

GA-74

INSTANT, HIGH VISCOSITY, ANAEROBIC GASKETING ADHESIVE

TECHNICAL DATA SHEET

JUNE 2021



PRODUCT DESCRIPTION

Bostik Born2Bond™ Gasketing anaerobic adhesives are a single-component, cost effective alternative to conventional pre-formed gaskets on metal flanges. Flexible, durable and resistant to wear and tear, they can be used during installation or for preventative maintenance. Achieving 100% surface-to-surface contact, the adhesives create a cohesive, durable connection that can withstand vibration, extreme temperatures and exposure to oils, solvents and water. They also offer better stress distribution and, unlike traditional gaskets, do not require any 'bedding-in'.

GA-74 is an instant anaerobic gasketing material with high viscosity and medium strength. It is recommended for use on rigid iron, steel and aluminum flanges. Once cured the product prevents leakage and/or loosening of parts from vibration and shock.

For more information, please consult <https://born2bond.bostik.com>

KEY FEATURES

- Medium strength
- High viscosity
- Fluorescent
- Instant low pressure seal
- Outstanding fatigue strength
- Vibration resistant
- Corrosion prevention
- Prevents sagging and micro-movement
- Higher power transmission
- Single component
- Suitable for active and passive metals
- High pressure seal - 350bar

DIRECTIONS FOR USE

1. For best results, clean all surfaces (internal and external) with Born2Bond™ Pre-Bonding Cleaner and wait until fully evaporated.
2. The product is designed for close fitting flanged parts with gaps up to 0.25 mm.
3. Apply manually as a continuous bead or by screen-printing to one surface of the flanges.
4. If the cure speed is too slow, use Born2Bond™ Anaerobic Activator.

5. Tighten flanges after application.
6. Cured product can be removed by using of Born2Bond™ Gasket&Adhesive Remover and a soft scraper.
7. Finish the cleaning process with a Born2Bond™ Pre-bonding Cleaner soaked soft cloth.

METHOD OF USE

Manual: Directly from the bottle with or without dispensing tips for more precise dispensing.

Semi-Automated: Use of pressure-time systems for accurate volume and larger series.

Full-Automated: fully automated robot or application lines.

APPLICATIONS

- Engines and powertrains
- Pumps and compressors
- Storage of liquids and gas
- Gearboxes and transmissions

STORAGE/SHELF LIFE

Store product in the unopened container in a dry area out of direct sunlight. Storage below 7°C or greater than 28°C can adversely affect product performance. If stored properly, this product has a shelf life of 24 months.

HEALTH/SAFETY

The Safety Data Sheet is available on the Bostik website and should be consulted for proper handling, cleanup and spill containment before use. Keep containers covered to minimize contamination.

LIMITATIONS

This product is not recommended for use in pure oxygen and/or oxygen-rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Material removed from containers may be contaminated during use. Do not return product to the original container. Bostik will not assume responsibility for product that has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or customer service representative.

PRODUCT CHARACTERISTICS

Basis Technology	Acrylic
Components	1K
Appearance / Color	Orange
Cure	Anaerobic
Temperature use Range	-55°C to 150°C

UNCURED PHYSICAL PROPERTIES

Viscosity [Brookfield: Sp7 @20rpm @25°C]:	30.000 - 50.000 mPa.s
Specific Gravity ASTM D1475 - 13(2020)	1.10

CURING PROPERTIES

The table below shows the curing properties of the product on mild steel according to ISO 10964

Fixture time @ 20°C	15-30min
Fixture time with Activator* @ 20°C	<10min
Full Cure @20°C	24h

*Bostik Born2Bond Anaerobic Activator

BONDING PERFORMANCE

The performance data reported below were measured according to ISO 4857 after curing for one week at 22°C (71.6°F).

Shear strength [ISO 4587 - mild steel]	>5-8.5 N/mm ²
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CONVERSIONS

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{kV/mm} \times 25.4 = \text{V/mil}$$

$$\text{mm} / 25.4 = \text{in}$$

$$\mu\text{m} / 25.4 = \text{mil}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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