



### **Product Description**

Vibra-TITE 542 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**

Vibra-TITE 542 can be used in a broad variety of applications such as:

- Locks keys and splines
- Eliminates backlash in worn assemblies
- Locks bearings in place, preventing spin out
- Bonds rotor to shaft in low horsepower motors
- Locks bushings and sleeves in housings and 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.

### **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 parts.

### **Compatible Primers**

Vibra-TITE 612 (Primer T) can be used. The use of primers can cause loss of strength and performance should be tested.

### **Technical Features**

Resin:.....Dimethylacrylate  
 Color:.....Green  
 Fixture Speed w/Primer.....<5 minutes  
 Fixture Speed w/out Primer..10-60 min. @77°F  
 Viscosity.....2000 cps  
 Gap Fill.....0.015"  
 Max. Operating Temp....-65°F to +300°F

### **Cured Performance**

Full Cure Time.....24 hours @ 68°F  
 Shear Strength.....>4000 psi

### **Presentation**

Bottles.....10ml, 50ml, 250ml and liter

### **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 high strength of this material may require heat to disassemble. Product conforms to MIL-R-46082, ASTM D-5363.

#### **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.