Permabond®
Engineering Adhesives

MUNITIONS ADHESIVES & SEALANTS



Permabond is a world leader in adhesive and sealant technologies, and a trusted supplier to high-reliability manufacturing industries worldwide.

Permabond offers a range of products for the munitions manufacturing industry. We have a wealth of experience in providing custom formulations to suit specific munitions customer requirements.

A global team of technical, sales, and distribution professionals are specially trained to ensure they can assist you in selecting the most appropriate standard or custom formulated product for your unique application. Our team looks forward to hearing from you.



KEY FEATURES & BENEFITS

Anaerobic Adhesives and Sealants:

- Better joint coverage for improved sealing consistency
- Low viscosity for easy application after the bullet is inserted
- UV fluorescent for inspection identification
- Reduced trajectory deflection

Dual Cure Anaerobic-UV Sealants:

- Instant Seal
- Easy to dispense
- Low viscosity for penetration between bullet and casing
- Cures anaerobically between bullet and casing
- Meniscus of 'fillet' can be cured with UV light – this gives additional durability and extra protection against moisture
- Fluoresces under UV black light for inspection purposes

Munitions Adhesives & Sealants

The table below lists Permabond adhesives and sealants that are commonly used for the listed applications. Depending on your application requirements a different Permabond solution may be more suitable to your needs. Please contact Permabond's technical team for support with your product selection.

Grade	A1024	A1062	UV7134
Features	Low viscosity wicking anaerobic sealant.	Dual cure bullet sealant. Secondary UV cure allows the curing of the excess meniscus around the top of the casing providing improved durability and a visible seal.	Dual cure, friable bullet sealant that seals crimps and primers. Secondary UV cure to lock out moisture while fully burning off during firing.
Appearance	Yellow	Red or Green	Green
Typical Appliactions	Sealing between bullet and casing	Sealing between bullet and casing	Sealing primers and crimps on bullets
Cure Method	Anaerobic cure	Anaerobic / UV cure	Anaerobic / UV cure
Viscosity (mPa.s) cP	10-20	10-20	2400
Handling Time	<5 minutes (copper) <20 minutes (steel)	<5 minutes (copper) <20 minutes (steel) 5 - 20 seconds (UV cure)	<30 mins (Anaerobic cure) <10 seconds (UV cure)
UV Fluorescence	Yes	Yes	Yes

Benefits of Permabond over lacquer

- Solvent free - no emissions or waste, non-flammable, 100% reactive
- Single component - no mixing or pot-life
- Viscosity can be matched to application
- No creep, shrinkage, or cracking
- Excellent protection against moisture ingress

Benefits of Permabond over bitumen-based sealants

- No heat-cure required
- No drying out or cracking
- Low viscosity for easy in-line dispensing
- Rapid cure
- Built in UV fluorescence enables easy inspection

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