



# Kem Vibra-TITE 541

High Strength Retaining Compound



### Product Description

Kem Vibra-TITE 541 High Strength Retaining Compound is a single part, high 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

Kem Vibra-TITE 541 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
- Augments press fits
- Locks bushings & sleeves in housings & on shafts
- Restores the fit to worn assemblies or out-of-tolerance parts

This high viscosity product is not recommended for extremely close or interference fits. For large gaps, use of Vibra-TITE primer to ensure a fast, full cure is advisable.

### Usage Instructions

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

### Procedure for Application

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

### Technical Features

#	Parameter	Specifications
1	Resin Type	Anaerobic
2	Color	Green
3	Toxicity	Low
4	Solids	100%
5	Viscosity, cps, Brookfield 3 @ 20 rpm	1370
6	Specific Gravity	1.1
7	Shelf Life, Months @ 20°C	12
8	Operating Temperature, Max°C	-50 to 177

### Performance of Cured Material

Fixture Time @ 23°C	15 – 20 min.
Full Cure Time	24 Hrs. @ 23°C

### Shear Strength

Cold rolled steel 3200 psi

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

### Environmental and Fluid Resistance (Shear Strength Value)

Heat Age	105%
Engine Oil @ 150°C	100%
Brake Fluid @ 150°C	82%
ATF @ 150°C	80%
50/50 water Ethylene Glycol @ 150°C	80%
Water @ 100°C	80%
Gasoline @ 25°C	100%
Diesel Fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	95%

**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

The high strength of this material may require heat to disassemble.

#### 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.