

860

MOLDABLE POLYMER GASKETING

APPLICATION AREAS

- Gear Boxes
- Bearing Housings
- Fittings Including Thread Fittings
 - Electrical Boxes
 - Turbine Casings
 - Vacuum Systems
 - Transmissions



PRODUCT DATA SHEET

KEY FEATURES AND BENEFITS

- Never sticks to surfaces
- Remains elastic, no aging
- Forms ultra-thin gasket
- Can withstand higher pressures
- Fills gaps up to 6 mm (1/4") deep
- NSF P1 Registration number 134017, 134018
- Economical; costs less than compressed sheet gasket

PACKAGING

Kit
Toolbox Kit

DIRECTIONS

Use 2 mm (1/16") bead for 25mm (1") wide flange, 3 mm (1/8") bead for 50 mm (2") wide flange. Use larger beads for rough flanges. Flanges: Remove old gasketing material and clean surfaces to be sealed. Apply Chesterton 860 MPG to one flange face. Make a continuous bead around inside of bolt holes and flange irregularities. Spray 860 Curing Agent on opposite mating flange. Spray 860 Curing Agent on the surface of 860 Polymer. Assemble equipment immediately after spraying curing agent on polymer. Thread Fittings: Clean threads thoroughly. Apply 860 across male threads and spread evenly. Spray 860 Curing Agent on female threads. Spray 860 Curing Agent over polymer on male threads. Assemble fitting immediately.

DESCRIPTION

Chesterton® 860 Moldable Polymer Gasketing is a solid flexible gasketing material which fills in surface irregularities, stops leaks and never sticks to surfaces after curing. It is the one product to use to handle almost every gasketing application. 860 MPG is easily formed into simple or complex shapes, eliminating the necessity to inventory pre-cut gaskets or sheets of gasketing. Waste, often 50% with conventional gasket sheeting material, is eliminated with this unique polymeric material. Using MPG, gaskets as thin as 0,13 mm (5 mil) can be formed. This gives the best fit between flanges and provides far superior pressure and chemical resistance. Because it forms a very quick seal, 860 MPG will hold up to 1 kg/cm² (15 psi) as soon as equipment is assembled and up to 7 kg/cm² (100 psi) in minutes. It can be used in applications ranging in temperature from -51°C to 260°C (-60°F to 500°F). Disassembly of equipment is always easy when sealed with a gasket made of 860 Moldable Polymer Gasketing. It will never bond mating surfaces together nor stick to the surface to which it is applied. After disassembly, just peel the gasket off. No scraping is ever necessary. Cured 860 Moldable Polymer Gasketing conforms to paragraphs 175.300 and 177.2600 of 21 CFR of the FDA (United States Food & Drug Administration) and meets NSF requirements for incidental food contact.

Information continues on page 2

860

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TYPICAL PHYSICAL PROPERTIES

Cure Time	Gel Time 3-4hrs (Full cure 24 hrs)
Hydraulic Pressure (Max)	211 kg/cm ² (3,000 psi)
Steam Pressure at 170°C (338°F)	6,8 kg/cm ² (100 psi)
Coverage per 400 grams 3 mm (1/8 inch) bead 6 mm (1/4 inch) bead	3289 linear cm (108 linear feet) 822 linear cm (27 linear feet)
Temperature Limit (continuous)	-51°C (-60°F) to + 260°C (+500°F)
Temperature Limit (intermittent)	to +320°C (600°F)
Chemical Resistance	See chart below
Tensile Strength at 25°C (77°F)	25 kg/cm ² (360 psi)
Elongation, % at yield	180%
Linear Shrinkage - 3 days at 25°C (77°F)	0.4 - 0.6%
Hardness, Shore A	50
Volume Resistivity 25°C (77°F) ohm/cm	2.0 x 10 ¹⁵
Dielectric Constant 25°C (77°F) 1 KHz	4
Dissipation Factor 25°C (77°F) 1 KHz	0.027
Dielectric Strength volts/mil	500

Before using this product, please refer to Safety Data Sheet (SDS).

Chemical Resistance	Resistance	Temperature °C	Temperature °F
Acetone	Resistant	25	77
Benzene	Fair	25	77
Ethyl Alcohol	Resistant	25	77
Gasoline	Poor	25	77
Hydrochloric Acid, 36%	Resistant	25	77
Mineral Oil	Resistant Fair	25 121	77 250
Nitric Acid, 10%	Resistant	25	77
Nitric Acid, 70%	Fair	25	77
Phosphoric Acid, 30%	Resistant	25	77
Perchloroethylene	Resistant	25	77
Potassium Hydroxide-Concentrated	Fair	149	300
Sodium Hydroxide, 15%	Resistant	25	77
Steam to 7 kg/cm ² (100 psi)	Resistant	170	338
Sulfuric Acid, 10%	Resistant	25	77
Sulfuric Acid, 95%	Poor	25	77
Toluene	Fair	25	77
Xylene	Fair	25	77

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