

**ADHESIVE R&D**’s anaerobic adhesive’s and sealants represent the latest generation in anaerobic chemistry. Anaerobic threadlockers remain liquid when they are exposed to the oxygen in air, but in the lack of air, (or anaerobic environment) these products quickly polymerize and fill the inner space between the surfaces. In a continuous quest to improve the performance of anaerobic adhesive’s and sealants, **ADHESIVE R&D** works with leading edge engineers to push the chemistry forward, to increase cure speeds and bond strengths, and to design products that are able to cure on contaminated or inert surfaces and yet remain stable without special handling.

**20 GREEN™** is a very high viscosity, high strength, retaining compound. It has excellent high temperature resistance and should be used where higher temperatures (400°F) will be encountered.

**20 GREEN™** was developed for bonding mating cylindrical parts such as bushings, bearings, pulleys and hubs onto shafts and splines. The high viscosity nature of 20RC makes it ideal for augmenting the strength of press fits using powder medal parts, for filling larger gaps, and thread locking larger fasteners.

## PHYSICAL PROPERTIES

Composition	Anaerobic Methacrylates
Color	Green
Fluorescence	Under Blue Light
Viscosity	8000 cps
Specific Weight	1.05
Flash Point	>100°F
Solvent Content	None
Shelf Life @ 72°F	2 years

## CURING PROPERTIES

Handling	5 minutes
Functional Cure Time	1-2 hours
Full Cure	8-10 hours
Locking Torque*	
Breakaway	250-350 inch lb's
Prevailing	250-350 inch lb's
Locking Shear	3-4000 PSI
Temperature Range	150°C

\* Per ASTM D5363 Specification.  
3/8-16 plain finish cap screws and nuts.  
Larger fasteners will increase surface area and breakaway torque.

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Rev 01/03