

GREEN HIGH STRENGTH SLEEVELOCKER MEDIUM VISCOSITY PART NO. 49474

PHYSICAL PROPERTIES

Monomer (Liquid)

| | |
|-------------------------------|---|
| Base Compound | Dimethacrylate Ester |
| Color | Green |
| Viscosity (cP @ 68°F)..... | 500 cP |
| Flash Point (TCC) | >200°F |
| Gap Fill | .010" |
| Corrosivity | None |
| Toxicity..... | Low |
| Specific Gravity (g/cc)..... | 1.1 |
| Shelf Life @ 40°F..... | 1 year unopened |
| Military Specifications | Mil-S-46082B - Type II |
| Curing Properties..... | Depends on environmental conditions and the substrates used |

Polymer (Cured)

| | |
|--|----------------|
| Locking Strength | Very High |
| Service Temperature Range | -75°F to 450°F |
| Appearance..... | Green liquid |
| Shear Strength (steel nuts and bolts)..... | 4500 psi |
| Full Cure Time..... | 24 hours |



DESCRIPTION

Dynatex® Green High Strength Sleeve Retainer is a high strength anaerobic threadlocking material that cures between engaged threads to form a unitized assembly that resists virtually all leakage, shock and vibration. 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. The high prevailing torque provides vibration resistance to adjustment screws. Ideal for all threaded engagements less than or equal to 1/2 inch in diameter. *Dynatex® Green High Strength Sleeve Retainer* can also fill porosity in welds, castings and powder metal parts. Excellent chemical resistance with a temperature resistance range from -65°F to 350°F (-54°C to 177°C).

FEATURES

- No mixing
- For use on assemblies with gaps up to 0.007" 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 MATERIALS

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

| | Average Value | Range |
|-------------------|---------------|-----------------------|
| Breakaway Torque | 100 in. lbs. | 50-150 in. lbs. |
| Prevailing Torque | 300 in. lbs. | 200-no limit in. lbs. |

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 | 20-60 min/24 hrs |
| Aluminum | 20-60 min/24 hrs |

CHEMICAL RESISTANCE

Shear strength on steel after 500 hours.

| Solvent | % Strength Retained |
|-------------------|---------------------|
| 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 AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), **Dynatex® Green High Strength SleeveLocker** 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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