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## Technical Data Sheet

### Permatex® the Right Stuff™ Grey

AAM Revised 10/07

#### PRODUCT DESCRIPTION

PERMATEX® The Right Stuff™ Grey is a single component, room temperature curing, elastomeric gasketing compound designed to provide reliable “formed-in-place” gaskets for mechanical assemblies. The Right Stuff™ Grey has been specifically designed to perform under higher torque loads of engines with high bolt densities, typically import vehicles. This product has a high blowout resistance, allowing leakproof gaskets to be made and placed into service immediately after reassembly. Permatex® Right Stuff™ Grey is sensor safe and seals instantly forming reliable, long lasting elastomeric rubber gaskets that outperform precut gaskets. OEM specified by Nissan, Honda, Mazda and Kia.

#### PRODUCT BENEFITS

- Immediate sealability
- Instant blow-out resistance
- Import OEM Approved and Specified
- Replaces most cut gaskets
- Low odor
- Resistant to ATF/oil/coolant
- Consistent sealing
- Sensor safe

#### TYPICAL APPLICATIONS

- Timing gear covers
- Transmission pans
- Valve covers
- Oil pans
- Water pumps
- Gearboxes
- Intake manifold end seals
- Stamped sheet metal covers
- Compressors
- Gearboxes

#### PROPERTIES OF UNCURED MATERIAL

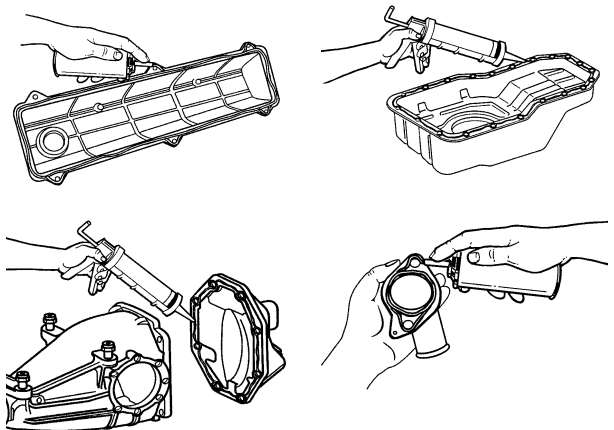
|                         | Typical Value      |
|-------------------------|--------------------|
| Chemical Type           | Elastomeric Rubber |
| Appearance              | Metallic Grey      |
| Specific Gravity @ 20°C | 1.45               |
| Viscosity               | Thixotropic Paste  |
| Flash Point (TCC), °F   | >200               |

#### DIRECTIONS FOR USE

##### For assembly as form-in-place gasket

1. Remove all previous material from mating surfaces. Permatex® Gasket Remover is recommended for most materials (not for plastics or painted surfaces).
2. For best results, clean and dry all surfaces with a residue-free solvent, such as Permatex® Brake and Parts Cleaner.

3. Cut nozzle to desired bead size, 1/16” to 1/4” in diameter. An 1/8” bead is usually sufficient for most applications.
4. Remove cap, puncture tube or cartridge seal and attach extension nozzle.
5. Apply a continuous and even bead of The Right Stuff™ Grey to one surface, first tracing the internal areas of the gasket configuration, then all surrounding bolt holes as shown below:



6. Assemble parts within 5 minutes while The Right Stuff™ Grey is still wet. Secure or tighten to recommended torque specs.
7. Re-torque will not be necessary after the product has cured.

##### For PowerBead

1. Clean and dry all flange surfaces to be sealed.
2. Remove black cap from top of extension nozzle.
3. Turn nozzle extension one complete turn (360°) counterclockwise.
4. Depress finger trigger and apply a continuous 1/16 inch to 1/8-inch PowerBead™ to one surface.
5. Assemble parts within 5 minutes while The Right Stuff™ Grey is still wet. Secure or tighten to recommended torque specs.
6. Parts or vehicle may be placed back into service immediately.
7. Re-torque will not be necessary after the product has cured.
8. To close, turn extension nozzle clockwise until tight (about one full turn). Wipe off excess material from nozzle and replace black cap.

##### For Cleanup

1. Allow excess material to extend beyond the extension nozzle or aerosol tip to cure, sealing and protecting the remaining product from moisture. For reuse, simply remove the cured product from the tip.

NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.  
PERMATEX, INC., HARTFORD SQUARE NORTH, 10 COLUMBUS BOULEVARD, HARTFORD, CT 06106 PHONE – (1-877)PERMATEX)

2. Remove uncured product from parts and hand-tools with a dry cloth, if skinned over, break film with a dry cloth to remove as much as possible, and remove the remaining material with Permatex® Gasket Remover as previously stated.
3. Clean hands with a dry cloth or Permatex® Fast Orange® hand cleaner.

**TYPICAL CURING PERFORMANCE**

**Cure Time**

The surface of this adhesive becomes dry to touch on exposure to atmospheric moisture within 5 minutes at 23± 2°C, 50 ± 5% RH. The product cures on exposure to moisture in the air and dries tack free in two hours, with full cure in 24 hours. Cure times will vary with temperature, humidity and gap.

**Instant Seal**

Parts assembled with Permatex® The Right Stuff™ Grey are instantly sealed and can be immediately placed into service.

**TYPICAL PROPERTIES OF CURED MATERIAL**

|   | <b>Typical Value</b> |
|---|----------------------|
| Hardness, Shore A, ASTM D2240                   | 60                   |
| Elongation at break, %, ASTM D412               | 175                  |
| Tensile strength, N/mm <sup>2</sup> , ASTM D412 | 3.4 min              |

**TYPICAL ENVIRONMENTAL RESISTANCE**

| <b>Temperature Resistance</b> | <b>Typical Values</b> |              |
|-------------------------------|-----------------------|--------------|
| Continuous, °C (°F)           | -60 to 232            | (-75 to 450) |
| Intermittent, °C (°F)         | -60 to 260            | (-75 to 500) |

**Chemical / Solvent Resistance**

The product retains effective properties in contact with automotive fluids, such as motor oil, transmission fluids, alcohol and antifreeze solutions. Note: Not recommended for parts in contact with gasoline.

**GENERAL INFORMATION**

**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.**

**For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).**

**ORDERING INFORMATION**

| <b>Part Number</b> | <b>Container Size</b>        |
|--------------------|------------------------------|
| 34311              | 5 oz. cartridge              |
| 34310              | 10.1 oz. cartridge           |
| 85144              | 7.5 oz. PowerBead            |
| 25238              | 3 oz. automatic tube, carded |

**STORAGE**

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C and 28°C (46°F and 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range.

**DATA RANGES**

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

**NOTE**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. **Permatex, Inc. specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Permatex, Inc. products and disclaims any liability for consequential or incidental damages of any kind, including lost profits.**

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