

TECHNICAL DATA SHEET

GREEN HIGH STRENGTH THREADLOCKER LOW VISCOSITY – WICKING STYLE PART NO. 49460

PHYSICAL PROPERTIES

Monomer (Liquid)

Base Compound Dimethacrylate Ester
Appearance Green liquid
Viscosity (Brookfield Spindle 3 @ 20rpm,
RVT, 25°C) 30 +/- 20 cps
Flash Point >200°F (93°C)
Gap Fill003"
Corrosivity None
Toxicity Low
Specific Gravity 1.1
Shelf Life 12 months unopened
RoHS-Compliant Yes
Meets Mil-S-46163A, Type III Grade R
..... ASTM D-5363 AN 0261

Polymer (Cured)

Appearance Green solid
Locking Strength High
Service Temp Range -65 to 300°F (-54 to 149°C)
Full Cure Time 24 hours
Pin/Collar Strength 2000 psi
..... 14 N/mm²

DESCRIPTION

Dynatex® Green High Strength Threadlocker is a low viscosity anaerobic threadlocking adhesive that develops medium to high strength. Because of its low viscosity and capillary action, the product wicks between engaged threads and eliminates the need to disassemble, apply product, and then reassemble. Cures when confined in the absence of air between close fitting metal surfaces. Prevents loosening and leaking from shock and vibration, and protects threads from rust and corrosion. *Dynatex® Green High Strength Threadlocker* can also be used to fill porosity in welds, casting and powder metal parts. Localized heating and hand tools are needed for disassembly.

FEATURES

- No mixing
- Eliminates disassembly prior to application
- Prevents loosening due to vibration issues
- Seals porosity
- Cures without cracking or shrinking
- Seals against leakage
- Prevents rusting of threads
- No curing outside of joint
- Tamper-free

TYPICAL APPLICATIONS

Use on:

- Pre-assembled threaded assemblies
- Adjustment screws
- Brazed joints in cooling systems
- Carburetors
- Electrical connectors

PERFORMANCE OF CURED MATERIALS

	inch-pounds	Newton meters
Breakaway Torque	50 to no limit	5.65 to no limit
Prevailing Torque	150 to 350	16.95 to 39.54

SETTING TIME (68°F/20°C, 65% R.H.)

Substrate	Set time/Full cure
Steel	15 min/24 hrs
Brass	15 min/24 hrs
Zinc-Plated	20 min/24 hrs
Stainless Steel	20 min/24 hrs

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.

SOLVENT RESISTANCE

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	---
Ketone (aromatic)	Acetone, Benzophenone	---
Aliphatic hydrocarbon (alkanes)	Petrol, Heptanes, Hexane	+-
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	+-
Halogenated hydrocarbons	Methylenchloride Chloroform Chlorobenzol	---
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+++ (--- if concentrated)
Weak aqueous base	Sodium hydroxide solution, caustic potash	+++ (--- if concentrated)

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 AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), *Dynatex® Green High Strength Threadlocker* has a shelf life of 12 months from date of shipment.

In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity. Cartons should always be stacked upright. DO NOT stack cartons on their side. **NEVER** stack cartons more than 8 high. DO NOT store within 1 meter (4 feet) of roofline of the warehouse or storage building.

USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these 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.

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

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