

Permabond HH120 Anaerobic Threadlocker

Category : Polymer , Adhesive , Thermoset , Acrylic/Cyanoacrylate Adhesive

Material Notes:

Permabond® HH120 Threadlocker is an excellent general purpose threadlocker and sealant. It is used for locking bolts, nuts and screws that require permanent assembly. Its high viscosity allows for ease of use on coarse threaded fasteners. Cure is fast and reliable on steel, cadmium, zinc and other plated fasteners. Major use areas include machinery and equipment manufacturing. Additional uses include sealing pipe flanges and retaining worn bearings. Features & Benefits: Prevents vibration loosening Controlled off-torque Non-drip, thixotropic Full cure at room temperature Provides corrosion protection Superior environmental resistance Environmentally friendly – 100% solids Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-HH120-Anaerobic-Threadlocker.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	7000 cP @Temperature 25.0 °C	7000 cP @Temperature 77.0 °F	Uncured
Storage Temperature	5.00 - 25.0 °C	41.0 - 77.0 °F	

Mechanical Properties	Metric	English	Comments
Adhesive Bond Strength	17.0 MPa	2470 psi	steel collar and pin shear; ISO 10123

Thermal Properties	Metric	English	Comments
CTE, linear	90.0 µm/m-°C	50.0 µin/in-°F	
Thermal Conductivity	0.190 W/m-K	1.32 BTU-in/hr-ft²-°F	
Maximum Service Temperature, Air	149 °C	300 °F	
Minimum Service Temperature, Air	-53.9 °C	-65.0 °F	

Electrical Properties	Metric	English	Comments
Dielectric Strength	11.0 kV/mm	279 kV/in	

Processing Properties	Metric	English	Comments
Cure Time	4.98 min @Temperature 23.0 °C	0.0830 hour @Temperature 73.4 °F	Brass, handling strength
	10.2 min	0.170 hour	M10 steel, handling strength

Processing Properties	@Temperature 23.0 °C Metric	@Temperature 73.4 °F English	Comments
	15.0 min	0.250 hour	Brass, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	30.0 min	0.500 hour	Zinc, handling strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	30.0 min	0.500 hour	M10 steel, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	360 min	6.00 hour	Stainless steel, handling strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	1440 min	24.0 hour	Zinc, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	1440 min	24.0 hour	M10 steel, full strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	

Descriptive Properties	Value	Comments
Appearance	Red	Uncured
Maximum Gap Fill (mm)	0.25	
Maximum Thread Size	M30	
Strength Retention	50% at 150°C	Relative to 0°C
	80% at 100°C	Relative to 0°C
	93% at 50°C	Relative to 0°C
Torque Strength (N m)	31	M10 steel, break
	34	M10 steel, prevail
UV Fluorescence	Yes	Uncured

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