

### **DELO-ML® 5849**

Anaerobic- and light curing adhesive

#### **Use**

- suitable for the bonding of axisymmetric components as well as for the securing of screws and the sealing of threads
- difficult to remove
- adhesive leaking from the bonding gap can be cured in seconds with visible light
- therefore, firmness to touch can be reached faster
- if one of the components to be bonded is translucent, non-metals can also be bonded through polymerization
- DELO curing lamps generating radiation adjusted to the adhesives are available to initiate this reaction

#### **Base**

- dimethacrylate
- one-component, solvent-free
- dual-curing adhesive

#### **Curing**

- anaerobic, i. e., by exclusion of air and under metal influence
- with visible light in a wavelength range of 320 - 450 nm
- both curing mechanisms can be used in combination or separately
- at room temperature

#### **Properties**

- medium-viscous setting
- light-curing and anaerobic-curing
- visible adhesive in boundary areas can be cured with visible light
- 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	clear / brownish
Maximal clearance (D-d) [mm]	0.15
optimum clearance (D-d) [mm]	0.05

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Thread size	≤ M 18 / ≤ R 1
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
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. 5 - 10
Curing time until final strength [h] at room temperature (approx. 23 °C), anaerobic on zinc-phosphated screws	24
Curing time until final strength [s] at room temperature (approx. 23 °C), with DELOLUX 03, UVA intensity: 55 - 60 mW/cm <sup>2</sup> , DELOLUXcontrol layer thickness: approx. 0.5 mm	approx. 8
Off-torque without Mon [Nm]	37
Off-torque with Mon 46 Nm [Nm] ISO 10964, screw M10/8.8	50
Tensile shear strength St/St [MPa] DIN EN 1465, sand-blasted	approx. 13
Compression shear strength [MPa] DIN 54452	20
Compression shear strength after 1 h [MPa] DIN 54452	approx. 15
Chemical resistance	very good
Recommended long-term temperature range of use [°C]	-40 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