

DELO-ML® 5302

Anaerobic adhesive, high strength

Use

- fixing: axisymmetric components, e. g., bearings or sockets
- securing and sealing: thread connections
- sealing: thread connections

Base

- methacrylic ester
- one-component, solvent-free

Curing

- anaerobic, i. e., by exclusion of air and under metal influence
- at room temperature

Properties

- low-viscous, capillary setting for reliable bonding
- sealing also after assembly
- reduced curing times with activator DELO-QUICK 5002
- excellent curing even on highly passivated surfaces by adding DELO-TOP 5009 or by activating the surfaces with DELO-QUICK 5002
- specific high strength, difficult to remove

Processing

- directly from the bottle
- automatic processing with DELO dispensing units DELOMAT 100 and DELOMAT 400
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- DELOTHEN cleaners are recommended for the optimal preparation of bonding areas
- thread connections must be tightened well

Technical data

Color	green
Maximal clearance (D-d) [mm]	0.05
optimum clearance (D-d) [mm]	0.01
Thread size	≤ M 10
Viscosity [mPas] Brookfield at 23 °C	15
Curing time until firmness to touch [min] at room temperature (approx. 23 °C), anaerobic on zinc-phosphated screws	5 - 10

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Curing time until firmness to touch [min] at room temperature (approx. 23 °C), with DELO-QUICK 5002 (accelerator for DELO-ML) on V2A screws	8 - 15
Curing time until final strength [h] at room temperature (approx. 23 °C), anaerobic on zinc-phosphated screws	24
Off-torque without Mon [Nm]	32
Off-torque with Mon 46 Nm [Nm] ISO 10964, screw M10/8.8	50
Compression shear strength [MPa] DIN 54452	25
Compression shear strength after 1 h [MPa] DIN 54452	18
Chemical resistance	very good
Recommended long-term temperature range of use [°C]	-60 to +150
Storage life in unopened original container up to 200 ml at room temperature (approx. 23 °C)	12 months

Instructions and advice

General

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this. It is the user's responsibility to test the suitability of the product for the intended purpose by considering all specific requirements. Type and physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions. The data and information provided are, therefore, no guarantee for specific product properties or the suitability of the product for a specific purpose.

Instructions for use

The instructions for use of DELO-ML are available on: www.DELO.de. We will be pleased to send them to you on demand.

Occupational health and safety

see material safety data sheet

Specification

see quality assurance test report