

### GREEN HIGH STRENGTH PNEUMATIC/HYDRAULIC LOW VISCOSITY SEALANT PART NO. 46454

#### DESCRIPTION

*Dynatex® Green High Strength Pneumatic/Hydraulic Sealant* 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) .....	160 cP
Flash Point (TCC) .....	Above 200°F
Gap Fill .....	.005"
Corrosivity .....	None
Toxicity .....	Low
Specific Gravity (g/cc) .....	1.09
Shelf Life @ 40°F .....	1 year unopened
Military Specifications .....	Mil-R-46082B Type I
Curing Properties .....	Depends on environmental conditions and the substrates used.

##### Polymer (Cured)

Retaining Strength .....	High
Service Temperature Range .....	-75°F to 400°F
Appearance .....	Green solid
Shear Strength (steel nuts and bolts) .....	3000 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 Pneumatic/Hydraulic Sealant* 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.

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**SETTING TIME (68°F, 65% R.H.)**

<b>Substrate</b>	<b>Set time/Full cure</b>
Steel	15-30 min/24 hrs
Zn Dichromate	45-60 min/24 hrs
Aluminum	20-45 min/24 hrs

**PERFORMANCE OF CURED MATERIALS**

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

	<b>Average Value</b>	<b>Range</b>
Breakaway Torque	175 in. lbs.	100-250 in. lbs.
Prevailing Torque	270 in. lbs.	180-270 in. lbs.

**CHEMICAL RESISTANCE**

Sheer strength on steel after 500 hours.

<b>Solvent</b>	<b>% Strength Retained</b>
Motor Oil	100
Unleaded Gasoline	100
Brake Fluid	100
Ethanol	100
Acetone	100
Water/Glycol Mix	90

**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.

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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 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*

350 Ring Road Elizabethtown, Kentucky 42701 USA (800) 999-2937 TEL (270) 769-5557 FAX (270) 769-6418  
Outside U.S. TEL +1(270) 769-5557 FAX +1(270) 769-6418  
Email: sales@dynatexinc.com Website: www.dynatexinc.com