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

Product Description

Vibra-TITE 541 High Strength Retaining Compound is a single part, medium 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 541 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.

Properties of Uncured Material

Chemical Type	Anaerobic
Appearance	Green
Toxicity	Low
Solids	100%
Viscosity @ 25ºC, cP Brookfield RVT, Spindle 3 @ 20 rpm	750-1650cPs
Specific Gravity	1.1

Performance of Cured Material

	Typical Values
Fixture Time	5-10 min @ 72ºF
Full Cure Time	24 hrs @ 72ºF
Temperature Range	-60ºF to 350ºF (-51ºC to 177ºC)

Shear Strength

Cold rolled steel	3500 psi
Aluminum	2700 psi

Static shear strength was measured on cylindrical parts with a 0.002” diametrical clearance.

Environmental and Fluid Resistance

(Relative Shear Strength)

	Typical Values
Heat age @150ºC	105%
Engine oil@ 150ºC	100%
Brake fluid @ 150ºC	82%
ATF @ 150ºC	80%
50/50 water/ethylene glycol @ 120ºC	80%
Water @ 100ºC	80%
Gasoline @ 25ºC	100%
Diesel fuel @ 25ºC	100%
Ethyl Alcohol @25ºC	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 high strength of this material may require heat to disassemble.

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.