

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.

80 GREEN™ is a medium viscosity high strength retaining compound. **80 GREEN™** bonds bushings, bearings, and gears to shafts, creating a plastic shim which seals the joint, prevents corrosion, and ultimately protects the shaft. It is also an excellent choice for high strength thread locking on medium size fasteners where high breakaway torques are required.

PHYSICAL PROPERTIES

Composition	Anaerobic Methacrylates
Color	Green
Fluorescence	Under Blue Light
Viscosity	1500 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.
80 Green™ meets ASTM D5363 AN0421 and Mil-S-46082 TYPE III.

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