

End Cap Bonding MEDIA POTTING

Product	Viscosity Description	Viscosity cP	Service Temp.	Cure
Permabond ES550 Non sag, toughened, high impact strength.	No Sag	1,500,000	-40°F to 355°F (-40°C to 180°C)	130°C (266°F) 75 min 150°C (300°F) 60 min 170°C (338°F) 40 min
Permabond ES562 Free flowing, toughened, high impact strength.	Free Flowing	22,500	-40°F to 355°F (-40°C to 180°C)	130°C (266°F) 60 min 150°C (300°F) 45 min 160°C (320°F) 20 min
Permabond MT382 Flexible modified epoxy, 200% elongation, Shore D 25.	Self Leveling	21,500	-40°F to 250°F (-40°C to 120°C)	2:1 Mix Ratio Handling Strength < 2 hours
Permabond PT328 Two component polyurethane.	Free Flowing	5,250	-40°F to 250°F (-40°C to 120°C)	1:1 Mix Ratio Handling Strength < 2 hours
Permabond ET5147 Formulated in compliance with FDA 175.105 and 175.300.	Thixotropic paste	-	-40°F to 250°F (-40°C to 120°C)	2:1 Mix Ratio Handling Strength < 5 hours

Permabond manufactures a full line of adhesives for filter manufacturing. Products with different viscosity, hardness, elongation, temperature resistance, and cure speeds are available. A few of our products and capabilities are listed here, please contact Permabond for more information!



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Adhesives & Sealants for FILTERS

Permabond's line of adhesives and sealants offers the performance characteristics needed to bond and seal the many different substrates used in filter manufacturing.

TYPICAL APPLICATIONS

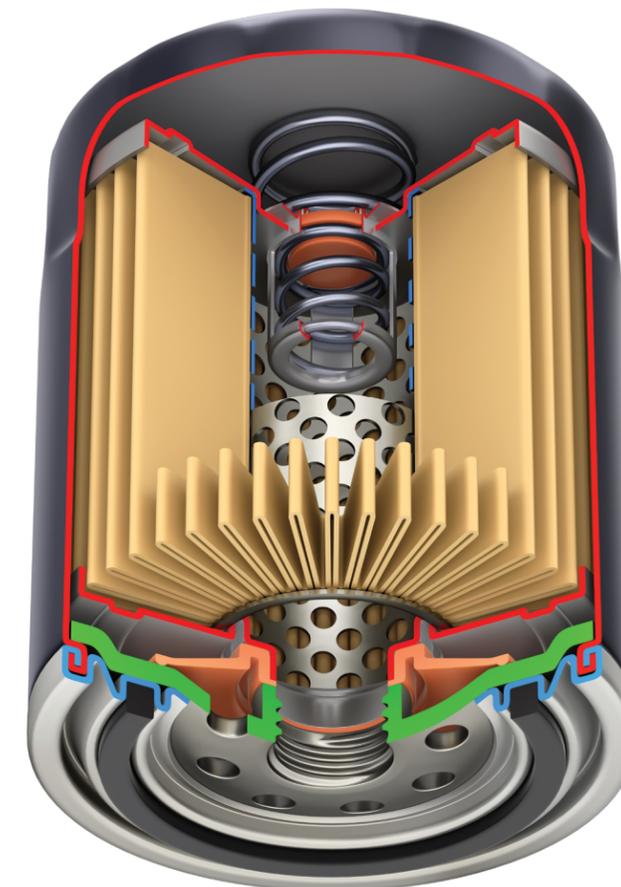
- Crimping Seals
- Sealing Disc Shaped Filters
- Sealing Rolled Seams to the Base Plate
- Bonding Filter Assembly to the End Plate
- Bonding Rubber Gaskets to the Base Plate
- Potting Filter Media into the Base Plate

Anaerobic adhesive sealants for rolled seams and crimp sealing.

Cyanoacrylate adhesives quickly form spliced gaskets and bond gaskets to end caps.

Single part epoxies are a cost effective alternative to welding metal filter components. The added benefit of a complete seal is a result of potting components for assembly.

Two component epoxies which are low viscosity are ideal for potting pleated filter media and have excellent resistance to water, fuel, etc. The low exotherm temperature makes them suitable for bulk volume potting applications.



Polyurethanes for potting media.

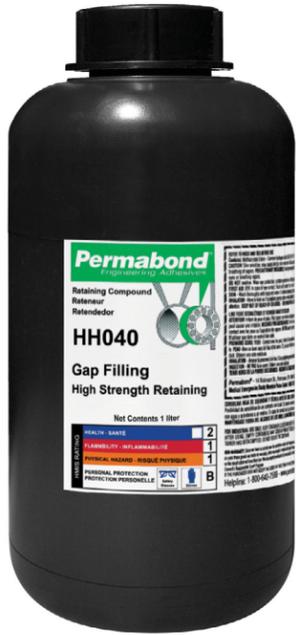
Structural acrylics offer high speed, durable bonding.

Some of these products are highlighted in the tables that follow. If you do not see the product you require, contact Permabond for a recommendation or custom formulation for your unique application.

Rolled Seam - Crimp Sealing ANAEROBIC ADHESIVE SEALANTS

Product	Viscosity (mPa.s) cP	Gap fill in (mm)	Flexibility	Compressive strength	Temp. resistance °C (°F)
Permabond HH040 General purpose seam sealer, thixotropic sealant.	5,000 thixotropic	0.010 (0.254)	Low	2,000 psi	High 300°F (150°C)
Permabond HM166 High temperature resistant seam sealer.	15,000 thixotropic	0.020 (0.500)	Low	2,300 psi	Very High 450°F (230°C)
Permabond MH196LV Maximum gap filling seam sealer.	Gel	0.020 (0.500)	High	750 psi	High 300°F (150°C)
Permabond LM198 Very flexible.	8,000 some thixotropic properties	0.012 (0.305)	High	1,400 psi	High 300°F (150°C)

Anaerobic adhesives cure when confined between metal surfaces such as a rolled seam. Products vary in temperature resistance, gap fill, and viscosity. Above are only a few popular grades listed. Contact Permabond if you don't see exactly what you need!



SEAM SEALING - CRIMP SEALING

The following list details why Permabond anaerobic sealants are the preferred choice for rolled seam and crimp sealing.

- Reduced reject rates
- Environmentally friendly
- Non-flammable - no hazardous shipping costs
- 100% solids - no waste
- Application process can be easily automated
- Fluoresce under black light for QC inspection
- Excellent resistance to water, oil, fuel, and other chemicals



Gasket Splicing and Bonding CYANOACRYLATES

Product	Flexibility	Viscosity cP	Fixture Time	Temp. range (°C) °F
Permabond 105 Elastomer bonding for gasket bonding or forming rubber gaskets.	Low	40	<15 sec	(-55 to +82) -65 to +180
Permabond 731 Toughened cyanoacrylate for high durability.	Toughened	150	<30 sec	(-55 to +120) -65 to +250
Permabond 792 Surface insensitive very fast curing with higher temperature resistance.	Low	90	<3 sec	(-55 to +120) -65 to +250
Permabond 825 Patented High temperature resistance.	Low	125	<20 sec	(-55 to +200) -65 to +390
Permabond 910® The original methyl, metal bonding cyanoacrylate.	Low	80	<15 sec	(-55 to +90) -65 to +195
Permabond 2011 Rapid curing high viscosity gel cyanoacrylate.	Low	Gel	<10 sec	(-55 to +120) -65 to +250

Gaskets are created by bonding two spliced ends of rubber together with Permabond cyanoacrylates. These gaskets or preformed gaskets are bonded to the end caps of heavy duty truck air filters and industrial element return filters with Permabond cyanoacrylates.

Contact Permabond if you don't see exactly what you need!

