

Quick Reference Guide

	Product	Visc. @ 25°C cP	Max. Gap		Torque M10 Steel Nuts & Bolts				Service Temp.
			in	mm	Breakaway		Prevail		
					lb•in	N•m	lb•in	N•m	Max. °F (°C)
Threadlockers	LM113 Removable, small fasteners	1200	0.006	0.15	80	9	40	5	300 (150)
	MM115 General purpose, removable	1300	0.006	0.15	140	16	60	7	300 (150)
	MM115 Pure NSF/ANSI 61 certified	1300	0.006	0.15	140	16	60	7	300 (150)
	HL126 Wicking grade for post assembly	12	0.005	0.13	125	14	300	34	300 (150)
	HM129 Permanent	500	0.006	0.15	280	32	500	56	300 (150)
	HH131 Permanent, High temp.	10,000	0.012	0.3	240	27	480	54	445 (230)
	LH050 General purpose	250,000	0.020	0.51	35	4	25	3	350 (177)
Pipe Sealants	LH050 Pure NSF 61 approved	250,000	0.020	0.51	35	4	25	3	350 (177)
	MH052 For coarse threads	50,000	0.020	0.51	180	20	100	11	300 (150)
	LM012 Hydraulic sealing	2000	0.008	0.2	25	3	15	2	350 (177)
Retaining Compounds	Product	Visc. @ 25°C cP	Max. Gap		Shear Strength (Steel 25°C)		Service Temp.		
			in	mm	psi	N/mm²	Max. °F (°C)		
	HH040 General purpose	5,000	0.010	0.25	2,000	14	300 (150)		
	HL138 General purpose, press fit	150	0.005	0.13	2,300	16	300 (150)		
	HM162 Fast curing, high temp. resist.	800	0.008	0.2	4,300	30	390 (200)		
Gasketmakers®	HM165 Max. gap fill, high temp. resist.	10,000	0.012	0.3	3,800	26	445 (230)		
	MH196 Fast curing, high temp. resist.	150,000	0.020	0.51	1,500	10	390 (200)		
	LH197 Medium strength, flexible	37,000	0.012	0.3	750	5	300 (150)		
	MH199 Easy dispense, high temp. resist.	185,000	0.020	0.51	1,100	8	390 (200)		
	HH190 General Purpose	600,000	0.025	0.63	900	6	250 (120)		

	Product	Visc. Mixed @ 25°C cP	Shear Strength Steel		Working Strength	Service Temp. Max °F (°C)
			psi	N/mm²		
Two Part Epoxies	ET500 Very fast, - clear, colorless	12,000	2,000	14	5 mins	175 (80)
	ET505 Tough, multipurpose, - amber	20,000	3,000	21	3 hours	175 (80)
	ET510 Rapid cure, high peel, - amber	25,000	1,750	12	20 mins	175 (80)
	ET515 Clear, flexible, - light amber	20,000	1,750	12	20 mins	175 (80)
	ET538 Toughened, thixotropic, - grey	195,000	2900	20	4 hour	175 (80)
	ET540 Tough, thixotropic, high temp. resist., - amber	300,000	2500	18	2 hours	240 (120)
Single Part Epoxies	ES550 No sag - Grey	1,500,000	6000	41	15 mins*	355 (180)
	ES558 Free flowing - Grey	200,000	6000	41	20 mins*	355 (180)
	ES562 Free flowing - White	20,000	5000	35	15 mins*	355 (180)
	ES569 No sag - Black	375,000	6000	41	20 mins*	355 (180)
	ES578 Thermal conductor, Electrical insulator - Black	700,000	6000	41	15 mins*	355 (180)

* Cure time at 180°C 355°F

	Product	Visc. @ 25°C cP	Shear Strength Steel		Handling Time	Service Temp. Max °F (°C)
			psi	N/mm²		
Surface Activated	TA435 & Initiator 41 Ideal for thermal cycling	90,000	3,600	25	2-20 mins depending on gap	250 (120)
	TA436 & Initiator 43 Ideal for motor magnet bonding	17,000	3600	25	1 -3 mins	300 (150)
	TA437 (Initiator 41) Single component, high temp. resist.	120,000	3000	20	3 - 5 mins (30-45 secs with Initiator 41)	390 (200)
	TA439 & Initiator 41 Non- corrosive	1000	1700	12	10-20 secs	390 (200)
	TA459 & Initiator 43 Non- corrosive	20,000	3,600	25	1 -3 mins	390 (200)
	TA440 A+B Rapid bonding of metal, ceramic, glass, wood and rigid plastic	10,000 (mixed)	3,600	25	<30 secs	250 (120)
1 : 1 MMA	TA4810 For plastics, metals & un-primed metal	95,000	4500	31	10 - 15 mins	250 (120)
	TA4820 As TA4810 with longer handling time	95,000	4500	31	30 - 35 mins	250 (120)

Quick Reference Guide

Product	Color	Visc. @ 25° C cP	Tensile Strength		Elongation	Shore D Hardness
			psi	N/mm ²		
UV610 High strength glass to metal bonding	Translucent	900	2,500	17	95%	70
UV620 General purpose, glass bonding, optically clear	Clear/Colorless	2,500	2,300	16	75%	62
UV625 Non-drip gel for glass & metal	Clear/Colorless	Gel	2,400	16.5	40%	65
UV630 Low viscosity, plastic bonding	Clear/Colorless	250	2,000	14	110%	60
UV632 Low viscosity, plastic bonding, excellent adhesion to acrylic.	Clear/Colorless	250	1,900	13	170%	60
UV640 Plastic bonding	Clear/Colorless	3,500	1,900	13	110%	60
UV648 Medium viscosity, plastic bonding, excellent adhesion to acrylic.	Clear/Colorless	Gel	1,600	11	150%	60
UV670 Flexible when cured	Clear/Colorless	2,500	1,700	12	85%	58
UV7141 Dual UV & anaerobic curing for bonding ceramic, mirrors, glass & metal	Clear/Slight yellow	1500	3,000	20	-	-

Product	Description
POP	Surface treatment for polyolefin (PE, PP), PTFE and silicone.
CSA NF	Non-flammable, cyanoacrylate accelerator speeds cure and provides surface cure for applications like wire tacking. Allows the use of cyanoacrylates on porous substrates such as wood, ceramic and fabric.
QFS16	Cyanoacrylate accelerator speeds cure and provides surface cure for applications like wire tacking. Allows the use of cyanoacrylates on porous substrates such as wood, ceramic and fabric.
ASC10	Anaerobic accelerator to speed cure, provide cure on inactive substrates and poorly mated parts.
Initiators	Initiator 41, & 43 are sold with surface activated structural acrylics.

Product	Visc. @ 25°C cP	Max. Gap Fill		Set Time (secs) Steel	Service Temp. Max °F (°C)
		in.	mm		
101 Low viscosity	2	0.002	0.05	5	180 (82)
102 General purpose	80	0.006	0.15	10	180 (82)
108 Intermediate gap fill	500	0.008	0.2	10	180 (82)
268 Fast curing, maximum gap fill	1,800	0.017	0.43	10	180 (82)
731 Impact resistant, clear	150	0.006	0.15	30	250 (120)
735 Impact resistant, black	250	0.006	0.15	30	250 (120)
737 Impact resistant, black, gap fill	3,000	0.02	0.51	15	250 (120)
791 Fast curing, low viscosity	40	0.004	0.1	3	180 (82)
792 Fast curing, low viscosity	80	0.006	0.15	3	180 (82)
801 High temperature resistant to 130°C	35	0.003	0.08	10	270 (130)
802 High temperature resistant to 160°C	100	0.006	0.15	10	320 (160)
820 High temperature resistant to 200°C	100	0.006	0.15	10	390 (200)
910 General purpose, metal bonding	80	0.006	0.15	10	195 (90)
920 Resists 250°C with post heat cure	80	0.006	0.15	10	482 (250)
940 Low odor, low bloom, very low viscosity	7	0.002	0.05	10	180 (82)
941 Low odor, low bloom, low viscosity	30	0.003	0.08	10	180 (82)
943 Low odor, low bloom, med.viscosity	100	0.006	0.15	10	180 (82)
947 Low odor, low bloom, gap fill	1,200	0.01	0.25	25	180 (82)
2011 Thixotropic gel, very fast	Gel	0.02	0.51	10	180 (82)

UV Curable

Cyanoacrylate

Other Products

Permabond Worldwide
Wherever your manufacturing or R&D site may be located, Permabond representatives can be called upon to assist you. We have an extensive network of professional distributors worldwide.



- Americas +1 732 868 1372
• US Helpline 800-640-7599
info.americas@permabond.com
- Asia + 86 21 5773 4913
info.asia@permabond.com
- Europe +44 (0) 1962 711661
info.europe@permabond.com