VIBRA-TITE IS A REGISTERED TRADEMARK OF ND INDUSTRIES, INC.

## Product Description

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. 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 air-tight 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

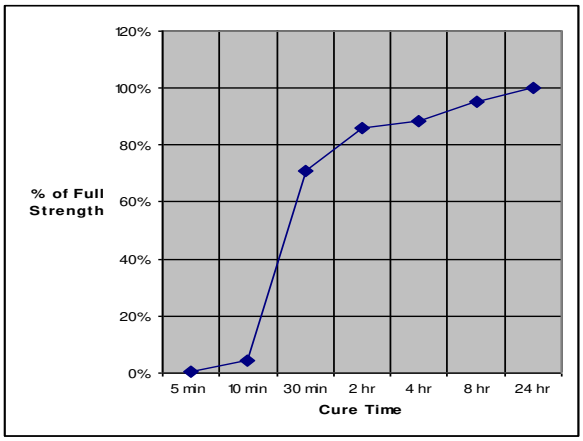
## Properties of Uncured Material

| | |
|---|---|
| Chemical Type | Anaerobic |
| Appearance | Green |
| Toxicity | Low |
| Solids | 100% |
| Viscosity | 100-150cps |
| Specific Gravity | 1.04 |

## Typical Curing 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 collars.




## Performance of Cured Material

| | Typical Values |
|---|---|
| Fixture Time | 15-20 min @ 72ºF |
| Full Cure Time | 24 hrs @ 72ºF |
| Temperature Range | -60ºF to 300ºF (-51ºC to 150ºC) |

## 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 values)**

| | Typical Values |
|---|---|
| Heat age | 100% |
| Engine oil@ 150ºC | 92% |
| Brake fluid @ 150ºC | 88% |
| ATF @ 150ºC | 75% |
| 50/50 water/ ethylene glycol @ 120ºC | 55% |
| Water @ 100ºC | 62% |
| Gasoline @ 25ºC | 100% |
| Diesel fuel @ 25ºC | 100% |
| Ethyl Alcohol @25ºC | 55% |

## Instructions for Use

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

## Compatible Primers

Primers such as 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.

## Presentation

Bottles…..2ml, 10ml, 50ml, 250ml and liter

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# 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

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 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.