

Features & Benefits

- Full cure seal to the burst rating of pipe
- Easy to use and apply
- Directional freedom
- Uncured material fully dissolves in water
- Does not contain solvents
- Excellent chemical and temperature resistance
- Cures at room temperature
- Ideal for sealing hydraulic systems

Description

PERMABOND® LM012 is an unfilled, medium-high viscosity anaerobic adhesive. Although its instant seal capability is limited, seal after full cure is complete. Its major benefit as related to other pipe sealants is that it is an unfilled resin that is compatible with hydraulic fluids. If the adhesive is accidentally spilled into the hydraulic system, e.g., squeezed out of the joint, it will be dispersed in the fluid. It contains no particles that can clog or foul hydraulic screens and valves. Thus it is used in very sensitive high pressure hydraulic systems.

MIL-S-22473 Grade HVV

Each lot of LM012 is tested to the lot requirements of these specifications.

ASTM D5363 AN 0163 Group 01 Class 6 Grade 3

Each lot of LM012 is tested to the general requirements defined in paragraphs 5.1.1 and 5.1.2 and the detail requirements defined in section 5.2

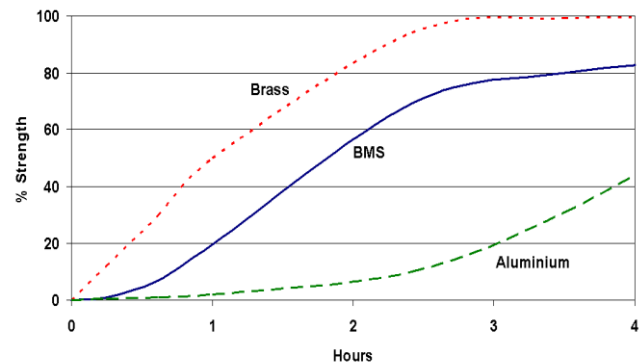
Physical Properties of Uncured Adhesive

Chemical Composition	Methacrylate esters
Appearance	Brown
Viscosity @ 25°C	2,000 mPa.s (cP)
Specific Gravity	1.07

Typical Curing Properties

Maximum gap fill	0.5 mm 0.02 in
Handling time	30 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® A905, ASC10, or heat can be considered.

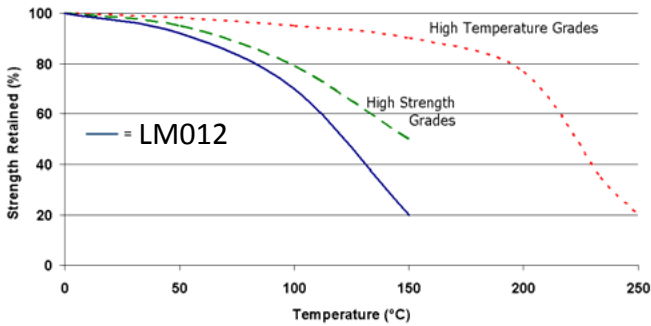
Typical Performance of Cured Adhesive

Torque strength (M10 steel ISO10964)	Break 3 N·m 25 in.lb Prevail 2 N·m 15 in.lb
Shear strength (steel collar & pin ISO10123)	5 MPa 750 psi
Coefficient of thermal expansion	90 x 10 ⁻⁶ in/in/°C
Thermal Conductivity	0.19 W/mK
Dielectric strength	11 kV/mm
Electrical Resistance	10 ¹⁷ Ω

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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.

LM012 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

1000 Hour immersion	Temperature, °C (°F)	Pressure, psi	Results
50% Antifreeze / 50% water solution	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

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 and sealants 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) Prevent the tip from touching metal surfaces during application.
- 2) Apply Permabond® LM012 onto the leading 3-4 threads half way around the male pipe for pipes up to 1½ inches in diameter. For larger pipes, apply completely around the pipe.
- 3) Screw fittings together. Permabond pipe sealants will seal even when the direction the pipe must face does not allow the complete seating of the threads.
- 4) Visually inspect for a bead of pipe sealant around the entire pipe. If the sealant isn't visible around the circumference, repeat the steps above using more sealant.

Storage & Handling

Storage Temperature	Below 27°C (80°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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