

### **DELO-ML® 5327**

Anaerobic adhesive, high strength

#### **Use**

- fixing: coaxial join parts, i. e. bearings or sockets
- locking and sealing: thread connections

#### **Base**

- urethanemethacrylester
- one-part, solvent-free

#### **Curing**

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

#### **Characteristics**

- low viscous setting
- by trying to untighten pre-stressed thread connections, screw can break
- reduced curing times with DELO-QUICK 5002 activator
- excellent curing even on highly passive surfaces by adding DELO-TOP 5009 or by activating 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
- surfaces to be bonded must be dry, free from dust, grease and other contaminations
- DELOTHEN cleaners are recommended for optimal preparation of surfaces to be bonded
- also suitable on slightly greasy surfaces
- thread connections must be well tightened

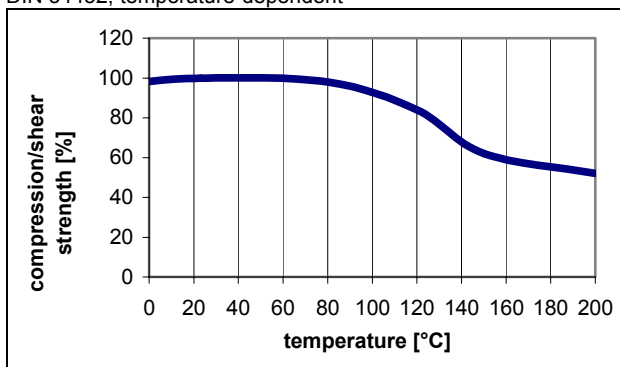
#### **Technical data**

Color	green
maximum clearance (D-d) [mm]	0.13
optimum clearance (D-d) [mm]	0.04
thread	≤ M 10
Viscosity [mPas] brookfield at 23 °C	300
Curing time until firmness to touch [min] at room temperature (approx. 23 °C), anaerobic on zinc phosphated screws	2 - 4

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<b>Curing time until firmness to touch [min]</b> at room temperature (approx. 23 °C), with DELO-QUICK 5002 (accelerator for DELO-ML) on V2A screws	approx. 20
<b>Curing time until final strength [h]</b> at room temperature (approx. 23 °C), anaerobic on zinc phosphated screws	24
<b>off-torque without Mon [Nm]</b>	50
<b>off-torque with Mon 46 Nm [Nm]</b> ISO 10964, screw M10/8.8	70
<b>Tensile shear strength Al/Al [MPa]</b> DIN EN 1465, sand-blasted join part thickness: 1.6 mm after 24 h at room temperature (ca. 23 °C)	approx. 11
<b>tensile/shear strength St/St [MPa]</b> DIN EN 1465, sand-blasted	approx. 16
<b>compression/shear strength [MPa]</b> DIN 54452	33
<b>compression/shear strength after 1 h [MPa]</b> DIN 54452	approx. 28

**compression/shear strength**  
DIN 54452, temperature-dependent



<b>chemical stability</b>	very good
<b>Recommended long-term temperature range of use [°C]</b>	-60 to +200
<b>Storage life</b> in unopened original container up to 200 ml at room temperature (approx. 23 °C)	6 months
<b>Storage life</b> at approx. +5 °C in unopened original container	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 instruction for use is available under following address: [www.DELO.de](http://www.DELO.de). If requested we will also be pleased to send it to you.

**Occupational health and safety**  
see material safety data sheet

**Specification**  
see quality assurance test report