

Features & Benefits

- 💧 Vibration resistant
- 💧 Very high strength
- 💧 Excellent chemical resistance
- 💧 Lubricates threads for easier assembly
- 💧 High temperature resistance

Approvals

DVGW Approval for Gas /
 KTW-BWGL Drinking Water Compliant

Description

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.

Typical Physical Properties of Uncured Adhesive

Chemical composition	Acrylic
Appearance	Red
Viscosity @ 25°C	2rpm: 23,000 mPa.s (cP) 20rpm: 7,500 mPa.s (cP)
Specific Gravity	1.1
UV fluorescence	No

Typical Curing Properties

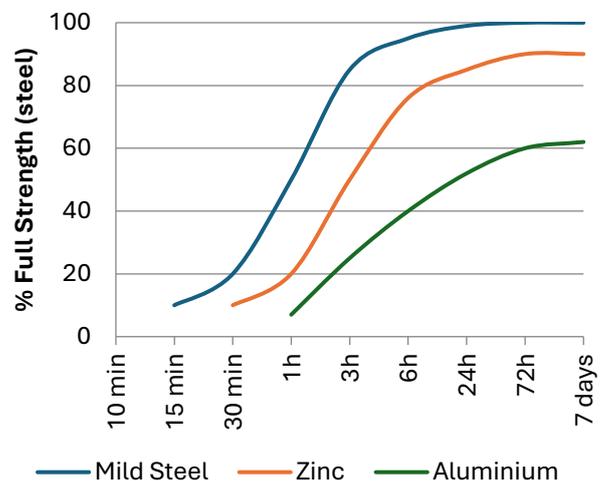
Maximum gap fill	0.3 mm 0.012 in
Maximum thread size	M56 2 in
Time taken to reach handling strength (M10 steel) @23°C*	15 minutes
Time taken to reach working strength (M10 steel) @23°C	3-6 hours
Full strength (M10 steel) @23°C	24 hours

*Handling time at 23°C / 73°F. Copper and its alloys will make the adhesive cure more quickly, while oxidised or passivated surfaces (like stainless steel) will reduce cure speed. To reduce curing time, use Permabond® activator A905 or ASC10. Alternatively, increasing the curing temperature will reduce curing time.

Typical Performance of Cured Adhesive

Torque strength (M10 steel ISO 10964)	Break 27 N·m 240 in.lb Prevail 54 N·m 480 in.lb
Shear strength (Steel collar & pin ISO 10123)	17 MPa 2500 psi
Coefficient of thermal expansion	90 x 10 ⁻⁶ mm/mm/°C
Dielectric strength	11 kV/mm
Thermal conductivity	0.19 W/(m.K)

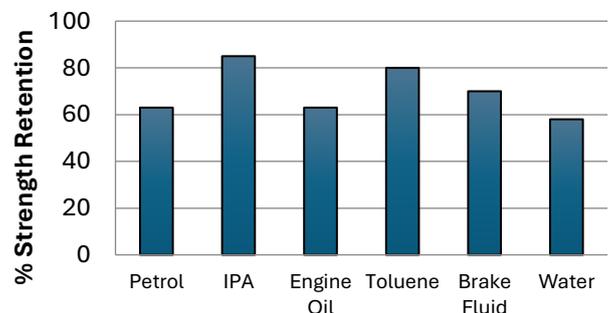
Strength Development



*Cure times are typical at 23°C. Copper and its alloys will follow the faster cure while oxidised or passivated surfaces like stainless steel will tend towards the slower curve. Lower temperatures or large gaps will tend to extend the cure time. To reduce the cure time the use of Permabond® A905, ASC10, or heat can be considered.

Chemical Resistance

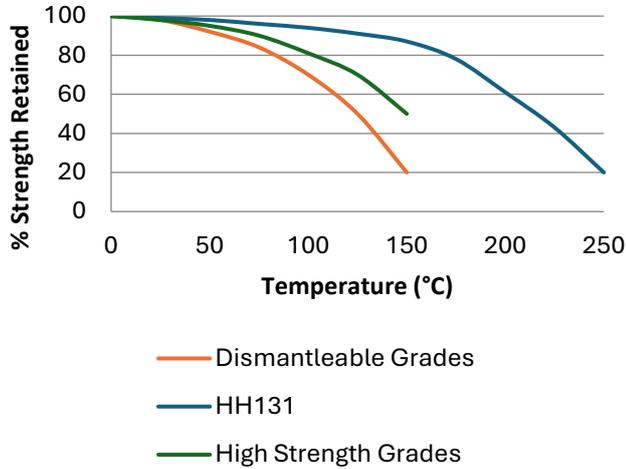
1 month immersion at 85°C



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Hot Strength



*"Hot strength" Breakaway strength on M10 Zinc plated bolts according to ISO 10964. Cured at 23°C for 24 hours then conditioned for 30 minutes at testing temperature.

Permabond® HH131 can withstand higher temperatures for brief periods (such as for paint-baking and wave soldering processes) provided the joint is not unduly stressed.

This product is not recommended for use in contact with oxygen, oxygen rich systems and other strong oxidizing materials. This product may adversely affect some thermoplastics and users must check compatibility of the product with such substrates before using.

Surface Preparation

Though the anaerobic adhesives will tolerate a slight degree of surface contamination, best results are obtained on clean, dry and grease free surfaces. The use of a suitable solvent-based cleaner (such as acetone or isopropanol) is recommended.

In general, roughened surfaces (~25µm) give higher bond strengths than polished or ground surfaces. To reduce the curing time, especially on inactive surfaces (such as zinc, aluminium and stainless steel), the use of Permabond® A905 or ASC10 can be considered.

Directions for Use

- 1) Shake bottle before use.
- 2) Prevent the tip from touching metal surfaces during application.
- 3) When working with through-holes, dispense a bead of material across the contact length of the threads.
- 4) When working with blind-holes, apply several drops down the threads to the bottom of the hole.
- 5) Assemble and torque the parts as necessary.
- 6) Replace lid to bottle to avoid contamination of remaining liquid adhesive.

NB: Adhesive outside of a closed joint (i.e., excess material) will remain uncured due to air contact. Adhesive inside the joint will cure solid. Ensure the adhesive viscosity is suitable for your thread size.

Video Link

Threadlocker directions for use:

<https://youtu.be/7144nHEDYI8>



Storage & Handling

Storage Temperature	5 to 25°C (41 to 77°F)
Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Safety Data Sheet.	

This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.

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