

# TECHNICAL DATA SHEET



**Cyclo Industries, Inc**

**401 Maplewood Dr • Jupiter, FL 33458 • 561-775-9600**

**Extreme Temperature Retaining  
Compound-Green**

**C-62050**

## PRODUCT DESCRIPTION

Cyclo® Extreme Temperature Retaining Compound-Green is a one component anaerobic retaining adhesive for cylindrical joints. It is a green colored liquid resin that hardens and cures in the absence of air. This product self-hardens into a tough plastic material when it is confined between close-fitting metal parts. It is used to bond cylindrical fitting parts, particularly where temperature resistance above 200°C is required.

## PRODUCT BENEFITS

- No mixing
- No curing outside of joint
- Prevents fretting and corrosion
- Allows the use of slip fit or press fit
- For use on assemblies with gaps up to 0.015" diametral

## TYPICAL APPLICATIONS

- Pump housing sleeves
- Bearings in various close fitting applications
- Locating pins in radiator and cooling assemblies

## DIRECTIONS FOR USE

1. Remove any grease or oil by using compliant Cyclo® Brake & Parts Cleaner.
2. For slip fitted assemblies, apply adhesive around the leading edge of the collar and use a rotating motion during assembly.
3. For press fits, adhesive should be applied thoroughly to both bond surfaces and assembled at high press-on rates.
4. For shrink fitted assemblies, the adhesive should be coated onto the pin; the collar should then be heated to create sufficient clearance for free assembly.
5. For faster cure rates, use Cyclo® C-930 Surface Preparation on both surfaces.
6. Parts should not be disturbed until sufficient handling strength is achieved.
7. Any material that is on the outside of the assembly will not cure. Wipe off with a dry cloth.

## For Cleanup

1. Residual liquid films outside the joints are readily soluble in compliant Cyclo® Brake & Parts Cleaner.
2. Cured product can be removed with a combination of soaking in Cyclo® Gasket Remover and mechanical abrasion such as a wire brush.

## For Disassembly

1. Apply localized heat to assembly to approximately 260°C(500°F). Disassemble while hot.

## For Reassembly

1. Remove any loose product from the assembly.
2. Apply primer to mating parts.
3. Assemble as per directions.

## PROPERTIES OF UNCURED MATERIAL

	Typical Value
Appearance	Green liquid
Specific Gravity @ 77°F	1.16
Viscosity @ 25°C, Brookfield RVF Spindle 3@ 20 rpm, cps	8500
Flash Point, COC, °C (°F)	>93(>200)
Cure Speed (steel/steel) Fixture – Full cure -	1 hour 24 hours

## PERFORMANCE OF CURED MATERIAL

	Value
Temperature Resistance °C(°F)	-54 to +232 (-65 to +450)
Shear Strength –	3900PSI
Corrosivity -	None (Slightly acidic, may discolor some metals.)

## TYPICAL CURING PERFORMANCE

### Cure speed vs. substrate

The rate of cure will depend on the material used. Cyclo® Extreme Temperature Retaining Compound-Green will react faster and stronger with **Active Metals**. However, **Inactive Metals** will require the use of an activator (Cyclo® C-930 Surface Preparation) to obtain maximum strength and cure speed at room temperature.

Active Metals	Inactive Metals
Soft Steel Iron	Bright Platings
Copper	Anodized Surfaces
Brass	Titanium
Manganese	Zinc
Bronze	Pure Aluminum
Nickel	Stainless Steel
Aluminum Alloy	Cadmium

The graph below shows the breakaway strength developed with time on 3/8" - 16 Grade 5 bolts and Grade 2 nuts compared to different materials.

**DISCLAIMER:** Cyclo Industries, Inc. provides the information contained herein in good faith but makes no representation as to its comprehensiveness or accuracy. Individuals receiving this information must exercise their independent judgment in determining its appropriateness for a particular purpose. Cyclo Industries, Inc. makes no representations or warranties, either expressed or implied, of merchantability, fitness for a particular purpose with respect to the information set forth herein or to the product to which the information refers. Accordingly, Cyclo Industries, Inc. will not be responsible for damages resulting from use of or reliance upon this information.

# TECHNICAL DATA SHEET



**Cyclo Industries, Inc**

**401 Maplewood Dr • Jupiter, FL 33458 • 561-775-9600**

**Extreme Temperature Retaining  
Compound-Green**

**C-62050**

## Material Safety Data Sheet, (MSDS).

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm

compatibility of the product on such substrates.

## ORDERING INFORMATION

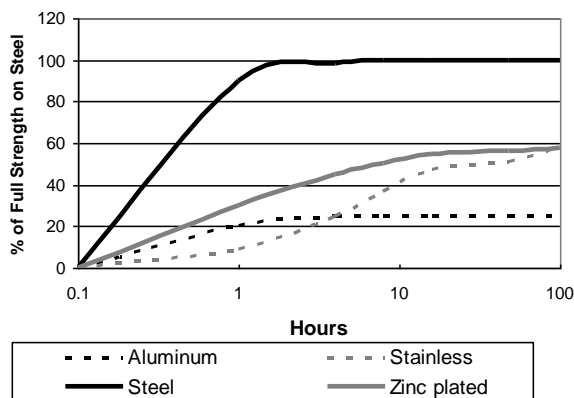
C-62050

50 ml bottle

## STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

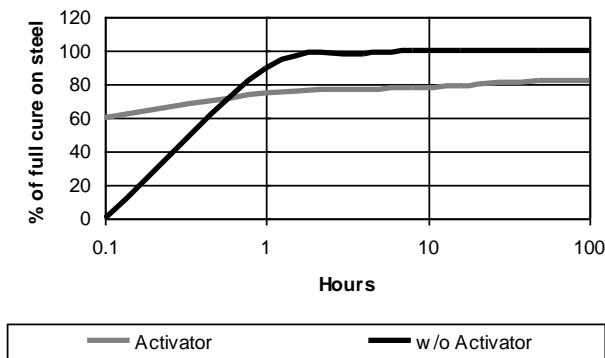
### Cure Speed vs Substrate



## Cure speed vs. activator

Where cure speed is unacceptably long, or large gaps are present, applying an activator (Cyclo® C-930 Surface Preparation) to the surface will improve cure speed. A 3/8-16 steel nut and bolt assembly will fixture in about 5 minutes using an activator, while fixturing will occur in about 20 minutes without an activator. Full cure in 24 hours for both procedures. The graph below shows the breakaway strength developed with time using Cyclo® C-930 Surface Preparation.

### Cure Speed vs Activator



## GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. For safe handling information on this product, consult the**

**DISCLAIMER:** Cyclo Industries, Inc. provides the information contained herein in good faith but makes no representation as to its comprehensiveness or accuracy. Individuals receiving this information must exercise their independent judgment in determining its appropriateness for a particular purpose. Cyclo Industries, Inc. makes no representations or warranties, either expressed or implied, of merchantability, fitness for a particular purpose with respect to the information set forth herein or to the product to which the information refers. Accordingly, Cyclo Industries, Inc. will not be responsible for damages resulting from use of or reliance upon this information.