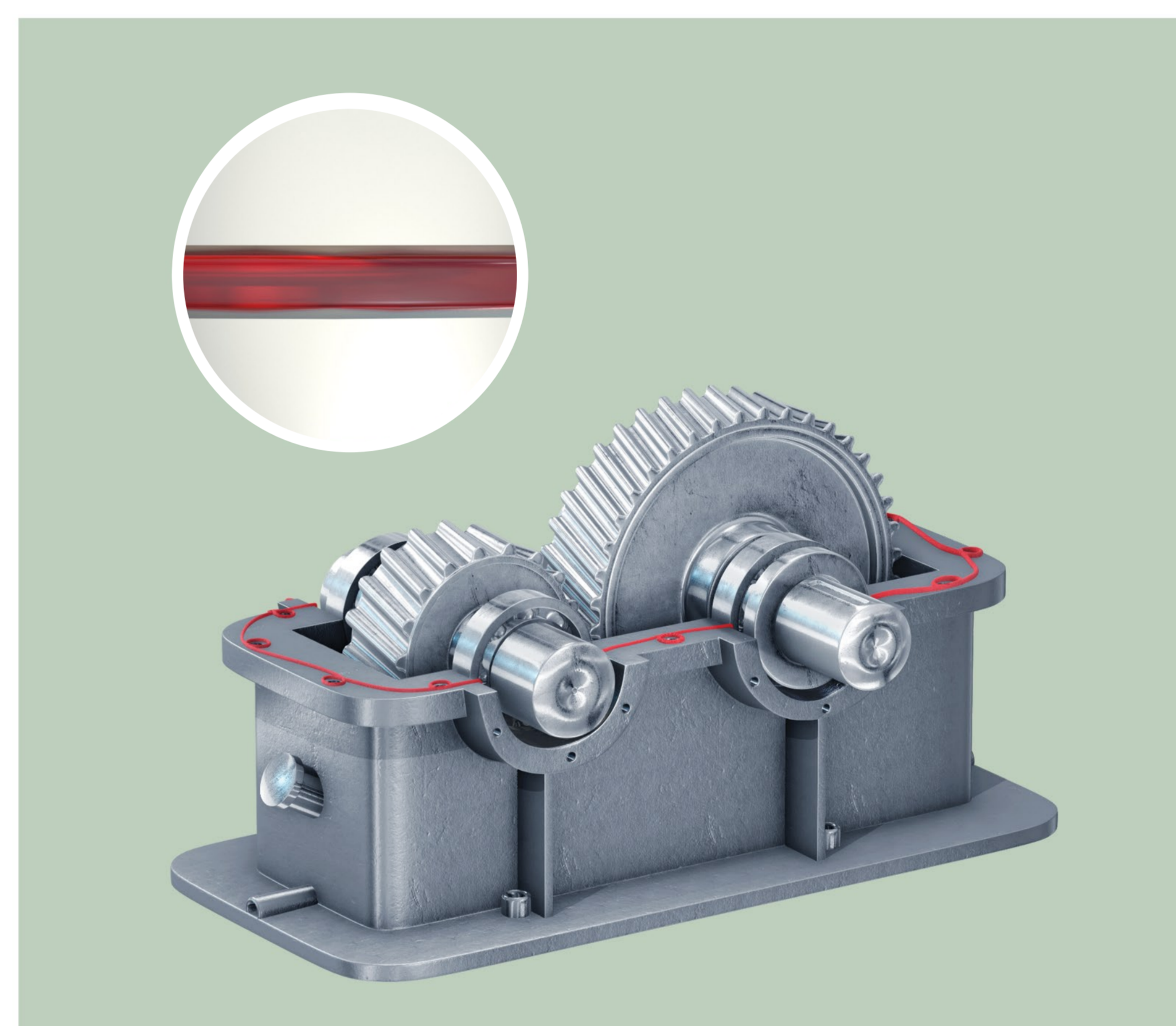


CUT GASKETS LEAK. WE SEAL.



Problem

With compression gaskets:
Not all surface imperfections are filled.
They distort, relax under compression
and displace from the joint.



Solution

With liquid gaskets:
When assembled, all surface imperfections
are filled, adding structural stiffness and
eliminating micromovement and slipping.
They do not shrink, crack or suffer from
relaxation.

LIQUID GASKETS HOLD UP BETTER. FOR LONGER LASTING SEALS.

To provide a leak-free seal over a long period of time, gaskets must fill voids and be resistant to liquids and /or gases, while withstanding the operating temperatures and pressures to which they are subjected. LOCTITE® offers a range of gasketing products designed for any flange type, gap size or material.



HOW TO CHOOSE A GASKETING PRODUCT

Flange Type

Rigid Machined Flanges

Rigid, machined flange surfaces typically are designed for no gap, allowing for metal to metal contact. For these assemblies anaerobic liquid gaskets are the best choice because they provide the highest strength seal.

Stamped or Flexible Flanges

Typically thinner, stamped metal flanges can have larger gaps that need to be filled. They are also subject to more flex in service. For these types of assemblies, silicone liquid gasketing products provide the best seal.

 **Bestseller**

518™ Pen

No-drip, No-mess

The new LOCTITE® 518™ Pen is a leak-fighting flange sealant with an easy to apply roll-on applicator. It's the fastest way to apply reliable and long-lasting liquid gaskets, without any mess or waste. Rigid, machined flange surfaces typically are designed for no gap, allowing for metal to metal contact. For these assemblies anaerobic liquid gaskets are the best choice because they provide the highest strength seal.

 **Flange Type:** Rigid Machined Flange



 **Bestseller**

SI 5910™

High Adhesion

LOCTITE® SI 5910™ is a low strength, silicone-based gasketing product designed for use on flexible flanges with machined or cast surfaces. It has good resistance against oil and joint movement. Typical applications include stamped sheet metal covers. Typically thinner, stamped metal flanges can have larger gaps that need to be filled. They are also subject to more flex in service. For these types of assemblies, silicone liquid gasketing products provide the best seal.

 **Flange Type:** Stamped/Flexible Flange



FIND THE RIGHT PRODUCT FOR YOUR APPLICATION

FLANGE TYPE

Rigid Machined Flange

- LOCTITE® 518™
- LOCTITE® 518™ Pen
- LOCTITE® 510™
- LOCTITE® NS 5540™
- LOCTITE® NS 5550™

Stamped Flange

- LOCTITE® SI 5699™
- LOCTITE® SI 5910™
- LOCTITE® SI 5900™
- LOCTITE® SI 596™

Rigid Machined Flange Gasketing Products



518™ General Purpose

- Color:** Red
- Viscosity:** 750,000 cP Thixotropic
- Temperature Resistance:** 300°F
- Cure Method:** Anaerobic



518™ Pen No-drip, No-mess

- Color:** Red
- Viscosity:** 750,000 cP Thixotropic
- Temperature Resistance:** 300°F
- Cure Method:** Anaerobic



510™ High Temperature

- Color:** Opaque Pink
- Viscosity:** 90,000 cP Thixotropic
- Temperature Resistance:** 400°F
- Cure Method:** Anaerobic



NS 5540™ Extreme Temperature

- Color:** Brown
- Viscosity:** 48,000 cP
- Temperature Resistance:** 1,300°F
- Cure Method:** Heat

NS 5550™ Extreme Temperature



Color: Brown

Viscosity: 2,000,000 cP

Temperature Resistance: 1,500°F

Cure Method: Heat

Stamped Flange Gasketing Products



SI 5699™ Chemical Resistant

Color: Grey

Viscosity: Paste

Temperature Resistance: 392°F

Cure Method: Moisture



SI 5900™ Instant Seal

Color: Black

Viscosity: Paste

Temperature Resistance: 392°F

Cure Method: Moisture



SI 5910™ High Adhesion

Color: Black

Viscosity: Paste

Temperature Resistance: 392°F

Cure Method: Moisture



SI 596™ High Temperature

Color: Red

Viscosity: Paste

Temperature Resistance: 600°F

Cure Method: Moisture

Surface Preparation Gasketing Products

SF 790™

Part Cleaner IDH 135544

A gray to off-white methylene chloride liquid solvent in an aerosol spray designed to remove baked-on chemical gaskets, gasket cements and conventional gasket materials from metal surfaces. Its aerosol spray form enables spray application on to intricate shapes with maximum penetration.



SF 7649™

Primer IDH 209715

Designed to promote the curing speed of LOCTITE® anaerobic adhesives and sealants without any significant loss of joint strength. Especially recommended for applications with passive metals or inert surfaces and with large bond gaps.



Equipment Gasketing Products



HD10 Pneumatic Handheld 300 ml Cartridge Dispenser

IDH 1714379

A manually controlled applicator that dispenses product from 300 ml cartridges or 250 ml tubes (when tube adapter 989347 is used). The cartridge or tube is pneumatically pressurized and product is dispensed from the nozzle while the trigger is depressed.



Manual Cartridge Applicator

IDH 1093940

A hand-held, manually operated meter-mix dispenser. These dispensers provide a convenient, cost-effective method to apply product with minimal waste. The dispensers are compatible with 1:1 and 1:2 mix ratio products.

GASKETING PRODUCTS

Product	IDH Number	Pack Size	Color	Features	Max Gap Fill Unprimed	Viscosity [cP] 20 RPM	Thixotropic (yes/no)	Temperature Range	Fixture Time [min] Steel
RIGID MACHINED FLANGES									
518™	2096064	50 ml	Red	Ideal for use on rigid iron, steel and aluminium flanges	0.01 in. (0.25 mm)	750,000	Yes	-65°F to 300°F (-55°C to 150°C)	25
	2096061	300 ml							
518™ Pen	2392164	25 ml	Red	Roll on applicator	0.005 in. (0.125 mm)	750,000	Yes	-65°F to 300°F (-55°C to 150°C)	25
510™	135474	50 ml	Opaque Pink	High Temperature Applications	0.01 in. (0.25 mm)	90,000**	Yes	-65°F to 400°F (-55°C to 200°C)	25
	234225	250 ml							
NS 5540™	2374452	1 pint	Brown	High Temperature	0.005 in. (0.125 mm)	48,000	No	-40°F to 1300°F (-40°C to 704°C)	Heat cure product
NS 5550™	2374447	1 quart	Brown	High Temperature	0.025 in. (0.64 mm)	2,000,000	No	-40°F to 1500°F (-40°C to 815°C)	Heat cure product

Product	IDH Number	Pack Size	Color	Features	Viscosity [cP] 20 RPM	Temperature Range	Tack Free Time (min)
STAMPED OR FLEXIBLE FLANGES							
SI 596™	135507	80 ml	Red	High temperature (acetic acid silicone)	73,000 cPs*	-75°F to 600°F (-59°C to 316°C)	30
	198817	300 ml					
SI 5699™	135275	70 ml	Grey	For flexible flanges, machined or cast surfaces, metal or plastic, increased oil resistance	200 g/min**	-67°F to 392°F (-55°C to 200°C)	30
	135270	300 ml					
SI 5900™	743912	90 ml	Black	Excellent oil resistance, high adhesion, high joint movement, excellent in water/glycol	30 g/min**	-67°F to 392°F (-55°C to 200°C)	15
	743913	190 ml					
SI 5910™	231232	300 ml	Black	High joint movement, oil resistance, good on wide variety of plastics, glasses, ceramic, metals	500 g/min**	-67°F to 392°F (-55°C to 200°C)	40

*Note: To increase gap fill, use a primer
 **Different viscosity test used

A COSTLY 5% LEAKAGE RATE ELIMINATED



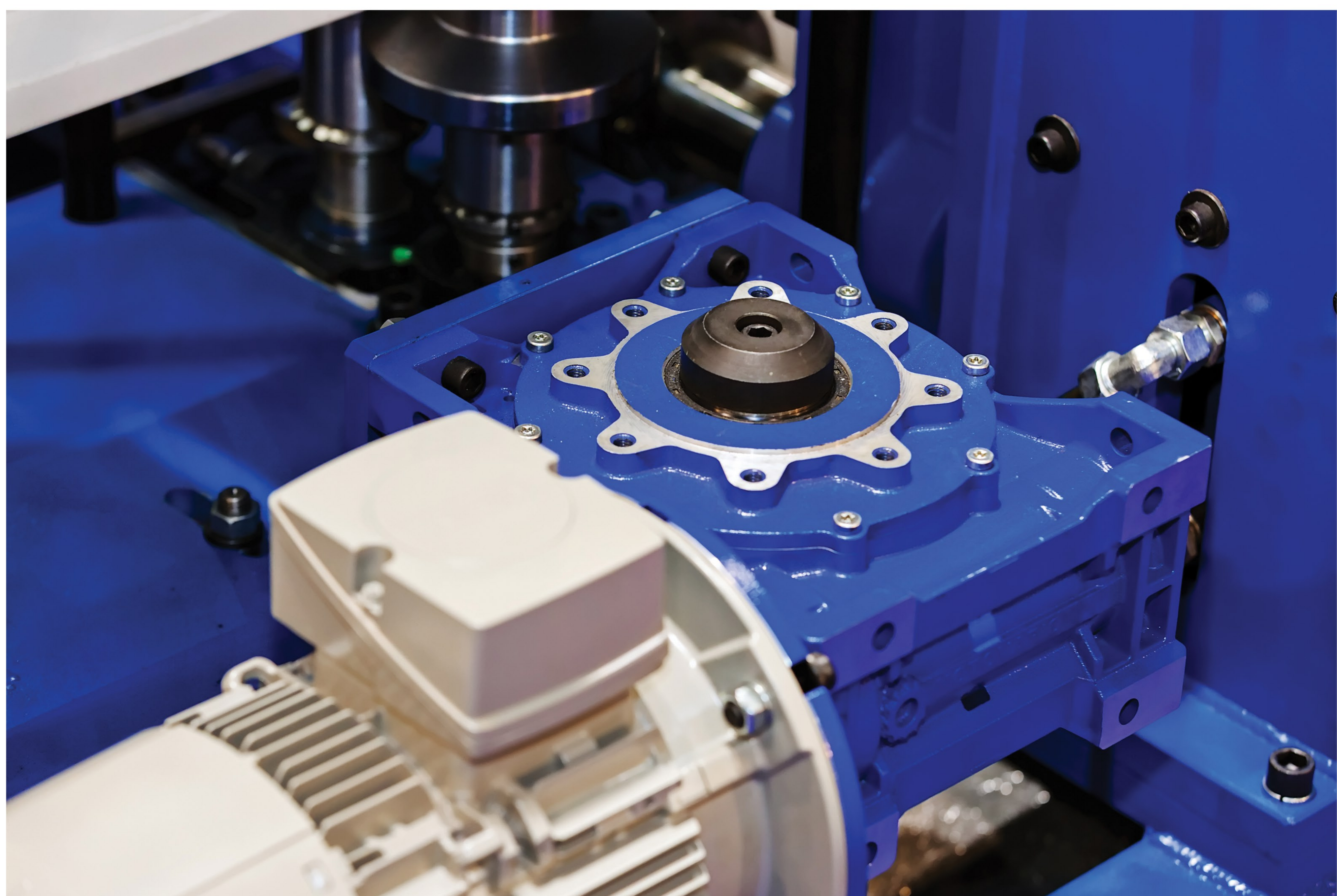
“A high leakage rate was causing warranty claims and production delays. LOCTITE®’s engineering solutions expert helped us completely eliminate the problem.”

A manufacturer of cast iron gear boxes and geared motors experienced a 5% leakage rate using a competitor’s liquid gasket on the adapter assembly flange. This was costly due to both leakage-related warranty claims on purchased units and testing and production delays caused by the slow cure rate. The competitive product also made it difficult to disassemble and repair the gearbox. **LOCTITE® 518™** gasket sealant was an ideal solution, offering a complete seal, quick curing, and easy disassembly. A LOCTITE® engineering solutions expert showed the plant’s team how to clean flange surfaces and dispense **LOCTITE® 518™** in a continuous bead. Immediately following assembly, **LOCTITE® 518™** fills the gaps between the flange surfaces and the products can be instantly pressure tested to 40 psi. Leaks have now been eliminated and disassembly is easier for customers.

Benefits

LOCTITE® 518™ Gasket Sealant:

- Seals more effectively, eliminating leakage during operation
- Sustains low pressure testing of 40 psi immediately upon assembly
- Easily disassembles with a small amount of cleavage force



LOCTITE®

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