

PERMABOND® LH150

Anaerobic Pipe Sealant

Permabond®
Engineering Adhesives

Ref #: 010106PBLH150

TYPICAL APPLICATIONS

Typical Industries Served

Automotive
Appliances
Construction
Fire Protection
Plumbing
Utilities

General Assembly

Locks and Seals Pipe

General Pipe Maintenance

Replaces Dopes and Tapes

FEATURES & BENEFITS

- ◆ Lower Cost Per Application
- ◆ Full Cure at Room Temperature
- ◆ Easy to Use & Apply
- ◆ Directional Freedom
- ◆ Low Shrinkage During Cure
- ◆ Uncured Material Fully Dissolves in Water
- ◆ Nonflammable
- ◆ Will not Tear, Shred, or Gall Fitting
- ◆ High Temperature Resistance
- ◆ Superior Resistance to a Wide Range of Chemicals
- ◆ Full Cure Seal to the Burst Rating of Pipe
- ◆ Environmentally Friendly

GENERAL DESCRIPTION

PERMABOND's LH150 Pipe Sealant with Teflon® is an excellent general purpose pipe sealant that has accelerated curing properties. Accelerated curing properties of **PERMABOND's LH150** Pipe Sealant allows for optimum performance on steel and certain plated fittings. Instant sealing is achieved of up to 1000 psi upon limited hand tightening. After cure, the sealing capability is up to the burst rating of the typical pipe. The low locking strength allows easy disassembly. **PERMABOND's LH150** Pipe Sealant is approved by Underwriters Laboratory.

PERMABOND LH150 Pipe Sealant with Teflon provides an excellent replacement for pipe dopes and pipe tapes, and will provide a faster cure rate compared to **PERMABOND LH050** Pipe Sealant.

Non-Warranty: 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.

No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care® program.

PERMABOND

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PHYSICAL PROPERTIES OF THE UNCURED ADHESIVE

<u>Properties</u> Base Resin Solids, % Color Viscosity, cP, 25°C (77°F) Consistency Gap filling, in Specific Gravity Flash Point, °C (°F) Shelf Life stored at or below 27°C (80°F), months* Maximum Filler Size, μ Odor	Methacrylate Esters 100 White 260,000 Paste 0.020 1.2 >93 (200) 12 10 Low
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*Package size greater than one liter, six months.

SPEED OF CURE

Speed of Cure*, hours	
Fixture Strength	2
Full Strength	24

*Measured on clean M10 steel nuts & bolts.

BEHAVIOR ON DIFFERENT SUBSTRATES

Activity of Materials and Finishes

Super Active	Active	Inactive	Passive
Brass Copper Magnesium	Iron Steel Nickel Aluminum	Anodized aluminum Cadmium finishes Chrome finishes Passivated metals Stainless steel Titanium Zinc	Ceramics Glass Plastics Painted finishes
Super Active Active Inactive Passive	Very fast cure Fast cure Slow cure No cure without PERMABOND's ASC10 Surface Conditioner		

PERFORMANCE PROPERTIES OF THE CURED ADHESIVE

Cured at 25°C for 24 hours	
Torque, ISO 10964	
Breakaway, lb-in (N·m)	
M10 steel nuts and bolts	35 (4)
Prevail, lb-in (N·m)	
M10 steel nuts and bolts	25 (3)
Compressive shear strength, ISO 10123 (Steel pin and collars)	1000 psi (7) N/mm ²

SEALING PROPERTIES

PERMABOND LH150 Pipe Sealant will provide maximum sealing capabilities after full cure. Typically, this is up to the burst rating of the pipe or fitting. **PERMABOND's LH150** Pipe Sealant, tested on a high pressure hydraulic fittings results in failure of the fitting itself at 40,000 psi.

Instant sealing property is a function of the on-torque assembly, type of fitting, and grade of fitting. The instant sealing property of **PERMABOND LH150** Pipe Sealant is 1,000 psi when hand assembled and 3,000 psi when a 10 in-lb. on-torque is applied.

THERMAL PROPERTIES

PERMABOND LH150 Pipe Sealant resists high temperatures up to 177°C (350°F) for sealing. At operating temperatures of up to 150°C (300°F), full locking strength is maintained.

CHEMICAL RESISTANCE

Permabond LH150 Pipe Sealant was tested for resistance to fluids for 1,000 hours under the indicated temperature conditions:

1,000 Hours Soak	Temperature, °C (°F)	Pressure, psi	Results
Antifreeze, 50%/Water, 50%	126 (260)	60	No leak
Brake Fluid	150 (300)	60	No leak
Differential Lube	150 (300)	60	No leak
5W/30 Engine Oil	150 (300)	60	No leak
Transmission Fluid	150 (300)	60	No leak
Diesel Fuel #2	25 (77)	60	No leak
ASTM Fuel C	25 (77)	60	No leak
Water, Steam	198 (390)	540	No leak
Air	150 (300)	60	No leak

MATERIAL COVERAGE

The number of various sized fittings that may be coated with one 50mL, and one 250mL tube of **Permabond LH150** Pipe Sealant are shown:

Fitting Size, inches	Volume, mL/100 Pieces	Usage, Pieces/50 mL	Usage, Pieces/250 mL
0.125	7.25	700	3450
0.25	9.66	500	2600
0.375	12.05	400	2100
0.5	14.05	340	1700
0.75	19.3	260	1300
1.0	24.2	200	1000

APPLICATION & DISPENSING

1. For best results, clean all surfaces with a cleaning solvent and allow to dry.
2. If the substrates being used are inactive metals or the cure speed is too slow, then spray the parts with ASC10 and allow to dry.
3. Apply the sealant around leading threads of the male fitting. Force the material into all the voids. Adjust amount of sealant according to the size of the fitting.
4. Assemble and tighten the fittings until proper alignment is obtained. Visually check for a small bead of sealant around the entire circumference of the pipe.
5. A seal to moderate pressure is obtained immediately on properly tightened fittings. Allow the sealant to cure for at least 24 hours to obtain maximum pressure and chemical resistance.

PERMABOND LH150 Pipe Sealant may be readily dispensed out of the tube, or brush-top bottle. When using the tube package size, the convenient flip-top may be used to spread the sealant directly on to the first two-three threads of the male-component fitting. For larger volumes, the brush-top applicator may be used to “paint” the adhesive on to the first two-three threads of the male-component fitting. Following sealant application, tightening the fittings by hand, or using a wrench will complete assembly. Adjustments may be made up to 10 hours after assembly, without affecting the performance properties of the cured seal.

STORAGE & HANDLING

PERMABOND's LH150 pipe sealant should be stored in the original unopened container in a cool place away from sparks, flame, excessive heat and sunlight. Handling should be done using plastic gloves and proper eye protection. Skin contact should be avoided. If skin contact occurs, the affected area should be washed thoroughly with soap and water. Eye contact should be treated by thorough washing with water followed by medical attention. Adequate ventilation is necessary to prevent inhalation of vapors. Proper Personal Protective Equipment is always recommended when using chemicals. **For more information, consult the Material Safety Data Sheet.**

PERMABOND LH150 Pipe Sealant has a shelf life of one year when stored at or below 27°C (80°F). Do not freeze. Product removed from original container might be contaminated during use. Do not return this material to the original container.

FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN.

