



SEALANT, SILICONE RUBBER, ACETOXY CURED, LOW VISCOSITY	WSE-M4G323-A1
SEALANT, SILICONE RUBBER, ACETOXY CURED, MEDIUM VISCOSITY	WSE-M4G323-A2
SEALANT, SILICONE RUBBER, ACETOXY CURED, HIGH VISCOSITY	WSE-M4G323-A3
SEALANT, SILICONE RUBBER, OXIME CURED, LOW VISCOSITY	WSE-M4G323-A4
SEALANT, SILICONE RUBBER, OXIME CURED, HIGH VISCOSITY	WSE-M4G323-A5
SEALANT, SILICONE RUBBER, OXIME CURED, VERY HIGH VISCOSITY	WSE-M4G323-A6
SEALANT, SILICONE RUBBER, OXIME CURED, VERY HIGH VISCOSITY	WSS-M4G323-A7
SEALANT, SILICONE RUBBER, OXIME CURED, HIGH VISCOSITY	WSS-M4G323-A8

1. SCOPE

The material defined by these specifications is an one component thixotropic spreadable silicone rubber based adhesive/sealant. It is capable of being pumped, metered and distributed into a gasket profile. These materials are ready for use as received, requiring no catalyst or heat cure.

2. APPLICATION

These specifications were released originally for materials used for formed-in-place gaskets such as engine oil pan, rocker cover, cylinder block or oil pump, where high operating temperatures (up to 204 °C) may be encountered.

WSE-M4G323-

- A1 Low viscosity, low modulus acetox cured material with medium assembly time and very good adhesion and joint movement on clean and oiled panels of steel to aluminum and aluminum to aluminum.
- A2 Medium viscosity, medium modulus acetox cured material with good blowout resistance, medium assembly time, good oil and coolant resistance.

Date	Action	Revisions
2006 06 12	Revised	Para 3.0 inserted; para 3.1, 3.2, 3.3, 3.17, 3.18 and 4 deleted Para 3.7, 3.10 and 3.13 revised; Corrected numbering 3.12 A. Reaume
1998 05 12	Activated	Add -A8, Rev. para 2, 3, Title, Add. para 5.1 T. Kopp
1991 11 05	NEO1E101	Released E. J. Duda



- A3 High viscosity, high modulus acetoxycured material with excellent blowout resistance, short assembly time, good high temperature resistance with excellent adhesion and joint movement on clean and oiled aluminum to aluminum.
- A4 Low viscosity, low modulus oxime cured material with no blowout resistance and long assembly time and good adhesion between steel to aluminum and aluminum to aluminum on clean and oiled panels. This material has very poor resistance to coolant/water and must not be used for these applications.
- A5 Very high viscosity, low modulus oxime cured material with very good blowout resistance and long assembly time, good oil resistance and excellent joint movement on clean and oiled steel to aluminum and aluminum to aluminum panels. This material has very poor resistance to coolant/water and must not be used for these applications.
- A6 Very high viscosity, medium modulus, oxime cured material with excellent blowout resistance and long assembly time, good oil resistance and excellent adhesion and joint movement on oiled steel and aluminum panels. This material has very poor resistance to coolant/water and must not be used for these applications.
- A7 Very high viscosity, medium modulus, oxime cured material with excellent blowout resistance and very long assembly time, good oil resistance and excellent adhesion and joint movement on oiled steel and aluminum panels. This material has very poor resistance to coolant/water and must not be used for these applications.
- A8 High viscosity, high modulus, oxime cured material with very good blowout resistance and low assembly time, dependable oil resistance, good adhesion and joint movement on oiled steel and aluminum panels. This material has good resistance to coolant/water and is suitable for use in automatic transmissions.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.4 SPECIFIC GRAVITY (ASTM D 792, Method A)

A1	A2	A3	A4	A5	A6	A7	A8
1.04- 1.09	1.06- 1.10	1.06- 1.10	1.30- 1.37	1.28- 1.35	1.30- 1.37	1.30- 1.37	1.44- 1.49

WSE-M4G323-A1/A6
WSS-M4G323-A7/A8**3.5 EXTRUSION RATE, s**

A1	A2	A3	A4	A5	A6	A7	A8
40- 150	200- 390	320- 900	30- 150	700- 1700	1400- 2400	1400- 2600	500- 1600

Test Method: Time to dispense 50 cc through a stainless steel nozzle with a 3.2 +/- 0.13 mm orifice and 50 +/- 0.13 mm in length at 448 kPa pressure using a #250 Semco gun and 170 g PE cartridge assembly. Start the test by dispensing 10 g and then timing the next 50 cc. To convert from g to cc, multiply by specific gravity.

3.6 BLOW RESISTANCE, s, min

(FLTM BV 126-01, 14 kPa pressure, cured for 30 minutes at 23 +/- 2 °C, 50% R.H., 1 mm and 1.5 mm gap, 4.0 mm flange)

Gap, 1 mm

15	120	300	0	100	100	110	80
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Gap, 1.5 mm

10	20	300	0	60	100	110	20
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Take 60 s to assemble and test 30 minutes after assembly.

3.7 CURE RATE (Assembly Time), minutes, range

(FLTM BV 127-02 or FLTM BV 125-01, max time at which both surfaces have a continuous strip of sealant at 50 +/- 5% relative humidity and 23 +/- 2 °C)

5 – 18	5 – 10	2 – 14	12 – 30	5 – 20	7 – 24	120 – 300	5 - 20
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3.8 TOTAL SILICONE VOLATILES, max

(FLTM AV 102-01, cured 24 h at 23 +/- 2 °C and 50 +/- 5% R.H.)

0.6	0.6	0.6	0.6	0.6	0.6	0.6	0.6
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