

Product Description

Kem 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. Kem 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 airtight 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

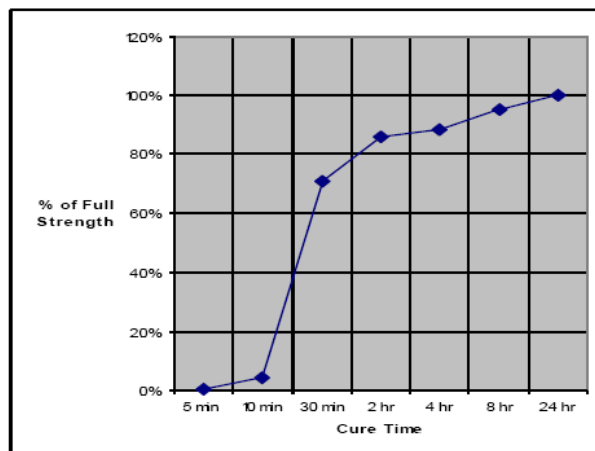
Technical Features

#	Parameter	Specifications
1	Resin Type	Anaerobic
2	Color	Green
3	Toxicity	Low
4	Solids	100%
5	Viscosity, cps.	100 – 150
6	Specific Gravity	1.04
7	Shelf Life, Months @ 20°C	12
8	Operating Temperature, Max°C	-50 to 200

Curing Schedule and 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



Performance of Cured Material

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

Heat Age	100%
Engine Oil @ 150°C	92%
Brake Fluid @ 150°C	88%
ATF @ 150°C	75%
50/50 water Ethylene Glycol @ 150°C	55%
Water @ 100°C	62%
Gasoline @ 25°C	100%
Diesel Fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	55%

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.

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

Packing – Tubes – 50 ml, 250 ml,

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

Kem 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

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.