Loctite HL135275

Loctite 5699 High Performance RTV Silicone Gasket Maker Instruction Manual

Model: HL135275

1. Product Overview

The Loctite 5699 High Performance RTV Silicone Gasket Maker is engineered for flange sealing applications. This grey silicone formulation is resistant to water and glycol, making it suitable for use on flexible flanges, machined or cast surfaces, and various materials including metal and plastic. It offers high oil resistance and becomes tack-free within 10 minutes of application, facilitating efficient assembly.

Key Features:

- Water and Glycol Resistant
- High Oil Resistance
- Tack-Free within 10 Minutes
- Suitable for Flexible Flanges, Machined, and Cast Surfaces
- High Flexibility and Vibration Resistance
- Non-Corrosive



Image 1: Loctite 5699 High Performance RTV Silicone Gasket Maker, showing product in retail packaging.

2. Safety Information

Always prioritize safety when handling chemical products. Read and understand the product label and Safety Data Sheet (SDS) before use.

Precautions:

- **Ventilation:** Use in a well-ventilated area to avoid inhalation of vapors.
- **Skin Contact:** Avoid contact with skin. Wear protective gloves. In case of contact, wash thoroughly with soap and water.
- **Eye Contact:** Avoid contact with eyes. Wear eye protection. In case of contact, flush eyes immediately with plenty of water for at least 15 minutes and seek medical attention.
- **Ingestion:** Do not ingest. If swallowed, do not induce vomiting. Seek medical attention immediately.
- **Storage:** Keep container tightly closed when not in use. Store in a cool, dry place, away from direct sunlight and sources of ignition. Keep out of reach of children.

- **Disposal:** Dispose of contents and container in accordance with local, regional, national, and international regulations.

3. Preparation

Required Materials:

- Loctite 5699 Gasket Maker
- Surface cleaner/degreaser (e.g., brake cleaner, acetone)
- Clean, lint-free rags
- Scraper or wire brush for old gasket removal
- Protective gloves and eye protection

Surface Preparation:

1. **Clean Surfaces:** Ensure all mating surfaces are clean, dry, and free from oil, grease, old gasket material, and other contaminants. Use a suitable cleaner/degreaser and clean rags.
2. **Remove Old Gasket:** Carefully scrape off any remnants of old gasket material. Ensure surfaces are smooth and even.
3. **Dry Thoroughly:** Allow surfaces to dry completely before applying the gasket maker.

4. Application Instructions

1. **Prepare Tube:** Cut the nozzle to the desired bead size, typically 1/16 to 1/4 inch (1.5 to 6 mm) in diameter, depending on the application.
2. **Apply Bead:** Apply a continuous, even bead of Loctite 5699 to one of the mating surfaces. Ensure the bead encircles all bolt holes.
3. **Assemble Parts:** Immediately assemble the parts while the gasket maker is still wet. The product is tack-free within 10 minutes, so assembly should occur within this timeframe for optimal performance.
4. **Tighten Bolts:** Hand-tighten the bolts until the material begins to squeeze out. Allow the gasket maker to cure for approximately 1 hour before re-tightening to the manufacturer's specified torque.
5. **Full Cure:** For best results and to ensure maximum strength and resistance, allow the assembly to cure for 24 hours before exposing it to full operational conditions or fluids.

5. Curing and Performance

Loctite 5699 is designed for rapid tack-free performance and robust sealing capabilities.

- **Tack-Free Time:** Approximately 10 minutes. This is the time within which parts should be assembled after application.
- **Full Cure Time:** Typically 24 hours. Full strength and resistance to fluids are achieved after complete curing.
- **Performance:** Once cured, the gasket maker forms a flexible, durable seal with excellent resistance to oil, water, and glycol, and high tolerance to vibration.

6. Storage and Maintenance

Storage:

- Store the product in its original, unopened container in a cool, dry location.
- Ideal storage temperature is between 8°C to 28°C (46°F to 82°F).
- Do not freeze.

Maintenance:

- Clean any excess uncured material from tools and surfaces immediately with a suitable solvent. Cured material may require mechanical removal.
- Ensure the cap is securely replaced on the tube after each use to prevent premature curing of the remaining product.

7. Troubleshooting

If you encounter issues during or after application, consider the following common problems and solutions:

- **Issue: Leaks after assembly.**
  Possible Causes: Improper surface preparation (e.g., oil residue, old gasket material), insufficient amount of gasket maker, assembly outside of tack-free time, insufficient cure time before exposure to fluids.
  Solution: Disassemble, thoroughly re-clean and dry surfaces, apply a continuous and adequate bead, assemble within 10 minutes, and allow full 24-hour cure before operating.
- **Issue: Gasket material not curing properly.**
  Possible Causes: Lack of atmospheric moisture (RTV silicones cure with moisture), contamination on surfaces, expired product.
  Solution: Ensure application in an area with normal humidity, verify surfaces are completely clean, check product expiry date.
- **Issue: Difficulty removing cured gasket.**
  Solution: Cured silicone may require mechanical removal using a scraper or specialized gasket remover products.

8. Product Specifications

Specification	Detail
Item Model Number	HL135275
National Stock Number	8030-01-508-9181
Manufacturer	Loctite
Date First Available	September 29, 2004
Specific Uses For Product	Industrial, Automotive, Mechanical
Material	Silicone
Item Form	Paste
Special Feature	High oil resistance, flexibility, and high vibration resistance
Country Of Origin	United States
Item Package Weight	0.298 lb
Item Package Dimension	6.0" L x 3.0" W x 1.0" H

9. Warranty and Support

For specific warranty information regarding the Loctite 5699 High Performance RTV Silicone Gasket Maker, please refer to the

official Loctite website or contact Loctite customer support directly.

You can find more information and support on the official Loctite Brand Store.

Ask a question about this manual

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the question and use this page's manual context to help answer it.

Name

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Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question