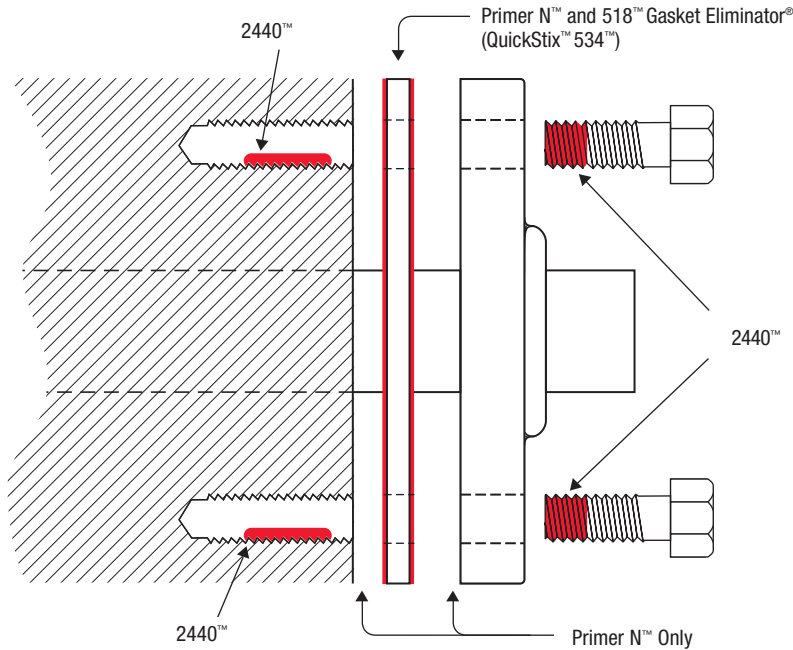


# GASKET DRESSING

# FORM-IN-PLACE SILICONES

## SEALED FLANGES



1. Remove old gasketing material and other heavy contaminants with Loctite® Chisel® Gasket Remover. Use mechanical removal technique if required.

**Note:** Avoid grinding.

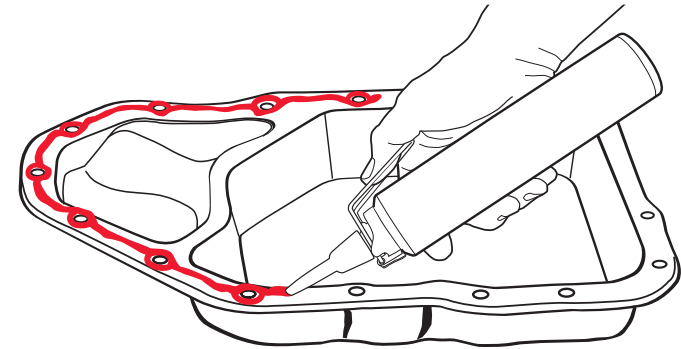
2. Clean both flanges with Loctite® ODC-Free Cleaner & Degreaser.
3. Spray Loctite® 7649™ Primer N™ on both flange faces and both sides of the precut gasket. Allow 1-2 minutes to dry.
4. Smear Loctite® Gasket Eliminator® Flange Sealant to both sides of precut gasket with a clean applicator.
5. Place coated gasket on flange surface and assemble parts immediately.

**Note:** • If cover bolts into blind holes (as above), apply Loctite® 2440™ Threadlocker into hole and on threads. Tighten normally.

- If it is a through bolt assembly, apply Loctite® 2440™ Threadlocker or Loctite® QuickStix™ 248™ Threadlocker to bolt threads.

6. Tighten normally.

## STAMPED OR SHEET METAL FLANGES



1. Remove old gasketing material and other heavy contaminants with Loctite® Chisel® Gasket Remover.
2. Clean both flanges with Loctite® ODC-Free Cleaner & Degreaser.
3. Apply a continuous bead of Loctite® Instant Gasket or Loctite® high performance silicones to sealing surface. Circle all bolt holes.  
**Note:** • Use proper bead diameter to seal flange width and depth.  
• Minimize excessive material “squeeze in”.
4. Assemble within 10 minutes by pressing together. Tighten as required.
5. Clean up any excess or squeeze out.
6. Cure times will vary with temperature, humidity, and gap. Typical full cure time is 24 hours.

	Loctite® Instant Gasket*	Loctite® 587™ Blue
COLOR	Black	Blue
VISCOSITY, cP	Paste	Paste
GAP FILL	¼"	¼"
CURE METHOD	Moisture/Oxime	Moisture/Oxime
CURE SPEED		
Tack-Free	30 minutes	30 minutes
Full Cure	24 hours	24 hours
SERVICE TEMP. RANGE		
Intermittent	-75°F to 500°F -59°F to 260°C	-75°F to 500°F -59°F to 260°C

\*Loctite® Instant Gasket provides a low pressure instant seal (100 psi at zero gap).