



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 pre-cut 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

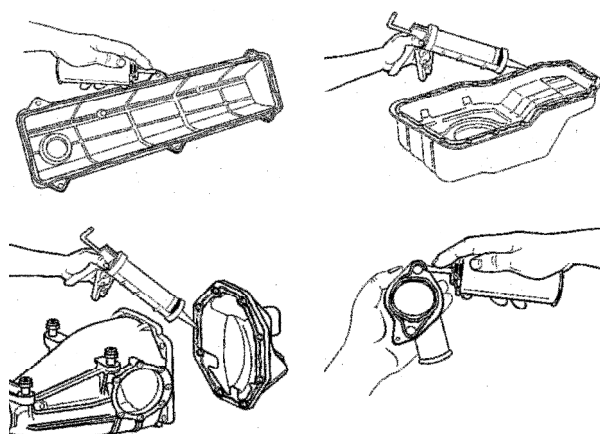
	Typical Value
Chemical Type	Elastomeric Rubber
Appearance	Metallic Grey
Specific Gravity @ 20°C	1.45
Viscosity	Thixotropic Paste
Flash Point (TCC), °F	>200

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.
- 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.
 - 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

	Typical Value
Hardness, Shore A, ASTM D2240	60
Elongation at break, %, ASTM D412	175
Tensile strength, N/mm ² , ASTM D412	3.4 min

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance	Typical Values	
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

Part Number	Container Size
34311	5 oz. cartridge
34310	10.1 oz. cartridge
81544	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

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