

Permabond HM162 Anaerobic Retainer

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

Material Notes:

Permabond® HM162 is a medium viscosity retaining compound that cures when confined between metal parts to form an extremely tough bond. It is best suited for cylindrical parts and where high temperature resistance is required. In the uncured, liquid state, the adhesive wets the metal surfaces, keying into all surface irregularities and fills the space between the mated parts. Features & Benefits: Rapid cure Very high strength Improved fatigue life Excellent chemical resistance Excellent temperature resistance Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-HM162-Anaerobic-Retainer.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	1000 cP @Temperature 25.0 °C	1000 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	30.0 MPa	4350 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	199 °C	390 °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	M10 steel, handling strength
	4.98 min @Temperature 23.0 °C	0.0830 hour @Temperature 73.4 °F	Brass, handling strength
	7.02 min	0.117 hour	

Processing Properties	Metric @ Temperature 23.0 °C	English @ Temperature 73.4 °F	Zinc handling strength Comments
	15.0 min @Temperature 23.0 °C	0.250 hour @Temperature 73.4 °F	Brass, working strength
	30.0 min @Temperature 23.0 °C	0.500 hour @Temperature 73.4 °F	Stainless steel, handling strength
	60.0 - 180 min @Temperature 23.0 °C	1.00 - 3.00 hour @Temperature 73.4 °F	M10 steel, working strength
	180 min @Temperature 23.0 °C	3.00 hour @Temperature 73.4 °F	Zinc, working strength
	1440 min @Temperature 23.0 °C	24.0 hour @Temperature 73.4 °F	Stainless 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	Zinc, full strength

Descriptive Properties	Value	Comments
Appearance	Green	Uncured
Maximum Gap Fill (mm)	0.2	
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)	32	M10 steel, break
	57	M10 steel, prevail
UV Fluorescence	Yes	Uncured

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