

# DELO®-ML VE 323114 (prospective 5199)

## 1C | anaerobic-curing

free of solvents | low-strength, unfilled

### Special features of product

- compliant with RoHS Directive 2015/863/EU

### Typical area of use

- 60 - 150 °C
- metal bondings
- screw locking and thread sealing

## Curing

Curing time

until initial strength at rt approx. +23 °C anaerobic on zinc-phosphated screws	5 - 10	min
until final strength at rt approx. +23 °C anaerobic on zinc-phosphated screws	24	h

## Processing

Storage life in unopened original container

up to <= 200 ml at 0 °C to +25 °C	3	month(s)
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## Technical properties

Color in cured condition in 0.1 mm layer thickness	yellow
Fluorescence	fluorescent

## Parameters

Density by the criteria of DIN 66137-2   liquid	1.10	g/cm³
Viscosity by the criteria of DIN 53019   liquid   Rheometer   Shear rate: 2 1/s   Gap: 500 µm	60000	mPa·s
Off-torque by the criteria of ISO 10964   <b>Steel, zinc-phosphated</b>   <b>Steel, zinc-phosphated</b>   at approx. +23 °C   24 h	5	N·m

Off-torque <i>by the criteria of ISO 10964   <b>Steel, zinc-phosphated</b>   <b>Steel, zinc-phosphated</b>   Tightening torque: 46 N·m   at approx. +23 °C   24 h</i>	44	N·m
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>Steel</b>   <b>Steel</b>   Pretreatment: sand-blasted   at approx. +23 °C   72 h</i>	2	MPa
Compression shear strength <i>by the criteria of ISO 10123   <b>Steel shaft</b>   <b>Steel hub</b>   at approx. +23 °C   1 h</i>	0.2	MPa
Compression shear strength <i>by the criteria of ISO 10123   <b>Steel shaft</b>   <b>Steel hub</b>   at approx. +23 °C   24 h</i>	5	MPa

**Converting table**

°F = (°C x 1.8) + 32	1 MPa = 145.04 psi
1 inch = 25.4 mm	1 GPa = 145.04 ksi
1 mil = 25.4 µm	1 cP = 1 mPa·s
1 oz = 28.3495 g	1 N = 0.225 lb

**General curing and processing information**

The curing time stated in the technical data was determined in the laboratory. It can vary depending on the adhesive quantity and component geometry and is therefore a reference value. Values measured after 24 h at approx. 23 °C / 50 % r.h., unless otherwise specified.

**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 customer's responsibility to test the suitability of a product for the intended purpose by considering all specific requirements and by applying standards the customer deems suitable (e. g. DIN 2304-1). Type, 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.

Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.

All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist. This product is still a development product and therefore subject to modifications.

**Instructions for use**

You can find further details in the instructions for use.

The instructions for use are available on [www.DELO-adhesives.com](http://www.DELO-adhesives.com).

We will be pleased to send them to you on demand.

**Occupational health and safety**

See material safety data sheet.

**Specification**

Nothing contained in this Technical Datasheet shall be interpreted as any express warranty or guarantee. This Technical Datasheet is for reference only and does not constitute a product specification. Please ask our responsible Sales Engineer for the applicable product specification which includes defined ranges. DELO is neither liable for any values and content of this Technical Datasheet nor for oral or written recommendations regarding the use, unless otherwise agreed in writing. This limitation of liability is not applicable for damages resulting from intent, gross negligence or culpable breach of cardinal obligations, nor shall it apply in case of death or personal injury or in case of liability under any applicable compulsory law.

DRAFT VERSION

**CONTACT**

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