



Product Description

Vibra-TITE 535 Gel Retaining Compound is an anaerobic retaining adhesive for all types of cylindrical assemblies. Cured performance shows controlled high strength with good temperature and solvent resistance against water and non-polar solvents. This product cures rapidly on plated, oily metal surfaces or inactive surfaces.

Typical Applications

Replaces press fit assemblies and keyways. Used on gear box bolts/drive shaft, bearing applications.

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:.....Modified acrylate
Color:.....Green
Fixture Speed w/Primer.....<1 seconds
Fixture Speed w/o Primer 5-10 min @ 77°F
Viscosity.....Gel
Gap Fill.....0.015"
Max. Operating Temp..... -65°F to +300°F

Cured Performance

Full Cure Time: 24 hours @ 68°F
Typical Breakaway Strength:
 3/8 Phos-oil 170 – 300 lb-ins
Typical Prevailing Strength:
 3/8 Phos-oil 100 – 350 lb-ins

Presentation

Tubes.....50ml, 250ml

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 535 is easy, the product is color coded green and once cured, it seals and vibration proofs the assembly, giving high compressive shears.