

# ThreeBond 1184

## Liquid Gasket

ThreeBond **1184** is a one component liquid gasket developed for sealing applications by preventing leakage of oils, water and gases under pressure at joining surfaces, it provides excellent resistance to contact fluids, shock and vibration. By maintaining its functionality over a wide range of temperatures and for an extended period of time it can improve the performance of equipment, extend the functional life and reduce the total cost.

### 1. Features

- Synthetic rubber based resin
- One component solvent base resin
- Semi-drying type
- Service temperature : -40 / +150°C
- Thread and flange sealing

### 2. Properties

#### Before curing

Test	Results	Units
Colour	Grey	-
Viscosity at 25°C	9.5	Pa.s
Specific gravity at 25°C	1.26	-
Residue after heating	57.5	%
Tack free time	12	min

#### After curing

Test	Results	Units
Hardness	23	Shore A
Lap shear strength	0.17	MPa
Elongation	1720	%

#### Influence of 1184 on rubber

Rubber kind	Mass change	Units
NR	+ 38	wt %
CR	+ 45	
SBR	+ 55	
NBR	+ 44	
EPDM	+ 67	

Immersion in 1184 for 24h at 25°C

#### Pressure resistance

Conditions	Results	Units
At room temperature	10.0	MPa
At 80°C	8.5	
At 150°C	8.5	
After -40°Cx2h + 100°Cx3h	10.0	

#### Shear strengths

Conditions	Results	Units
Fe / Fe at 25°C	1.9	MPa
Fe / Fe after 5h at 130°C	3.3	
Al / Al at 25°C	0.2	
Al / Al after 5h at 130°C	2.7	

#### Chemical resistance

Tests were conducted in accordance with specifications JIS-K-6820. A glass pane with a recess filled with a layer of sealant was left at room temperature for 24 hours and then dried at 100°C for 3 hours. Then parts were immersed in chemicals for 24h and after dried at 65°C for 24h before measuring the mass change at room temperature.

Chemicals	Mass change (%)	Immersion temperature
Water	- 1.9	90 to 95°C
Salt water	- 2.1	
Antifreeze	- 1.9	
10% H <sub>2</sub> SO <sub>4</sub>	- 1.6	25°C
10% NaOH	- 2.0	
10% KOH	- 1.4	
Lubricant Oil n°1	- 4.5	95 to 100°C
Lubricant Oil n°2	- 3.6	
Lubricant Oil n°3	+ 0.9	
Engine Oil	- 1.6	
Turbine Oil	- 3.8	
Gasoline	- 2.8	45 to 50°C
Fuel oil B	- 3.1	
Kerosene	- 1.3	

### 3. Handling

- Before use, please refer to the safety data sheet.
- Flammable product. Do not expose to heat source.
- Prior to opening the container, let it reach room temperature to avoid condensation inside.
- To obtain optimal results, remove humidity, grease and other impurities from the surfaces to be assembled.
- Depending on the materials (dimensions and surface roughness), apply an appropriate and uniform amount of liquid gasket on the surface, then assemble rapidly.
- The product once transferred into another container should not be returned to the original one. Any excess product should be wiped out using a cloth.
- Keep the product in its original container, tightly sealed and store it in a dark, dry and well ventilated place at **-5 ~ 40°C**.

Data given here were compiled to the best of our knowledge and are based on experiments and tests of our Company. We cannot guarantee the results obtained through the use of our products, and all products are sold and samples given without any warranty, expressed or implied, of fitness for any particular purpose or otherwise and upon condition that the user shall make his own tests to determine the suitability of the product for his purpose.