



# Kem Vibra-TITE 538

High Strength Retaining Compound



## Product Description

Kem 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:

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

## Usage Instructions

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 Kem 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

## Technical Features

#	Parameter	Specifications
1	Resin Type	Dimethylacrylate
2	Color	Green
3	Fixture Speed w/Primer	< 5 min.
4	Fixture Speed w/o Primer @ 25°C	10 – 60 min.
5	Viscosity, cps.	2100 – 2900
6	Gap Fill	0.015"
7	Shelf Life, Months @ 20°C	12
8	Operating Temperature, Max°C	-50 to 150

## Performance of Cured Material

Full Cure Time @ 20°C	24 Hrs.
Shear Strength	> 3500 Psi

**Packing** – Tubes – 50 ml, 250 ml and 1 L Bottle

## General Information

### Storage

Product should be stored in a cool and dry location at temperatures between -10 °C to 30 °C. Optimal storage is 22±4°C. Shelf life is 18 months from date of manufacture when stored at 22±4°C.

### Note

Using Kem 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.

### Health & Safety

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

### NOTE TO USER

The information contained in this document while based on evidence and reliable methods can not be considered exhaustive. This information are current to the date of issuance of this data sheet.

The user, under its own responsibility, shall respect all the existing provisions on hygiene and safety and shall verify every time the features and the specific and appropriate way to use the product, cause the respect of the provisions is not under producer's direct control. The manufacturer does not guarantee nor assume any liability or responsibility for whatsoever harm that might result from a misuse of the product or for damages that have arisen after the product's distribution.

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