

TECHNICAL DATA SHEET

GREEN HIGH STRENGTH SLEEVELOCKER MEDIUM VISCOSITY PART NO. 49473

PHYSICAL PROPERTIES

Monomer (Liquid)

Base CompoundUrethane Methacrylate
Appearance..... Green liquid
Viscosity (Brookfield Spindle
3 @ 20rpm, RVT, 25°C) 600 +/- 200 cps
Flash Point.....>200°F (93°C)
Gap Fill0.010"
Specific Gravity (g/cc)..... 1.1
Shelf Life 12 months unopened
Military Specifications Mil-S-46082B - Type II,
..... ASTM-D5363 AN 0412
RoHS-Compliant Yes

Polymer (Cured)

Appearance..... Green solid
Locking Strength High
Service Temp Range...-65 to 400°F (-54 to 204°C)
Full Cure Time..... 24 hours
Pin/Collar Strength 2000 psi
..... 13.79 N/mm²

FEATURES

- No mixing
- For use on assemblies with gaps up to 0.010" in diameter
- Restores fit to worn assemblies
- Prevents fretting and corrosion
- Allows the use of slip fit or press fit
- No curing outside of joint

TYPICAL APPLICATIONS

- Cylinder sleeves
- Bearings and bushings
- Woodruff keys
- Valve guides
- Valve seats
- Liner assemblies

PERFORMANCE OF CURED ADHESIVE

	Inch-pounds	Newton meters
Breakaway Torque	50 to 150	5.65 to 16.95
Prevailing Torque	200 to no Limit	22.60 to no limit

DESCRIPTION

Dynatex® Green High Strength SleeveLocker is a high strength anaerobic retaining and locking adhesive, which develops extremely high strength. It is used to bond cylindrical parts; may be applied to retain pulleys, gears, rotors and shafts, as well as to secure bushings, bearings and housing plugs. *Dynatex® Green High Strength SleeveLocker* will also augment shrink and press fit assemblies in high-heat and high-friction environments. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration.

SETTING TIME (68°F, 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

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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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