

Permabond HH131 High Temperature Threadlocker

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

Material Notes:

Permabond® HH131 is a very high temperature resistant, high strength anaerobic threadlocker and sealant. This material cures in the absence of air between tight fitting metal parts. It is used for locking bolts, nuts and screws that require permanent assembly. This material is best suited for applications requiring high temperature resistance. Features & Benefits: Vibration resistant Very high strength Excellent chemical resistance Lubricates threads for easier assembly High temperature resistance Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-HH131-High-Temperature-Threadlocker.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	7500 cP	7500 cP	at 20 rpm vibration
	@Temperature 25.0 °C	@Temperature 77.0 °F	
	23000 cP	23000 cP	at 2 rpm vibration
	@Temperature 25.0 °C	@Temperature 77.0 °F	
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	229 °C	445 °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	15.0 min	0.250 hour	M10 steel, handling strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	30.0 min	0.500 hour	

Processing Properties	Metric @ Temperature 23.0 °C	English @ Temperature 73.4 °F	Zinc handling strength Comments
	60.0 min @Temperature 23.0 °C	1.00 hour @Temperature 73.4 °F	Aluminum, handling strength
	180 min @Temperature 23.0 °C	3.00 hour @Temperature 73.4 °F	Zinc, working strength
	180 - 360 min @Temperature 23.0 °C	3.00 - 6.00 hour @Temperature 73.4 °F	M10 steel, working strength
	1440 min @Temperature 23.0 °C	24.0 hour @Temperature 73.4 °F	M10 steel, full strength
	4320 min @Temperature 23.0 °C	72.0 hour @Temperature 73.4 °F	Aluminum, working strength

Descriptive Properties	Value	Comments
Appearance	Red	Uncured
Maximum Gap Fill (mm)	0.3	
Maximum Thread Size	M56	
Strength Retention	20% at 250°C	Relative to 0°C
	60% at 200°C	Relative to 0°C
	87% at 150°C	Relative to 0°C
	93% at 100°C	Relative to 0°C
	98% at 50°C	Relative to 0°C
Torque Strength (N m)	27	M10 steel, break
	54	M10 steel, prevail
UV Fluorescence	No	Uncured

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