

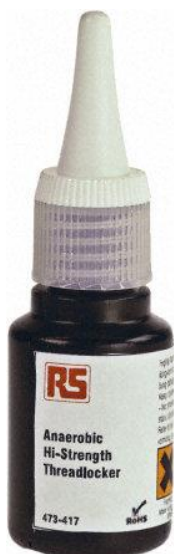


ENGLISH

Datasheet

Green Pipe & Thread Sealant Liquid For Jointing

RS Stock number [473-417](#)



Description:

It is a single component, very high strength anaerobic retaining compound. It comes in 10 ml bottles.

Applications:

The product is specially formulated for bonding cylindrical parts, to give very high strength bonds. Typical applications include locking sleeves onto shafts. It is designed to augment the strength of press fit and slip fit assemblies. Once applied, parts slip together easily, lubricated by the adhesive. The product also prevents corrosion of assembled parts.



Properties:

Chemical Type:	Dimethacrylate / Triacrylate
Appearance:	Green
Specific Gravity:	~ 1.08
Viscosity (cPs):	Range: 1800 – 3300, Typical: 2500
Breakaway Torque (N/m):	Range: 25 – 42, Typical: 30
Prevail Torque (N/m):	Range: 25 – 42, Typical: 32
Shear Strength (N/mm ²):	Range: 17 – 37, Typical: 27
Initial Fixture Time (mins):	≥ 15
Full Cure (hours):	24
Flash Point (°C):	> 100
Shelf Life at 20 °C (months):	12
Max Gap Fill (mm):	0.25
Temperature Range (°C):	-50 to 150 (continuous)

Chemical / Solvent Resistance:

The anaerobics exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen or chlorine lines.

Cure Speed vs Temperature:

All figures relating to cure speed are tested at 21 °C. Lower temperatures will result in slower cure. Heating the assembled parts accelerates the curing process. Activators should be used when the temperature is below 5 °C.

Cure Speed vs Substrate:

Cure speed and strength vary according to the substrates. When used on mild steel and brass components anaerobic adhesives will reach full strength more rapidly than more inert materials such as stainless steel and zinc dichromate.

Activators may be used to accelerate cure speed.

Anaerobic adhesives only cure in the absence of air and with metal part activation.



Cure Speed vs Bond Gap:

The size of the bond gap greatly affects the speed of cure of anaerobic adhesives. The larger the gap between surfaces, the slower the cure speed. Maximum recommended gap for the product is 0.25 mm, which will give approximately the cure schedule as detailed in the properties table.

Cure Speed vs Activator:

Where speed of cure is too slow or the bond gap very large, an anaerobic activator may be used to accelerate cure speed. The use of an accelerator may reduce bond strength by 30%.

Environmental Resistance:

Hot Strength:

These adhesives are suitable for use at temperatures up to 150°C. At 130°C the bond will be approximately 50% of the strength at 21°C.

Heat Ageing:

The product retain over 90% of full strength when heated to 100°C for 90 days and then cooled and tested at 21°C.

Curing Performance:

Typical curing speed as % of final strength.

15 mins	~ 10 % strength
45 mins	~ 50% strength
24 hours	100% strength

Storage:

Optimal storage conditions are between 8 °C and 21 °C. Storage outside this temperature range can adversely affect product properties and may affected the stated shelf-life.



Directions for use:

This product is suitable for high strength retaining applications that require medium gap filling. Ensure parts are clean and dry and free from grease or oil. Apply adhesive to all the engaged area. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint.

Product normally hand applied from the bottle or tube. Dispensing systems are available for high volume assembly applications.

General Information:

Product is packed in bulk (≥ 5 kg) and has a shelf-life of 6 months. The material must be filled into smaller bottles / tubes within this time period.

This product is not recommended on certain plastics as stress cracking can sometimes result. Some anti corrosion chemicals inhibit the cure system in this type of anaerobic.

Trials are recommended to establish whether cleaning of the parts is necessary. Activator may be required on plated parts.