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## Technical Data Sheet

# Permatex® Ultra Black® Gasket Maker

INDUSTRIAL

### PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex® Ultra Black® Gasket Maker is a single component, room temperature, vulcanizing, gasketing compound designed to provide reliable "formed-in-place" gaskets for mechanical assemblies. This material cures on exposure to moisture in the air to form a tough, flexible, silicone rubber gasket. The product resists aging, weathering and thermal cycling without hardening, shrinking or cracking. Designed to provide increased oil resistance and complies with extended warranty requirements.

### PRODUCT BENEFITS

- Improved oil resistance
- Sensor safe, non-corrosive
- Good adhesion and flexibility
- Replaces most cut gaskets
- Can be used as a gasket maker or dressing
- Non-flammable, Non-toxic
- Low odor

### TYPICAL APPLICATIONS

- Pump Housings
- Machine tools
- Compressors
- Gearboxes
- Valve covers
- Oil pans
- Transmission pans

### DIRECTIONS FOR USE

#### For assembly as a form-in-place gasket

1. Remove all previous material from mating surfaces. Permatex® Low VOC Gasket Remover can be used depending on the material
2. For best results, clean and dry all surfaces with a residue-free solvent, such as Permatex® Brake and Parts Cleaner
3. Cut nozzle to desired bead size, 1/16" to 1/4" in diameter. An 1/8" bead 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 silicone to one surface, first tracing the internal areas of the gasket configuration, then all surrounding bolt holes.

6. Assemble parts immediately while silicone is still wet. Secure or tighten to recommended torque specs.
7. Re-torque will not be necessary after the product has cured.

#### For assembly as a gasket dressing

1. Repeat steps 1 through 4 as in previous section.
2. Apply a thin film of silicone to one surface to be sealed.
3. Place the pre-cut gasket onto silicone film.
4. Apply a second thin film to pre-cut gasket surface.
5. Remove any excess and assemble parts immediately.

### For Cleanup

1. Allow excess material to extend beyond the extension nozzle or aerosol tip to cure, sealing and protecting 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. Remove the remaining material with Permatex® Silicone Stripper.
3. Clean hands with a dry cloth or Permatex® Fast Orange® Hand Cleaner.

### PROPERTIES OF UNCURED MATERIAL

Chemical Type	Typical Value
Appearance	Oxime silicone
Odor	Metallic Black
Specific Gravity	No acetic odor
Viscosity	1.26
Flash Point_C (_F)	Thixotropic paste
	>93 (>200)

### TYPICAL CURING PERFORMANCE

Permatex® Ultra Black® Gasket Maker cures on exposure to moisture in the air. The product dries tack free in two hours and fully cures in 24 hours. Cure times will vary with temperature, humidity and gap.

### PERFORMANCE OF CURED MATERIAL

After 7 days at 25°C (77°F), 50% Relative Humidity

	Typical Values
Hardness (Shore A)	42
Elongation, %*	360
Tensile Strength, N/mm <sup>2</sup> (psi)**	1.8 (260)

\*Material will stretch 3.5 times its original length before breaking.

\*\*Amount of force required to break material.

### TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance	Typical Values
Continuous, °C (°F)	-54 to 204 (-65 to 400)
Intermittent, °C (°F)	-54 to 260 (-65 to 500)

NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.  
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**Chemical / Solvent Resistance**

The product retains effective properties in contact with shop fluids, automotive fluids, such as motor oil, transmission fluids, alcohol and antifreeze solutions. Note: Not recommended for parts in contact with gasoline.

**GENERAL INFORMATION**

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

**ORDERING INFORMATION**

Part Number	Container Size
82180	3.35 oz. tube, carded
82080	8.75 oz. Automatic Tube®
85080	9.5 oz PowerBead™ can
24105	13 oz. cartridge

**STORAGE**

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

**NOTE**

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