

## Permabond HM129 Anaerobic Threadlocker

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

### Material Notes:

Permabond® HM129 is a high strength medium viscosity anaerobic threadlocker and sealant. This material cures in the absence of air between tight fitting metal parts. Cure is fast and reliable on steel, cadmium, zinc and other plated fasteners. It is used for locking and sealing bolts, nuts and screws that require permanent assembly. When cured, the material prevents loosening and leakage. Features & Benefits: Oil tolerant Vibration resistant Lubricates threads for easier assembly Provides corrosion protection Solvent free Information provided by Permabond.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Permabond-HM129-Anaerobic-Threadlocker.php](http://www.lookpolymers.com/polymer_Permabond-HM129-Anaerobic-Threadlocker.php)

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	500 cP	500 cP	Uncured
	@Temperature 25.0 °C	@Temperature 77.0 °F	
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	0.0830 hour	Brass, handling strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	10.2 min	0.170 hour	M10 steel, handling strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	

Processing Properties	Metric <sup>1</sup>	English <sup>hour</sup>	Comments Zinc, handling 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	
	60.0 - 180 min	1.00 - 3.00 hour	M10 steel, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	180 - 360 min	3.00 - 6.00 hour	Zinc, working strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	
	4320 min	72.0 hour	M10 steel, full strength
	@Temperature 23.0 °C	@Temperature 73.4 °F	

Descriptive Properties	Value	Comments
Appearance	Red	Uncured
Maximum Gap Fill (mm)	0.15	
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)	33	M10 steel, break
	58	M10 steel, prevail
UV Fluorescence	Yes	Uncured

## Contact Songhan Plastic Technology Co.,Ltd.

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