

# Professional Grade Gasket Maker

### TYPICAL PROPERTIES

Flow/Slump	NIL
Extrusion Rate (1/8" orifice, 90 psi)	335 g/min.
<b>Cure Characteristics - exposed to air, 77°F (25°C) and 50% RH</b>	
Skin-over time	6 min.
Tack-free time	15 min.
Cure time (1/8" thickness)	24 hrs.
<b>As Cured - after 72 hours at 77°F (25°C) and 50% RH</b>	
Durometer, Shore A	32 points
Tensile Strength	350 psi
Elongation	500%
Unprimed adhesion (most substrates*)	Good
Service Temperature	-85°F to 400°F
Application Temperature	-35°F to 140°F

### DESCRIPTION

**BOSS® 323** Hi-Temp Blue Gasket Maker is a one-part, non-slumping paste that cures to a tough, rubbery solid at room temperature on exposure to vapor in the air. This silicone was formulated to perform at temperatures ranging from -85°F to 400°F (-65°C to 204°C).

\*Optimum adhesion is obtained in 7 to 10 days curing time.

### HOW TO USE

#### Applying the Material: Tack-Free Time

**BOSS® 323** Hi-Temp Blue Gasket Maker is supplied ready-to-use. Under pressure it flows readily from its container. The paste-like consistency makes it easy to work; a spatula or wooden paddle can be used for tooling the surface. The cure progresses inward from the surface. At conditions of at least 77°F (25°C) and 50% relative humidity, the sealant forms a tack-free skin within 20 minutes. Tooling is not practical after this skin begins forming and should be completed within 5 to 10 minutes of application, even though this may require alternate periods of applying and tooling. Likewise, if masking tape has been used to mark off the area, it should be removed before the tack-free skin forms.

**Cure Time:** Cure time is affected by relative humidity, degree of confinement and cross-sectional thickness of the sealant. Sections up to 1/8" thick become rubbery solids in about 24 hours at room temperature and 50 percent relative humidity. Less moisture content reduces it slightly. In applications where **BOSS® 323** may be partly or totally confined during cure, the time required for proper cure is generally lengthened by the degree of confinement. Metal-to-metal bonds should not overlap more than one inch. Every application involving confinement during cure should be thoroughly tested before commercialization. The odor given off during cure is due to the liberation of acetic acid. This odor disappears as the cure progresses, and is not detectable after the cure is complete.

#### Bonding

1. Thoroughly clean and degrease metal and plastic surfaces, then rinse all surfaces, except plastic, with acetone. Rubber surfaces should be roughened with sandpaper, then wiped with acetone. Follow the precautions given on solvent container label.

2. Apply **BOSS® 323** to the prepared surface in a uniform thickness. Best adhesion is obtained with a 15 to 30 mil glue line. In those cases where the adhesive is used between surfaces, put the second surface in place, using enough pressure to displace the air but not the adhesive.

Continued...



### APPLICATIONS

- Valve covers
- Transmission pans
- Oil pump flanges
- Intermittent use to 550°F
- Insulates thermally
- Insulates electrically
- Waterproof seal
- Weatherproof seal
- Forms an even bead
- Oxygen sensor safe
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# BOSS® PRO

3. Let the unit stand undisturbed at room temperature to cure.

**Sealing:** Using BOSS® 323 Hi-Temp Blue Gasket Maker in sealing applications follows approximately the same step-by-step procedures outlined for bonding applications. After preparing the surface and priming where required, the sealant is applied by forcing it in the joint or seam to obtain full contact between sealant and surfaces.

## SPECIFICATIONS

- TT-S-001543A
- TT-S-00230C
- ASTM C-920 Type S, Grade NS, Class 25, Use G, A, M, O

## CLEAN UP

Uncured sealant can be easily removed using BOSS® 335 or a solvent such as alcohol or acetone. For an environmental and health friendlier choice use BOSS® 893 Biggie Wipes. If the sealant is cured it must be removed mechanically by cutting and scraping.

## SHIPPING LIMITATIONS

None.

Reactive VOC 23 g/l (<3% wt.)

## CAUTION

DIRECT CONTACT OF UNCURED SEALANT IRRITATES EYES AND MAY IRRITATE SKIN. OVEREXPOSURE TO VAPOR MAY IRRITATE EYES, NOSE, AND THROAT. Avoid eye and skin contact. Use only outdoors or in a well ventilated area. Do not handle contact lenses with sealant on hands. IN CASE OF EYE CONTACT, flush eyes with water for 15 minutes. Obtain medical attention. IN CASE OF SKIN CONTACT, remove from skin and flush with water. Sealant releases acetic acid (vinegar-like odor) during cure. KEEP OUT OF THE REACH OF CHILDREN. For safe handling information on this product, consult the Safety Data Sheet (SDS).

## STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), BOSS® 323 Hi-Temp Blue Gasket Maker has a shelf life of 12 months from date of shipment. In countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity. Cartons should always be stacked upright with the nozzle tip pointed upwards. DO NOT stack cartons on their side. **NEVER** stack cartons more than 8 high. DO NOT store within 1 meter (4 feet) of roofline of the warehouse or storage building.

## USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

## TECHNICAL DATA SHEET

### COLORS

- Blue

### PACKAGING

- 8 oz. Pressure Can
- Other sizes available upon request

**Limited Warranty:** Buyer assumes all risks of use, handling and storage of product not in strict accordance with label directions. Liability for any incidental or consequential damage or loss is specifically excluded at all times. Any implied warranty of merchantability or fitness for particular use is excluded. Seller will not accept liability for more than product replacement.

**Soudal Accumetric**

MADE IN U.S.A.

350 Ring Road  
Elizabethtown, KY 42701  
800-928-BOSS(2677)  
270-769-3385  
FAX 270-765-2412  
[www.bossproducts.com](http://www.bossproducts.com)

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