

**ADHESIVE R&D**<sup>®</sup>'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**<sup>®</sup> 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.

**90 GREEN**<sup>™</sup> is a medium strength , very low viscosity, wicking grade threadlocker and porosity filler. Use **90 GREEN**<sup>™</sup> on applications requiring a fast setting anaerobic product to seal and lock small screws and threaded fasteners. **90 GREEN**<sup>™</sup> is ideal in applications where additional torque can not be applied to a delicate fastener, but greater off torque is desired. Because of it's ability to wick by capillary action, **90 GREEN**<sup>™</sup> can be applied to small fasteners that have already been assembled. It is also the perfect product for sealing porosities in welds and cast parts.

**PHYSICAL PROPERTIES**

<b>Composition</b>	Anaerobic Methacrylates
<b>Color</b>	Green
<b>Fluorescence</b>	Under Blue Light
<b>Viscosity</b>	15 cps
<b>Specific Weight</b>	1.05
<b>Flash Point</b>	>100°F
<b>Solvent Content</b>	None
<b>Shelf Life @ 72°F</b>	2 years

**CURING PROPERTIES**

<b>Handling</b>	5 minutes
<b>Functional Cure Time</b>	1-2 hours
<b>Full Cure</b>	8-10 hours
<b>Locking Torque*</b>	
<b>Breakaway</b>	20-135 inch pounds
<b>Prevailing</b>	200-350 inch pounds
<b>Locking Shear</b>	3-4000 PSI
<b>Temperature Range</b>	400°F

\* Per ASTM D5363 Specification.  
 3/8-16 plain finish cap screws and nuts.  
 Larger fasteners will increase surface area and breakaway torque.  
 90 Green<sup>™</sup> meets ASTM D5363 AN0261 and Mil-S-46163 TYPE III GRADE R.

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