

## Features & Benefits

- NSF certified drinking water system component
- Simple one-part system
- Shaft-hub assemblies can be made with slip fits
- Expensive press fits can be eliminated
- High viscosity for maximum gap filling ability
- Excellent shear strength
- Superior environmental resistance
- Thixotropic viscosity allows easy dispensing

## Description

**PERMABOND<sup>®</sup> HH040 PURE** is a single component liquid that cures only when in contact with metal parts and oxygen is excluded. The liquid adhesive fills the "air space" between parts and upon cure unitizes and retains male and female parts. Thus it prevents their movement relative to each other, eliminating wear, erosion, and pitting. **HH040 PURE** cures to a tough cross-linked plastic that will prevent the corrosion of mated parts, and provides excellent environmental and temperature resistance.

**PERMABOND<sup>®</sup> HH040 PURE** Anaerobic Retaining Compound conforms to all applicable requirements of the NSF/ANSI Standard 61, Drinking Water System Components - Health Effects, as certified by NSF International and the American National Standards Institute.

Standard 61 establishes minimum health effects requirements for materials, components, products, or systems that contact drinking water or drinking water treatment chemicals. NSF standards are widely recognized by public health officials, and certified products have been tested and determined to cause no adverse health effects. This allows manufacturers using certified materials to bypass some or all chemical testing when seeking NSF certification.

NSF International has certified all PERMABOND<sup>®</sup> PURE products.

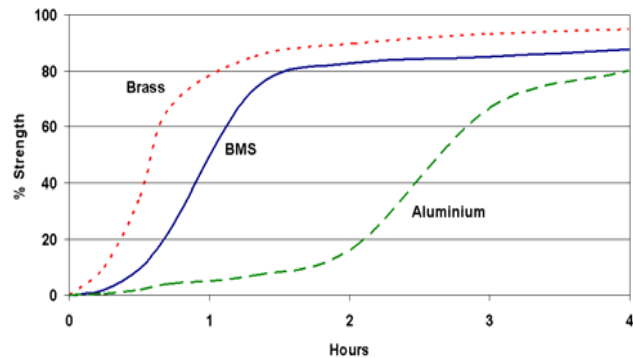
## Physical Properties of Uncured Adhesive

|                      |                             |
|----------------------|-----------------------------|
| Chemical composition | Methacrylates               |
| Appearance           | Colourless to light amber   |
| Viscosity @ 25°C     | 5000 mPa.s (cP) Thixotropic |
| Specific gravity     | 1.09                        |

## Typical Curing Properties

|                            |                      |
|----------------------------|----------------------|
| Maximum gap fill           | 0.25 mm <b>0.01"</b> |
| Maximum thread size        | M30 ¾"               |
| Handling strength (steel)* | 15 minutes           |
| Full strength              | 24 hours             |

## Strength Development



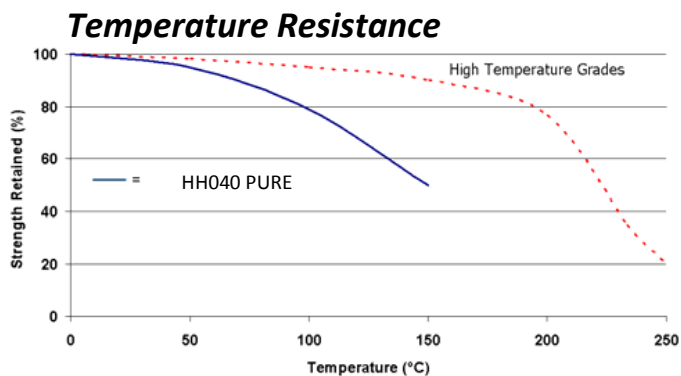
\*Cure times are typical at 23°C. Copper and its alloys will follow the faster cure while oxidised or passivated surfaces like stainless steel will tend towards the slower curve. Lower temperatures or large gaps will tend to extend the cure time. To reduce the cure time the use of Permabond<sup>®</sup>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

## Typical Performance of Cured Adhesive

|  |  |
|--|--|
| Torque strength (M10 Zn plated ISO10964) | Break 23 N·m <b>200 in.lb</b><br>Prevail 34 N·m <b>300 in.lb</b> |
| Shear strength (steel collar & pin)      | 14 MPa <b>2000 psi</b>   |
| Coefficient of thermal expansion         | 90 x 10 <sup>-6</sup> mm/mm/°C                                   |
| Dielectric strength                      | 11 kV/mm   |
| Thermal conductivity                     | 0.2 W/(m.K)  |

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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"Hot strength" shear strength tests performed on mild steel. 24hr cure at room temperature and conditioned to pull temperature for 30 minutes before testing.

HH040 PURE can withstand higher temperatures for brief periods (such as for paint baking and wave soldering processes) providing the joint is not unduly stressed. The minimum temperature the cured adhesive can be exposed to is -55°C (-65°F) depending on the materials being bonded.

### Joint Strength

The amount of bonded area, the bondline thickness and the surface finish of the cylindrical parts determine the strength of a joint. The bond area and bondline thickness (clearance) depend on the design of the joint. As the gap (clearance) between parts increases, some loss of strength is experienced. Maximum strength is obtained when the diametrical clearance does not exceed 0.005 inches.

| Clearance (inches) | % Strength Retained | Surface Finish (micro-inches)* | % Strength Retained |
|--------------------|---------------------|--------------------------------|---------------------|
| 0.0025             | 93%                 | 8                              | 45%                 |
| 0.0050             | 91%                 | 32                             | 57%                 |
| 0.0075             | 85%                 | 64                             | 70%                 |
| 0.0100             | 62%                 | 70                             | 100%                |

\* Micro-inches =  $1 \times 10^{-6}$  in. A machine finish will usually yield a surface roughness of 60 to 80 micro-inches that will typically give optimum strength when using HH040 PURE.

### Effect of Anaerobic Retaining Compound on Push-Off Force\*

|                  | Clearance (inches) | Finish (micro-inches) | Push-Off force (psi) |
|------------------|--------------------|-----------------------|----------------------|
| Interference fit | -0.0005            | 6                     | 2100                 |
| Slip fit HH040P  | +0.002             | 6                     | 2350                 |
| Slip fit HH040P  | +0.002             | 63                    | 3400                 |

\*1/2 inch steel collar & pin.

### 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. On slip fitted assemblies, apply adhesive on the leading edge of the pin and on the inside of the collar.
2. Assemble with twisting action.
3. On press fitting assemblies, apply the adhesive on the pin and collar. Assemble using a press.
4. On shrink fitted assemblies, apply the adhesive to the pin, heat the collar to create enough clearance and assemble.
5. Allow the parts to fixture before disturbing them.

**This product is not recommended for use in contact with oxygen, oxygen rich systems and other strong oxidizing materials.**

### 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 Material Safety Data Sheet. |                        |

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