

## 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

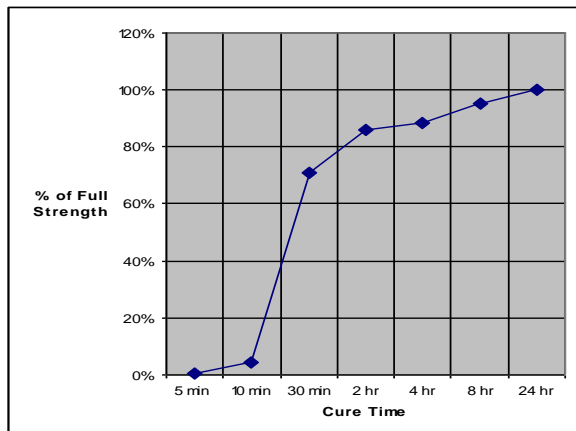
## Properties of Uncured Material

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.