

## Permabond HM128 Anaerobic Threadlocker

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

### Material Notes:

Permabond® HM128 Threadlocker is a high strength adhesive for permanent assembly. It is typically used for preventing vibration loosening of bolts, studs and cap screws. Full cure to a cross-linked plastic is achieved reliably and fast on steel and all common bolt platings. Additional application areas include machinery, equipment, and electric motor manufacturers. PERMABOND® HM128 Threadlocker replaces lock washers. Features & Benefits: Prevents vibration loosening Controlled off-torque Permanent threadlocking Full cure at room temperature 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-HM128-Anaerobic-Threadlocker.php](http://www.lookpolymers.com/polymer_Permabond-HM128-Anaerobic-Threadlocker.php)

| Physical Properties | Metric                         | English                        | Comments |
|---------------------|--------------------------------|--------------------------------|----------|
| Specific Gravity    | 1.10 g/cc                      | 1.10 g/cc                      | Uncured  |
| Viscosity           | 500 cP<br>@Temperature 25.0 °C | 500 cP<br>@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<br>@Temperature 23.0 °C | 0.0830 hour<br>@Temperature 73.4 °F | Brass, handling strength     |
|                       | 15.0 min                         | 0.250 hour                          | M10 steel, handling strength |

| Processing Properties | @Temperature 23.0 °C<br>Metric | @Temperature 73.4 °F<br>English | Comments                           |
|-----------------------|--------------------------------|---------------------------------|------------------------------------|
|                       | 30.0 min                       | 0.500 hour                      | Brass, working strength            |
|                       | @Temperature 23.0 °C           | @Temperature 73.4 °F            |                                    |
|                       | 60.0 min                       | 1.00 hour                       | Zinc, handling strength            |
|                       | @Temperature 23.0 °C           | @Temperature 73.4 °F            |                                    |
|                       | 60.0 - 180 min                 | 1.00 - 3.00 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                       | M10 steel, full strength           |
|                       | @Temperature 23.0 °C           | @Temperature 73.4 °F            |                                    |
|                       | 4320 min                       | 72.0 hour                       | Zinc, working strength             |
|                       | @Temperature 23.0 °C           | @Temperature 73.4 °F            |                                    |

| Descriptive Properties | Value        | Comments           |
|------------------------|--------------|--------------------|
| Appearance             | Red          | Uncured            |
| Maximum Gap Fill (mm)  | 0.15         |                    |
| 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)  | 31           | M10 steel, break   |
|                        | 40           | M10 steel, prevail |
| UV Fluorescence        | Yes          | Uncured            |

## Contact Songhan Plastic Technology Co.,Ltd.

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