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Permatex 25228

Permatex The Right Stuff 90 Minute Black Gasket Maker Instruction Manual

Model: 25228

PRODUCT OVERVIEW

Permatex The Right Stuff 90 Minute Black Gasket Maker is a superior silicone product designed to outperform conventional pre-cut gaskets. It offers a strong and fast high-flex silicone seal with excellent durability, allowing for a record return to service time of just 90 minutes.

- **Strong and Fast Seal:** Cures in just 90 minutes for quick return to service.
- **Replaces Precut Gaskets:** Formulated to create custom, durable gaskets.
- **Blowout Resistant:** Provides a reliable seal under demanding conditions.
- **High Flexibility & Oil Resistance:** Ideal for applications exposed to oil and vibration.
- **Sensor Safe RTV Silicone:** Safe for use with automotive sensors.
- **Ideal Applications:** Valve Covers, Intake Manifolds, Coolant Flanges, Oil Pans, Timing Covers, Heavy-Duty Truck and Fleet.
- **Convenient Packaging:** Includes an additional application nozzle for multiple use convenience.



Image: Front packaging of Permatex The Right Stuff 90 Minute Black Gasket Maker.

SAFETY INFORMATION

CAUTION: MAY IRRITATE EYES. MAY IRRITATE SKIN. Do not get in eyes. Do not get on skin or clothing. Do not breathe fumes. Keep out of reach of children.

FIRST AID TREATMENT: Contains polydimethylsiloxane, calcium carbonate. If swallowed, call a Poison Control Centre or doctor immediately. Do not induce vomiting. If in eyes, rinse with water for 15 minutes. If on skin, rinse well with water.

NOTE: Not recommended for use on head gaskets or parts in contact with gasoline.

Permatex® The Right Stuff® Black 90 Minute Gasket Maker

Formador de Juntas en 90 Minutos de Alta Flexibilidad

The Right Stuff® 90 minute is the only gasket maker in a tube that can return a vehicle back to service quickly. It outperforms pre-cut gaskets by providing superior adhesion to flanges with maximum flexibility. A premium professional grade gasket maker for today's fast-paced professional garage and heavy DIY'er. Temperature range -65°F to 500°F Intermittent.

Look for other Permatex® The Right Stuff® branded Gasket Makers that return vehicles to service in a matter of minutes.

DIRECTIONS:

1. For best results, surfaces should be clean and dry.
2. Cut nozzle and apply a continuous 1/16" to 1/4" (2 to 6mm) bead of silicone to one surface, surrounding all bolt holes. Assemble parts immediately while silicone is still wet. Finger tighten until material begins to squeeze out around flange.
3. Let dry for one hour then tighten to torque specifications.
4. Allow **90 minutes** before filling with fluids or returning to service.
5. Replace cap after use.

NOTE: Not recommended for use on head gaskets or parts in contact with gasoline.

The Right Stuff® 90 minutos es el único formador de juntas en un tubo que puede volver a poner un vehículo en servicio rápidamente. Supera a las juntas precortadas al proporcionar una adhesión superior a las pestañas con la máxima flexibilidad. Un sellador de juntas de primera calidad y grado profesional para el taller profesional de ritmo acelerado y el bricolaje intensivo de hoy en día. Rango de temperatura -65°F a 500°F Intermitente.

Busque otros formadores de juntas The Right Stuff® de Permatex® que devuelvan los vehículos al servicio en cuestión de minutos.

INSTRUCCIONES:

1. Para obtener mejores resultados, las superficies deben estar limpias y secas.
2. Corte la boquilla y aplique una línea continua de 1/16" a 1/4" (2 a 6mm) de silicona en una de las superficies, alrededor de los orificios de los pernos. Arme las piezas inmediatamente mientras la silicona está aún fresca. Apriete con la mano hasta que el material comience a salir por los bordes.
3. Deje secar durante una hora, luego apriete según las especificaciones.
4. Espere **90 minutos** antes de llenar con líquidos o de volver a ponerlo en servicio.
5. Tape el envase después de usar.

NOTA: No se recomienda el uso de este producto en juntas de culata o en piezas en contacto con gasolina.

WARNING / ATENCIÓN

Causes serious eye irritation / Provoca irritación ocular grave

May cause allergic skin reaction

Puede provocar una reacción alérgica en la piel

Suspected of causing cancer / Se sospecha que provoca cáncer



Precautionary Statements - Prevention: calcium carbonate, stearic acid, carbon black, 2-butanone oxime. Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Use personal protective equipment as required. Wash face, hands and any exposed skin thoroughly after handling. Avoid breathing dust/fume/gas/mist/vapors/spray. Contaminated work clothing should not be allowed out of the workplace. Wear protective gloves/protective clothing/eye protection/face protection. **Precautionary Statements - Response: IF IN EYES:** Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. If eye irritation persists: Get medical advice/attention. **IF ON SKIN:** Wash with plenty of soap and water. If skin irritation occurs: Get medical advice/attention. Wash contaminated clothing before reuse. **Precautionary Statements - Storage:** Store locked up. **Precautionary Statements - Disposal:** Dispose of contents/container to an approved waste disposal plant. **Keep out of the reach of children.** **Consejos de prudencia - Prevención:** carbonato de calcio, ácido estearico, negro de humo, butanone oxima. Pedir instrucciones especiales antes del uso. No manipular la sustancia antes de haber leído y comprendido todas las instrucciones de seguridad. Utilizar el equipo de protección individual obligatorio. Lavarse concienzudamente la cara, las manos y las áreas de la piel expuestas tras su manipulación. Evitar respirar el polvo/el humo/el gas/la niebla/los vapores/el aerosol. Las prendas de trabajo contaminadas no podran sacarse del lugar de trabajo. Llevar guantes/prendas/gafas/mascara de protección. **Consejos de prudencia - Respuesta: EN CASO DE CONTACTO CON LOS OJOS:** Aclarar cuidadosamente con agua durante varios minutos. Quitar las lentes de contacto, si lleva y resulta fácil. Seguir aclarando. Si persiste la irritación ocular: Consultar a un médico. **EN CASO DE CONTACTO CON LA PIEL:** Lavar con agua y jabón abundantes. En caso de irritación o erupción cutánea: Consultar a un médico. Lavar las prendas contaminadas antes de volver a usarlas. **Consejos de prudencia - Almacenamiento:** Guardar bajo llave. **Consejos de prudencia - Eliminación:** Eliminar el contenido/el recipiente en una planta de eliminación de residuos autorizada.

WARNING: Cancer - www.P65Warnings.ca.gov
ADVERTENCIA: Cáncer - www.P65Warnings.ca.gov

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Item# 25228 30-25228-2 Importador y Lote: Ver Envase



Image: Back packaging displaying safety warnings and usage directions.

SETUP AND APPLICATION

Proper preparation is crucial for optimal performance of the gasket maker.

1. **Surface Preparation:** For best results, ensure all surfaces are clean and dry. Remove any old gasket material, oil, grease, or debris.
2. **Application:** Cut the nozzle to the desired bead size. Apply a continuous bead of silicone, 2 to 6mm (1/16 to 1/4 inch) thick, to one surface, ensuring it surrounds all bolt holes.
3. **Assembly:** Immediately assemble parts while the silicone is still wet. Finger tighten the fasteners until the material begins to squeeze out around the flange.



Image: Close-up of the gasket maker being applied to a component.

OPERATING INSTRUCTIONS

Follow these steps for proper curing and optimal performance:

1. **Initial Cure:** Allow the gasket maker to dry for one hour then tighten to torque specifications.
2. **Full Cure:** Allow 24 hours for the gasket to fully cure before filling with fluids or returning the vehicle to service.

Video: [Official Permatex video demonstrating the features and application of The Right Stuff 90 Minute Black Gasket Maker.](#)

MAINTENANCE

To ensure the longevity of your Permatex Gasket Maker and future uses:

- **Storage:** Replace the cap tightly after each use to prevent the silicone from drying out. Store in a cool, dry place.
- **Nozzle Care:** If the nozzle becomes clogged, clear it with a thin wire or by cutting a fresh opening.

TROUBLESHOOTING

If you encounter issues with the gasket maker, consider the following:

- **Leakage after application:** Ensure surfaces were thoroughly clean and dry before application. Verify that the bead was continuous and surrounded all bolt holes. Allow sufficient cure time (24 hours) before exposing to fluids or stress.
- **Material not curing:** Check the product's expiration date. Ensure proper ventilation during application as moisture

from the air is necessary for curing.

- **Difficulty applying:** If the material is too thick, ensure it has been stored at room temperature. Warming the tube slightly (e.g., in warm water) can improve flow.

SPECIFICATIONS

Brand	Permatex
Model Number	25228
Product Dimensions	1.5 x 3.81 x 8 inches
Item Weight	3.68 ounces
Style	The Right Stuff 90 Min
Country of Origin	USA
Material (Tube)	Plastic

WARRANTY AND SUPPORT

For warranty information or technical support, please contact Permatex directly. Visit the official Permatex website or refer to the contact information provided on the product packaging for assistance.

Permatex is a leading manufacturer and distributor of premium chemical products to the automotive maintenance and repair, home and hardware markets. Product categories include gasket makers, sealants, hand cleaners, threadlockers, adhesives, cleaners, repair kits, and lubricants.

Official Permatex Website: www.permatex.com