

**EMERGENCY PHONE 1-800-255-3924**  
**TECHNICAL DATA SHEETS**  
**TORQUE GM 30**

**Description:**

**Torque GM 30** is an anaerobic curing adhesive for the gasketing and sealing of flanges. To replaces solid gaskets, gives flexible cured films. To seal against gases, water, LPG, hydrocarbons, oils and other chemicals. Thixotropic property prevents migration of the sealant before or during curing. Shocks and vibrations resistant are unaffected properties of sealing in the range of temperature from -55 to +180°C.

**Properties of Uncured Product:**

Composition	Methacrylate Ester
Appearance	Red Fluorescent Liquid
Specific Gravity (77°F/25°C g/ml)	1.13
Viscosity, Brookfield (77°F/25°C mPa.s)	
Spindle 2 - 5 rpm	650000 to 900,000 mPa.s
Flash Point, TCC	>93°C
Shelf life at 20°C	1 year
Storage temperature	8° - 28°C

**CURING PERFORMANCE**

**GM 10** is designed to be used and cured at room temperature. Where cured speed is unacceptably long, or large gaps are present, applying activator to the surface will reduce the curing within few minutes.

**HEAT CURE**

Typical heat cure conditions consist of heating and maintaining bondline at a temperature of 40°C and after one hour more than 80% of strength on steel is achieved.

**CURE SPEED VS. SUBSTRATE**

% Full strength	Steel	Aluminium
25	35min	35min
50	50min	3hrs
100	24-72hrs	

**CURE SPEED VS. JOINT GAP**

% Full strength	Gap 0,5mm
25	30min
50	1 hrs
100	6-72 hrs

**CURE SPEED VS. TEMPERATURE**

% Full strength	Temperature	
	5°C	40°C
25	1 hrs	20 min
50	2 hrs	25 min
100	24 - 72 hrs	6-72 hrs

**Properties of Cured Product:**

**Functional strength at 24 hrs 20° on steel**

Shear Strength (ASTM D1002)	5 to 13 N.m
Tensile Strength (DIN 53288)	4 to 14 N.m
Coefficient of thermal expansion (ASTM D696)	80 X 10 <sup>-6</sup> 1/K
Thermal conductivity (ASTM C177)	0.1 W/Mk
Specific heat	0.3 KJ.Kg <sup>-1</sup> K <sup>-1</sup>
Temperature range	-55°+150°C

**ENVIRONMENTAL RESISTANCE**

**Hot strength at temperature**

Test.Temp. °C	% retained strength
25°	100%
50°	85%
100°	45%
150°	30%

**Heat aging**

Samples aged 1000 hours at indicated temperature and tested at room temperature.

Test temp. °C	% retained strength
100°	250%
120°	210%
150°	130%

**Chemical / Solvent Resistance**

Specimens immersed for 1000 days at indicated temperature and tested at room temperature.

	Test Temp. ° C	% retained strength
50/50 Water / Glycol	87	90
Unleaded Gasoline	22	55
Motor Oil	125	140

**Engineering Excellence**

For technical information and support call **1-800-552-0299** or visit our website at

**[www.instantca.com](http://www.instantca.com)**