

Product Description

Vibra-TITE 546 is a quick fixturing high strength flexible, anaerobic retaining compound designed to bond metal cylindrical assemblies. The product performs on aluminum, steel, plated, stainless steel, and special alloy parts. 546 exhibits excellent temperature and solvent resistant.

Typical Applications

Locks shaft and hubs together for gears, bearing, bushings. Bonds pins, adaptors, plugs, specially designed to bond ring gears to housings.

Properties of Uncured Material

Chemical Type	Anaerobic
Appearance	Green
Toxicity	Low
Solids	100%
Viscosity @ 25°C, cP	
Brookfield RVT,	
Spindle 5 @ 20 rpm	1250 to 2700
Specific Gravity	1.16

Performance of Cured Material

	Typical Values
Fixture Time	1-5 min @ 72°F
Full Cure Time	24 hrs @ 72°F
Temperature Range	-60°F to 300°F (-51°C to 150°C)

Shear Strength

After 1 hour cure	
Steel pins and collars	>2000 psi
After 24 hour cure	
Steel pins and collars	>3000 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	98%
Brake fluid @ 150°C	100%
ATF @ 150°C	80%
50/50 water/ethylene glycol @ 120°C	80%
Water @ 100°C	85%
Gasoline @ 25°C	100%
Diesel fuel @ 25°C	100%
Ethyl Alcohol @ 25°C	95%

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

The data are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.

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.