

### **DELO-ML® 5549**

Anaerobic adhesive, adherent

#### **Use**

- fixing: coaxial components, e. g., bearings or sockets
- securing and sealing: thread connections
- bonding: metals, small surfaces and with a high fitting accuracy

#### **Base**

- methacrylic ester
- one-component, solvent-free

#### **Curing**

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

#### **Properties**

- ability to assume adhesive connections with bonding areas
- very good strengths and low roughness depth of the bonding areas
- when trying to unscrew prestressed thread connections, the screw can break
- reduced curing times on highly passivated surfaces by adding DELO-TOP 5009 or by activating the surfaces with DELO-QUICK 5002
- high strength, difficult to remove

#### **Processing**

- shake well before use
- 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	colorless
Maximal clearance (D-d) [mm]	0.25
optimum clearance (D-d) [mm]	0.08
Thread size	all threads
Viscosity [mPas] Brookfield at 23 °C	1000 thix
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	approx. 10 - 15
Curing time until final strength [h] at room temperature (approx. 23 °C), anaerobic on zinc-phosphated screws	24
Off-torque without Mon [Nm]	13
Off-torque with Mon 46 Nm [Nm] ISO 10964, screw M10/8.8	50
Tensile shear strength St/St [MPa]	approx. 13
Compression shear strength [MPa] DIN 54452	32
Compression shear strength after 1 h [MPa] DIN 54452	12
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](http://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