

### GREEN HIGH STRENGTH RETAINING COMPOUND HIGH VISCOSITY PART NO. 47454

#### 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 <sup>0</sup> F) ..... | 7000 cP  |
| Flash Point (TCC) .....                  | Above 200 <sup>0</sup> F                                     |
| Gap Fill .....                           | .016"  |
| Corrosivity .....                        | None   |
| Toxicity .....                           | Low  |
| Specific Gravity (g/cc) .....            | 1.10   |
| Shelf Life @ 40 <sup>0</sup> 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 <sup>0</sup> F to 464 <sup>0</sup> 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

The information and data contained herein is believed to be accurate and reliable; however, it the user's responsibility to determine suitable of use. Since the supplier cannot know all the uses, or the conditions of use to which there products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

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Likewise, if the application, product specifications or manner in which our products are used require government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

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**Dynatex**<sup>®</sup> *A division of Accumetric, LLC*

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