

Permabond HM118 Anaerobic Threadlocker

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

Material Notes:

Permabond® HM118 Threadlocker is an excellent general-purpose threadlocker and sealant. It is used for locking bolts, nuts and screws that require permanent assembly. Cure is fast and reliable on steel, cadmium, zinc and other plated fasteners. Major use areas include machinery and equipment manufacturing. Features & Benefits: Prevents vibration loosening High off-torque strength Full cure at room temperature Non-drip, thixotropic. Lubricates threads for easier assembly 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-HM118-Anaerobic-Threadlocker.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	1800 cP @Temperature 25.0 °C	1800 cP @Temperature 77.0 °F	at 20 rpm vibration
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 @Temperature 23.0 °C	0.170 hour @Temperature 73.4 °F	M10 steel, handling strength

Processing Properties	Metric 15.0 min	English 0.250 hour	Comments Zinc, handling strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	15.0 - 30.0 min	0.250 - 0.500 hour	M10 steel, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	30.0 min	0.500 hour	Brass, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	180 min	3.00 hour	Zinc, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	1440 min	24.0 hour	Zinc, full 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)	0.2	
Maximum Thread Size	M20	
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)	23	M10 steel, break
	32	M10 steel, prevail
UV Fluorescence	Yes	Uncured

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