



**Product Description**

Vibra-Tite 538 High Strength Retaining Compound is a single part, medium viscosity, high strength anaerobic resin used for bonding rigid assemblies of all types. This material can be used effectively to increase the strength of most mechanical assemblies.

**Typical Applications**

Vibra-Tite 538 can be used in a broad variety of applications such as:

- Locking keys and splines
- Eliminating backlash in worn assemblies
- Locking bearings in place, preventing spin out
- Bonding rotor to shaft in low horsepower motors
- Locking bushings and sleeves in housings and on shafts
- Restoring the fit to worn assemblies or out-of tolerance pans

**Instructions for Use**

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

**Procedure for Application**

Product is normally hand applied from the bottle onto threaded parts.

**Compatible Primers**

Primers such as Vibra-Tite Excel 611 (Primer N) or Excel 612 (Primer T) can be used. The use of primers can result in lower strength and performance should be tested after full cure.

**Technical Features**

Resin:.....Dimethacrylate  
 Color:.....Green  
 Fixture Speed w/Primer.....<5 minutes  
 Fixture Speed w/o Primer 10-60 min @ 77°F  
 Viscosity.....2100-2900 cps  
 Gap Fill.....0.015"  
 Max. Operating Temp..... -65°F to +300°F

**Cured Performance**

Full Cure Time: 24 hours @ 68°F  
Shear Strength: >3500 psi

**Presentation**

Bottles.....50 ml, 250 ml & 1L.

**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**

Using Vibra-TITE 538 is easy, the product is color coded green and once cured, it seals and vibration proofs the assembly, giving high compressive shears.