

GREEN HIGH STRENGTH RETAINING COMPOUND HIGH VISCOSITY PART NO. 47450

DESCRIPTION

Dynatex® Green High Strength Retaining Compound is a single component anaerobic retaining and locking adhesive, which develops high strength. The product cures between close fitting metal parts where there is an absence of air.

PHYSICAL PROPERTIES

Monomer (Liquid)

Base Compound	Dimethacrylate Ester
Color	Green
Viscosity (cP @ 68°F).....	7000 cP
Flash Point (TCC)	Above 200°F
Gap Fill016"
Corrosivity	None
Toxicity	Low
Specific Gravity (g/cc).....	1.10
Shelf Life @ 40°F.....	1 year unopened
Military Specifications.....	None
Curing Properties.....	Depends on environmental conditions and the substrates used.

Polymer (Cured)

Retaining Strength.....	High
Service Temperature Range	-75°F to 464°F
Appearance.....	Green solid
Sheer Strength (steel nuts and bolts)	3600 psi
Full Cure Time.....	24 hours

TYPICAL APPLICATIONS

Used to bond cylindrical parts, it can be applied to retain pulleys, gears, rotors and shafts as well as to secure bushings, bearings and housing plugs. *Dynatex® Green High Strength Retaining Compound* will augment shrink and press fit assemblies in demanding vibrational and high-friction applications.

CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

SETTING TIME (68°F, 65% R.H.)

Substrate	Set time/Full cure
Steel	60-120 min/24 hrs
Zn Dichromate	60-120 min/24 hrs
Aluminum	60-120 min/24 hrs

PERFORMANCE OF CURED MATERIALS

Bond strength after 24 hours at 20°C to 25°C on steel.

Shear Strength 2700-3600 psi.

CHEMICAL RESISTANCE

Sheer strength on steel after 500 hours.

Solvent	% Strength Retained
Motor Oil	100
Unleaded Gasoline	95
Brake Fluid	100
Ethanol	100
Acetone	95
Water/Glycol Mix	80

GENERAL INSTRUCTIONS

Surfaces to be bonded should be clean and dry and free of grease.

Product should be applied in enough quantity to fill all engaged threads. The product performs best in thin bond gaps. Very large gaps may create gaps, which will affect the cure speed and overall strength. Good contact is essential. An adequate bond develops in 15 to 45 minutes and maximum strength is attained in 24 hours.

This product is not recommended for use in pure oxygen environments and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

This product is not designed for plastics, particularly thermoplastics where stress cracking of the plastic could result. It is recommended to confirm compatibility of the product with all substrates prior to use.

STORAGE

Products should be stored unopened in a cool, dry place out of direct sunlight.

USERS PLEASE READ

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