



ENGINEERING STANDARDS

Material Specification

LIMITED USE
HN1823

Sealer - Anerobic

Do Not Use on New Programs; No Replacement

1. SCOPE

This standard describes a single component, gel-like anerobic material intended for use in place of preformed and precut gaskets. The material solidifies by polymerisation into a tough plastic when confined between closely fitted metal surfaces, producing an effective seal against leakage

2. GENERAL

The material shall be capable of sealing gaps up to 1.25mm with Primer N and 0.25mm without Primer N shall not migrate or drip when used on vertical surfaces.

3. PROPERTIES

3.1	Resin Type	Polyacrylate
3.2	Colour	Red
3.3	Specific Gravity	1.085
3.4	Shelf Life at 25° C	12 months minimum
3.5	Temperature range Continuous Operation	-57° C to 150°C
3.6	Viscosity at 22° C (Brookfield Viscometer 5 RPM)	400 – 1200 CPS
3.7	Cure Speed	With Primer N – 15min to 2 hours Without Primer N – 1-12 Hours

4 APPROVAL, INSPECTION AND REJECTION

Refer HN 1000, Clauses A, C and G(Line Trial).

5. HAZARDOUS MATERIALS

Refer HN 1000, Clause H.

6. RESTRICTED CHEMICALS

Refer HN 1000, Clause J.

7. APPROVED SUPPLIERS AND MATERIALS

APPROVED SUPPLIER	APPROVED MATERIAL
Loctite Corporation	Loctite 518

8. REFERENCES

HN 1000

9 Release and Revisions

This standard was originated in January 1985. It was first published in January 1985.

Issue	Publication Date	Description (Organization)
1	JAN 1985	Initial publication.
2	NOV 1998	- Approved Material Loctite 518 replaces Loctite 514. - References section added.
3	NOV 2002	- HN 1823 was made INACTIVE.
4	APR 2004	- HN 1823 was made ACTIVE. - Inclusion of reference to HN 1000, Clause C in section 4(APPROVED SUPPLIERS AND MATERIALS).
5	FEB 2016	Limited for Current Use. (Materials)