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## Technical Data Sheet

# Permatex® High-Temp Red RTV Silicone Gasket

INDUSTRIAL

### PRODUCT DESCRIPTION

**S.I.N.: 834-300**

Permatex® High-Temp RTV Silicone Gasket 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 maintain maximum performance in a continuous temperature environment of 600°F. Conforms to MIL-A-46106B, Type I. Permatex® High-Temp Red RTV Silicone shall meet the requirements of the F.D.A. 'Code of Federal Regulations 21 CFR' concerning food contact applications if use in accordance with its Section 177.2600: 'Rubber Articles Intended for Repeated Use'.

### PRODUCT BENEFITS

- High temperature use
- Superior adhesion and flexibility
- Replaces most cut gaskets
- Can be used as a gasket maker or dressing
- Easy application
- Non-flammable
- Non-toxic

### TYPICAL APPLICATIONS

- Sealing panels
- Window plates
- Oven doors
- Flues on high temperature applications

### DIRECTIONS FOR USE

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

1. Remove all previous material from mating surfaces. Permatex® Gasket Remover is recommended for most materials, not for plastics or painted surfaces.
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 as shown:
6. Assemble parts immediately while silicone is still wet.
7. Finger tighten flange only until material begins to seep out the sides of the flange.
8. Allow to set for at least two hours and re-torque at least one quarter to one half turn.

9. For best results, allow to cure overnight.

#### For assembly as a gasket dressing

1. Repeat steps 1 thru 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 to pre-cut gasket surface.
5. Remove any excess and assemble parts immediately.  
*Note: Product not recommended for use as a cylinder head gasket or head gasket sealant.*

#### Instructions for PowerBead™

1. Clean and dry all flange surfaces to be sealed.
2. Remove black cap from top of extension nozzle.
3. Turn nozzle extension one complete turn (360°) counterclockwise.
4. Depress finger trigger and apply a continuous 1/16 inch to 1/8 inch PowerBead™ to one surface.
5. Assemble parts immediately while silicone is still wet.
6. Finger tighten flange only until material begins to seep out the sides of the flange.
7. Allow to set for at least two hours and re-torque at least one quarter to one half turn.
8. For best results, allow to cure overnight.
9. To close, turn extension nozzle clockwise until tight (about one full turn). Wipe off excess material from nozzle and replace black cap.

#### Storage of Unused Product

1. Create a "Silicone Plug" by allowing 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. For PowerBead™ dispensers, you may store remaining product using either the above "silicone plug" method or using the included plastic cap.

#### For Cleanup

1. Remove uncured product from parts and hand-tools with Permatex® EnviroSafe® ODC Free Cleaner/Degreaser. If skinned over, break film with a dry cloth to remove as much as possible. Remove the remaining material with Permatex® Gasket Remover.
2. Clean hands with a dry cloth or Permatex® Fast Orange® hand cleaner.

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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**PROPERTIES OF UNCURED MATERIAL**

	<b>Typical Value</b>
Chemical Type	Acetoxy silicone rubber
Appearance	Red non-sag paste
Odor	Mild acetic
Specific Gravity	1.05
Extrusion rate @ 25_C, (grams/min)	>220
Flash Point_C (F)	>93 (>200)

**TYPICAL CURING PERFORMANCE**

Permatex® High-Temp RTV Silicone Gasket cures on exposure to moisture in the air. The product dries tack free in one hour and fully cures in 24 hours. Cure times will vary with temperature, humidity and gap. Note: The curing process can cause corrosion to some surfaces, for critical applications use the Ultra Series silicones.

**PERFORMANCE OF CURED MATERIAL**

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

	<b>Typical Values</b>	
Hardness (Shore A)	>20	
Elongation, %*	>350	
Tensile Strength, N/mm <sup>2</sup> (psi)**	>1.5	(>218)
Gap Fill, inch	0.25	

\*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 316	(-65 to 600)
Intermittent, °C (°F)	-54 to 343	(-65 to 650)

**Chemical / Solvent Resistance**

The product retains effective properties in contact with 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
81160 (26BR)	3 oz. tube, carded
81855 (26LA)	4.5 oz. Automatic Tube
81915	7.25 oz. Automatic Tube
81409 (26C)	11 oz. cartridge
85915	7.25 oz. PowerBead

**OEM INTERCHANGE**

Manufacture	OEM Specifications Numbers	
Caterpillar	8T9013	4C9614

**STORAGE**

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8\_ to 28\_C (46\_ 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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