



Scotch-Weld™ Anaerobic Gasket Maker GM10

Product Data Sheet

Updated :February 2010
Supersedes:April 2007

Product Description Scotch-Weld GM10 is a single component, low-medium strength, anaerobic gasketing compound. GM10 is a thixotropic product that is suitable for higher temperature applications. GM10 cures when confined in the absence of air between close-fitting flat metal surfaces.

Key Features Scotch-Weld GM10 is a `form-in-place` gasketing product designed for applications on rigid metal flanges and surfaces. GM10 is designed to withstand higher service temperatures than standard gasketing anaerobic products. GM10 develops low-medium strength. GM10 will give rapid low pressure seal (after 20mins) to allow on-line pressure testing.

Physical Properties

Chemical Type	Dimethacrylate
Appearance	Red Orange
Specific Gravity	1.15
Viscosity cPs (Brookfield RVT 'T'-Spindle D, 2.5rpm)	Range 250,000 – 600,000 Typical Value 425,000
Viscosity cPs (Brookfield RVT 'T'-Spindle D, 20rpm)	Range 40,000 – 80,000 Typical Value 60,000

Performance Characteristics

Maximum Gap Fill	0.50 mm
Fixture Time (ASTM D1002)	20 mins
Full Cure	24hrs
Strength Build Up	20 mins = 5% strength 3 hours = ~30% strength 24hours = 100% strength
Service Temperature Range	-50 to +200°C

Additional Product Information

Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.

GM10 is not recommended on certain plastics as stress cracking can sometimes result. Some anti-corrosion chemicals inhabit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary. Scotch-Weld AC64 Activator may be required on plated parts.

Application Techniques	Apply manually as a continuous bead or by screen printing to one surface. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint. Product is normally hand applied from the bottle. Dispensing systems are available for high volume assembly applications. Heating the assembled parts accelerates the curing process. AC64 Activator may be used to accelerate cure and should be used if the application temperature is below 5°C. The use of an accelerator may reduce the final bond strength by up to 30%
Storage Conditions	Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months. Refrigeration to 5°C gives optimum storage stability.
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C
Precautionary Information	Refer to product label and material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com
For Additional Information	To request additional information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA
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