

The Permabond range of anaerobic adhesives is formulated to provide superior performance benefits in applications with self-supporting or closely-mating metallic components such as retaining bearings, threadlocking, flange sealing, gasketing and sealing pipe work.

Benefit

- Liquid adhesive provides greater surface-to-surface contact than mechanical fasteners.
- Quick curing without air; accelerates assembly rates.
- Resistant to oils, solvents and other surface treatments.
- Available in permanent and removable formulations.
- Superior bond strength; often exceeds that of substrate material.
- Wide temperature range; from 55 to 150°C (-65 to 300°F)
- Gap fill capability from interference fits up to 0.5mm (0.02").
- Seals, bonds and locks with one product.



	Grade	Colour	Visc. mPa.s = cP	Maximum Gap Fill (mm) in	Set time, Steel mins	Shear Strength, Steel (N/mm ²) psi	Torque, M10 Steel nuts and bolts		Service Temp. (°C) °F
							Breakaway (N.m) in.lb	Prevail (N.m) in.lb	
Threadlockers	HH120	Red	7,000	(0.25) 0.01	10	(17) 2500	(31) 275	(34) 300	(-55 to 150) -65 to 300
	HH131	Red	2rpm: 23,000 20rpm: 7,500	(0.3) 0.012	15	(17) 2500	(27) 240	(54) 480	(-55 to 230) -65 to 445
	HL126	Green	10-30	(0.05) 0.001	15	(15) 2200	(14) 125	(34) 300	(-55 to 150) -65 to 300
	HM118	Red	1,800	(0.2) 0.008	10	(17) 2500	(23) 200	(32) 280	(-55 to 150) -65 to 300
	HM128	Red	500	(0.15) 0.006	15	(17) 2500	(31) 275	(40) 350	(-55 to 150) -65 to 300
	HM129	Red	500	(0.15) 0.006	10	(17) 2500	(33) 290	(58) 520	(-55 to 150) -65 to 300
	LM113	Purple	1,200	(0.15) 0.006	15	(5) 750	(9) 80	(5) 40	(-55 to 150) -65 to 300
	MM115	Blue	1,300	(0.15) 0.006	10	(10) 1450	(16) 140	(7) 60	(-55 to 150) -65 to 300
	MM115 Pure	Colorless	1,300	(0.15) 0.006	10	(10) 1450	(16) 140	(7) 60	(-55 to 150) -65 to 300
Retaining Compounds	HH040	Green	5,000	(0.25) 0.01	15	(14) 2000	(25) 220	(37) 330	(-55 to 150) -65 to 300
	HH040 Pure	Colorless	5,000	(0.25) 0.01	15	(14) 2000	(25) 220	(37) 330	(-55 to 150) -65 to 300
	HH167	Silver	2rpm: 500,000 20rpm: 90,000	(0.5) 0.02	15	(32) 4700	(32) 280	(45) 400	(-55 to 150) -65 to 300
	HL138	Green	225	(0.127) 0.005	10	(16) 2300	(20) 180	(36) 315	(-55 to 150) -65 to 300
	HM135	Green	700	(0.2) 0.008	5-10	(30) 4400	(31) 280	(50) 450	(-55 to 200) -65 to 390
	HM160	Green	600	(0.2) 0.008	15	(14) 2000	(30) 270	(50) 450	(-55 to 177) -65 to 350
	HM161	Green	2,000	(0.25) 0.01	10	(24) 3500	(31) 275	(45) 400	(-55 to 177) -65 to 350
	HM162	Green	1,000	(0.2) 0.008	5	(30) 4400	(32) 280	(57) 510	(-55 to 200) -65 to 390
	HM163	Green	3,500	(0.2) 0.08	5	(28) 4000	(30) 260	(55) 480	(-55 to 150) -65 to 300
HM165	Green	2rpm: 25,000 20rpm: 10,000	(0.3) 0.012	15-20	(20) 2900	(35) 310	(50) 450	(-55 to 230) -65 to 445	
Thread Sealers	LH050	White	250,000	(0.5) 0.02	120	(7) 1000	(4) 35	(3) 25	(-55 to 177) -65 to 350
	LH050 Pure	White	250,000	(0.5) 0.02	120	(7) 1000	(4) 35	(3) 25	(-55 to 177) -65 to 350
	LH051	White	2rpm: 450,000 20rpm: 20,000	(0.5) 0.02	120	(7) 1000	(4) 35	(3) 25	(-55 to 177) -65 to 350
	LH054	White	260,000	(0.5) 0.02	120	(7) 1000	(3) 25	(2) 20	(-55 to 177) -65 to 350
	LH150	White	260,000	(0.5) 0.02	120	(7) 1000	(6) 50	(3) 25	(-55 to 177) -65 to 350
	LM012	Brown	2,000	(0.2) 0.008	30	(5) 750	(3) 25	(2) 15	(-55 to 177) -65 to 350
	MH052	Yellow	2rpm: 65,000 20rpm: 25,000	(0.5) 0.02	15	(10) 1400	(20) 180	(11) 100	(-55 to 150) -65 to 300
Gasketmakers	HH190	Purple	300,000	(0.6) 0.025	15	(6) 900	(10) 90	(6) 50	(-55 to 121) -65 to 250
	LH197	Green	2rpm: 50,000 20rpm: 2500	(0.3) 0.012	20	(5) 750	(10) 90	(5) 45	(-55 to 150) -65 to 300
	MH196	Red	2rpm: 500,000 20rpm: 100,000	(0.5) 0.02	15	(10) 1450	(20) 175	(23) 200	(-55 to 200) -65 to 390
	MH199	Red	2rpm: 225,000 20rpm: 75,000	(0.5) 0.02	20	(8) 1100	(20) 175	(12) 100	(-55 to 200) -65 to 390
Activators	A905	Green	2	N/A	N/A	N/A	N/A	N/A	N/A
	ASC10	Green	2	N/A	N/A	N/A	N/A	N/A	N/A