



Scotch-Weld™ Anaerobic Gasket Maker GM74

Product Data Sheet

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Supersedes: September 2008

Product Description Scotch-Weld GM74 is a single component, low-medium strength, anaerobic anaerobic gasketing compound. GM74 is thixotropic product that cures quickly on steel surfaces. GM74 cures when confined in the absence of air between close-fitting metal surfaces.

Scotch-Weld GM74 is a `form-in-place` gasketing product designed for multi-purpose applications on rigid metal flanges and surfaces, e.g.gearbox casings, machinery covers, pump housings, compressor end caps, etc. GM74 cures quickly on steel surfaces and develops low-medium strength. GM74 will give rapid low pressure seal (after 20mins.) to allow on-line pressure testing.

Physical Properties

Chemical Type	Dimethacrylate
Appearance	Orange
Specific Gravity	1.11
Viscosity cPs (Brookfield RVT Spindle 6, 2.5rpm)	Range 50,000 – 150,000
Viscosity cPs (Brookfield RVT Spindle 6, 20rpm)	Range 20,000 – 40,000

Performance Characteristics

Maximum Gap Fill	0.35 mm
Fixture Time	20 mins
Full Cure	24hrs
Strength Build Up	20 mins = 5% strength 1 hours = ~30% strength 24hours = 100% strength
Service Temperature Range	-50 to +150°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.

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, please see below for contact details.
Important Note	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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