

Features & Benefits

- Eliminates pre-cut gaskets from flange assemblies
- Instant pressure seal
- Forms a tough, durable seal able to withstand high pressure
- No need to re-tighten flange bolts
- Non-flammable
- No shimming effects – better load transmission

Description

PERMABOND® HH190 Gasketmaker is an anaerobic curing flange sealant that can replace, or be used as a dressing for, conventional pre-cut gaskets. Since HH190 is a flowable paste, it conforms to the shape of the flange. The consistency allows metal to metal contact of the flanges while filling the areas where no contact exists because of irregularities. HH190 results in uniform stress distribution and eliminates the need for re-torquing because of stress relaxation of the flange bolts. It provides instant seal depending on the gap and flange width and ultimately seals up to 5000psi. It has excellent shock and vibration resistance and is able to be conveniently dismantled if necessary.

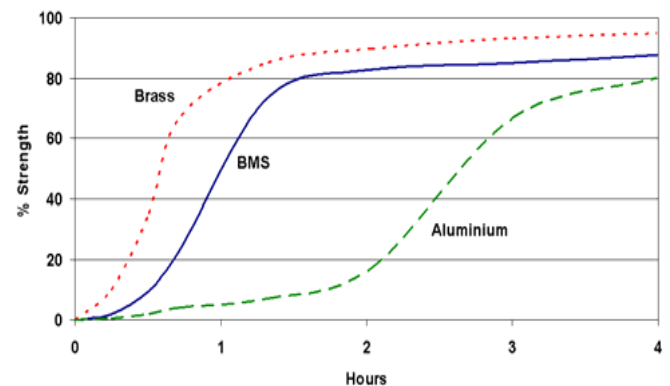
Physical Properties of Uncured Adhesive

Chemical composition	Acrylic
Appearance	Purple
Viscosity @ 25°C	600,000 mPa.s (cP) Flowable paste
Specific gravity	1.08

Typical Curing Properties

Maximum gap fill	0.5 mm 0.025 in
Maximum thread size	
Handling strength (steel)	15 minutes*
Full cure	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 A905, ASC10, or heat can be considered.

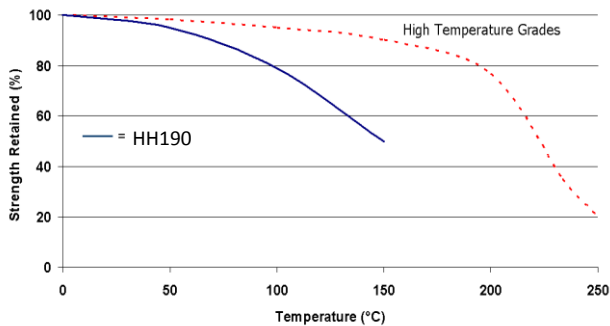
Typical Performance of Cured Adhesive

Shear strength (steel collar & pin)	6 MPa 900 psi
Coefficient of thermal expansion	90 x 10 ⁻⁶ mm/mm/°C
Dielectric strength	11 kV/mm
Thermal conductivity	0.19 W/(m.K)
Instant seal (5 mil gap)	>75 psi
Full seal (10 mil gap)	>5000 psi

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Temperature Resistance



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

HH190 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.

Chemical Resistance

340 Hour Immersion At 75°C (168°F)	Full Strength retained (%)
Water	100
Butyl alcohol	100
Toluene	99
Motor oil	99
Hydrocarbon test fluid	100
JP4-jet fuel	93
JP5-jet fuel	100
Ethylene glycol	99

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 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) Apply as a bead, by roller, silkscreen or stencil. Ensure all potential leak paths such as flange bolt holes are encircled.
- 2) Removal: use normal tools to lever the surfaces apart.
- 3) Ensure old adhesive is removed before reassembling the parts.

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.	

Contact Permabond:

Europe: Tel. +44 (0)1962 711661
 UK Helpline: 0800 975 9800
 Deutschland: 0800 10 13 177
 France: 0805 11 13 88
 info.europe@permabond.com

US: Tel. +1 732-868-1372
 Helpline: 800-640-7599
 info.americas@permabond.com
 Asia: Tel. +86 21 5773 4913
 info.asia@permabond.com

www.permabond.com

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