

Major Features

- * Toughened
- * Very high strength
- * Ideal when bonding dissimilar metals
- * Improved fatigue life

Permabond F200 is an anaerobic adhesive which has been developed to give excellent resistance to peel and impact forces. This toughening, combined with good adhesion to aluminium and copper alloys, makes it the first choice when relatively thin or lightweight components are being bonded which may be subject to 'distortion' in service. It is also capable of resisting the thermal stresses that may be generated when bonding dissimilar surfaces. Permabond F200 is also suitable for contact with potable water.

Physical Properties

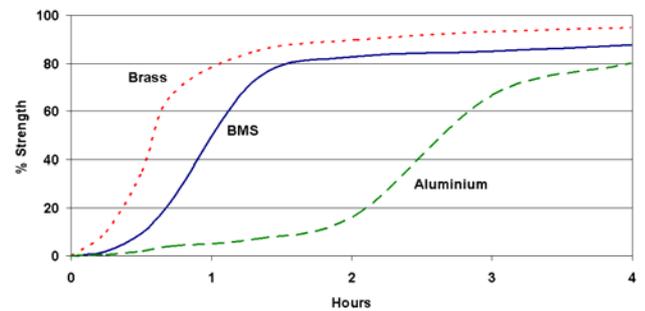
Chemical Type	Acrylic Single Part
Colour	Brown
Viscosity @ 25°C mm ² /s	200
Density	1.04
UV Fluorescent	No

Performance

Maximum Gap Fill		0.1 mm
Max. Thread Size		M10 ½"
Handling strength	Steel	10-25 minutes
Working strength		1 hour
Full strength		24 hours
Torque strength (Break / Preval)	M10 Steel Nuts and Bolts	33 / 58 Nm
Shear strength	Steel Collar and Pin	30 MPa
Service Temp.		-55 to +100°C

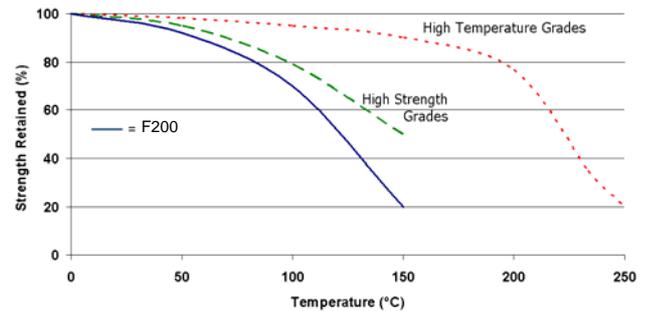
WRAS approved for contact with potable water

Strength Development



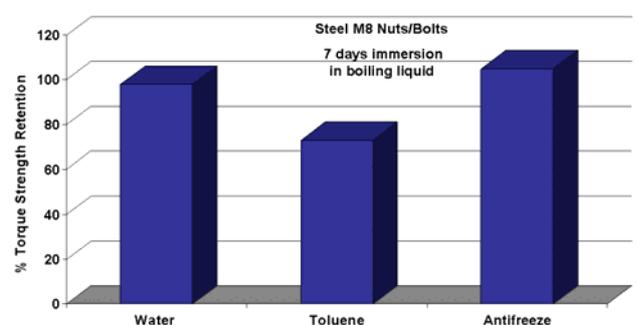
Cure times are typical at 23°C. Copper and its alloys will follow the faster cure while oxidised or passivated surfaces like stainless steel will tend towards the slower curve. Lower temperatures or large gaps will tend to extend the cure time. To reduce the cure time the use of Permabond A905, or heat,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

Hot Strength



The reduction in strength shown here is reversed on cooling providing the joint is not overstressed. Exposure to higher temperatures may be acceptable for short periods

Chemical Resistance



This product is not recommended for use in joints which will be in contact with either steam or pure oxygen. Avoid prolonged contact with strong acids, alkalis and very polar solvents

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 Permabond Cleaner A 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 can be considered.

Adhesive Application



Gasketing

Apply as a bead, by roller, silkscreen or stencil. Ensure all potential leak paths such as flange bolt holes are encircled.

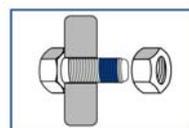
Removal: use normal tools to prise the surfaces apart. Ensure old adhesive is removed before reassembling the parts.

Retaining

Apply a circumferential bead; preferentially to the female component. Assemble with a twisting action.



For larger components use thixotropic products to prevent run off. Take care to ensure adhesive does not enter ball races or other mechanisms.



Thread Locking

Apply sufficient adhesive to the bolt to ensure adequate coverage. For coarse threads use thixotropic grades.

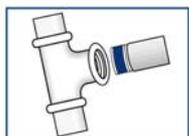
For blind holes adhesive should be applied to the lower end of the female thread to ensure it is not forced out of the joint during assembly.

Thread Sealing

Apply a continuous bead circumferentially 1-2 threads from the leading edge. Ensure sufficient is applied to give a complete seal.

For taper/parallel threads ensure adhesive is positioned where the threads will engage fully. Gaps, and therefore cure times, may be greater than expected with this joint configuration.

Tighten with normal tools.



Storage and Handling

Storage Temperature	5 to 25°C
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.	

Other products in the Permabond range....

Anaerobics

- ✓ Toughened
- ✓ Gas & Water approved
- ✓ High temperature resistance

Cyanoacrylates

- ✓ Low bloom / low odour
- ✓ Flexible,
- ✓ High temperature resistance

Epoxies

- ✓ Fast cure
- ✓ Toughened
- ✓ Flexible grades

Toughened Acrylics

- ✓ Rapid cure
- ✓ Low odour

UV Light Cured

- ✓ Glass / plastic bonding
- ✓ Optically clear
- ✓ Non yellowing

Contact Permabond:

Europe: Tel +44(0)1962 711 661
 UK Helpline: 0800 975 9800
 Deutschland: 0800 101 3177
 France: 0805 11 13 88
info.europe@permabond.com

US: Tel 00 1 732-868-1372
 Helpline 800-640-7599
info.americas@permabond.com

Asia: Tel 00 886 939 49 3310
info.asia@permabond.com

www.permabond.com

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