

Permabond HM163 Anaerobic Retainer

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

Material Notes:

Permabond® HM163 is a medium viscosity, thixotropic anaerobic retaining compound that cures when confined between metal parts to form a tough bond. It has been specifically formulated to provide a fast cure on inactive surfaces such as aluminum and stainless steel. The viscosity and thixotropic effect of the material allows for the use of larger tolerances on components. Features & Benefits: Fast setting and fixing of components Very high strength Thixotropic Excellent chemical resistance Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-HM163-Anaerobic-Retainer.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	3500 cP @Temperature 25.0 °C	3500 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	28.0 MPa	4060 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	

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 @Temperature 23.0 °C	0.117 hour @Temperature 73.4 °F	Zinc, handling strength
	15.0 min	0.250 hour	

Processing Properties	Metric @ Temperature 23.0 °C	English @ Temperature 73.4 °F	Brass, working strength Comments
	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)	30	M10 steel, break
	55	M10 steel, prevail
UV Fluorescence	Yes	Uncured

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