

Product Description

VIBRA-TITE 530 is a low viscosity, general purpose, anaerobic retaining compound used for press-fit and tight-clearance, and slip-fit metal applications. The product performs on aluminum, steel, plated, stainless steel, and special alloy parts. VIBRA-TITE 530 exhibits good temperature and solvent resistant. VIBRA-TITE 530 can be used where lubricity is needed to press fit parts or to create an air-tight seal on cylindrical assemblies. This product cures rapidly on all metal surfaces.

Typical Applications

- Locks keys & splines
- Locks bearings in place preventing spin-out
- Bonds rotor to shaft in low horsepower motors
- Augments press fits
- Locks bushings & sleeves in housings & on shafts
- Restores the fit to worn assemblies or out-of-tolerance parts

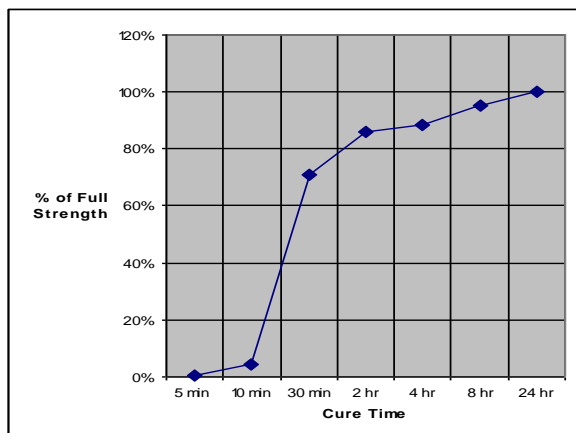
Properties of Uncured Material

Chemical Type	Anaerobic
Appearance	Green
Toxicity	Low
Solids	100%
Viscosity	100-150cps
Specific Gravity	1.04

Typical Curing Performance

Cure Speed

The cure rate depends on temperature and substrate. The graph below shows the shear strength developed with time on steel pins and collars.



Performance of Cured Material

	Typical Values
Fixture Time 72°F	15-20 min @
Full Cure Time	24 hrs @ 72°F
Temperature Range	-60°F to 350°F (-51°C to 200°C)

Shear Strength

Cold rolled steel	3000 psi
Aluminum	600 psi

Static shear strength was measured on cylindrical parts with a 0.002" diametrical clearance.

Environmental and Fluid Resistance

(Shear strength values)

	Typical Values
Heat age	100%
Engine oil @ 150°C	92%
Brake fluid @ 150°C	88%
ATF @ 150°C	75%
50/50 water/ ethylene glycol @ 120°C	55%
Water @ 100°C	62%
Gasoline @ 25°C	100%
Diesel fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	55%

Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

Compatible Primers

Primers such as Vibra-TITE Excel 611 (Primer N) or Excel 612 (Primer T) can be used to speed the fixture time of the adhesive. Fixture times can improve by as much as 50%. The use of primers can result in lower strength and performance should be tested after full cure.

Presentation

Bottles.....2ml, 10ml, 50ml, 250ml and liter



General Information

Storage

Product should be stored in a cool and dry location at temperatures between 14°F (-10°C) to 86°F (30°C). Shelf life is 2 years from date of manufacture when stored at 72±8°F (22±4°C).

Note

Vibra-TITE 530 is a low viscosity rapid curing liquid which augments press fit and slip fit applications. Product conforms to MIL-R-46082, ASTM D-5363, GM-1183024.

Health & Safety in use

IRRITANT: Contains Methacrylate Esters which may irritate eyes, respiratory organs and skin. In case of contact with the skin, wash immediately with plenty of water.