



PSI-636 RTV Silicone Gasket Maker

Product description

PSI-636 Silicone Gasket Maker is formulated to withstand continuous use at temperatures ranging from -80 to 400°F (-62 to 204°C) and intermittent use to 600°F (315°C). It exhibits excellent oil and ethylene glycol resistance. It is oxygen sensor safe, and non-corrosive to most metals. During cure the by-product is low odor.

Basic uses

PSI-636 can be used almost anywhere a cut gasket of paper, cork, etc., is used or to replace previously applied formed-in-place gaskets in areas with large gaps, such as valve covers, oil pans, transmission pans, cover plates, hose connections, timing case covers, oil pumps, thermostat housings, cam shaft rear covers, flanges, pushrod covers, etc.

Benefits

- Highly flexible over a wide temperature range.
- Non-corrosive.
- Excellent adhesion to metals.
- Oxygen sensor safe.
- Oil-resistant.

Application limitations

- Should not be applied in areas totally confined during cure as atmospheric moisture is required to trigger

curing mechanism.

- Should not be used where it will be in constant contact with gasoline, as swelling will occur.
- Should not be applied to an oily or greasy surface that has not been properly cleaned.
- Not for use between machined surfaces.
- Not for use in excessively hot applications, such as head and carburetor gaskets.
- May cause discoloration on copper or brass; testing prior to use is recommended.

Performance Data*

Properties	Results	Test Method
Uncured Properties - 70°F (21°C) & 50% RH		
Skin-Over Time	15 minutes	ASTM C679
Cure Time, 1/8" bead	12 hours	PSI S202
Sag/Slump	Nil	ASTM C639
VOC Content	0.4 lb/gal	
Specific Gravity	1.10	
Density	9.2 lb/gal	
Cured Properties - 14 days at 70°F (21°C) & 50% RH		
Hardness, Shore A	35	ASTM C661
Adhesion-in-Peel		
Steel, aluminum & glass	20 lb/in	ASTM C794
Adhesion - lapshear steel/steel	250 psi	
Tensile Strength, Die C	300 psi	ASTM D412
Ultimate Elongation, Die C	300%	ASTM D412
Tear, Die B	25 pli	
Coefficient of Thermal Expansion	270 x 10 ⁻⁶ per °C	
Linear Shrinkage	< 1%	
Corrosion to Steel or Aluminum	None	
Service Temperature, cured bead	-80 to 400°F (-62 to 204°C)	PSI S406
70 hrs. at 302°F (150°C), ASTM #3 Oil		
Tensile Change -20% / Elongation Change +15% / Volume Change +15%		
7 days at 212°F (100°C), 5W30 Oil		
Tensile Change -10% / Elongation Change -5% / Volume Swell +4%		
Hardness Change -40%		
7 days/392°F (200°C)		
Tensile Change -10% / Elongation Change +5% / Durometer Change -5%		
7 days, 50/50 Ethylene Glycol/Water		
Volume Swell 0%		
* Typical properties are for information only, not for purposes of specification.		

- Do not use excessive material as it may break off and travel to an undesirable place and cause engine failure.

Color

Custom colors available; minimum order 100 gallons.

Packaging

Available in 3 oz. (90 ml) squeeze tubes, 10.3 fl. oz. (305 ml) cartridges, 5 gal. pails and bulk 55 gallon drums (100 gallon minimum). Contact Customer Service for more information.

Installation

Surface preparation: Completely remove old gasket by using a gasket remover. Then remove all traces of grease or oil with a non-flammable, fast-evaporating cleaning fluid. Thoroughly dry the surface to be sealed. Apply a continuous bead about 1/16" to 1/8" wide onto the mating surface, encircling all bolt holes and studs. Assemble parts immediately.

Priming: PSI-636 adheres well to most metals without a primer. To obtain optimum adhesion to some plastics and metals, PSI-690 Primer is recommended.

Cleaning: Immediately remove all excess sealant and smears with mineral spirits. For equipment clean-up, use solvent equivalent to mineral spirits or toluol. See manufacturer's MSDS for handling and safety precautions.

Curing characteristics: Depending on humidity, temperature and thickness, the part can be put back into service in about 1 hour,

Shelf life: One year from date of shipment when stored in original, unopened container in a dry area at temperatures below 80°F (27°C).

Health precautions

- Use only with adequate ventilation.
- Keep away from heat and flame.
- Do not take internally. Call a physician if swallowed.
- Avoid eye and skin contact.
- Keep out of reach of children.

For additional health and safety information, consult a Material Safety Data Sheet.

Availability and cost

Polymeric Systems, Inc., is a part of Whitford Worldwide. For more information, please contact Polymeric Systems or Whitford Plastics Ltd. at:

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