DELO®-ML 5327

modified acrylate | 1C | anaerobic-curing
free of solvents | unfilled, high-strength

Special features of product
▪ compliant with RoHS Directive 2015/863/EU
▪ compliant with limits of VOC content in adhesive acc. to GB33372-2020

Typical area of use
▪ -60 - 200 °C
▪ screw locking and thread sealing

Curing
Curing time

<table>
<thead>
<tr>
<th>until initial strength</th>
<th>at rt approx. +23 °C</th>
<th>anaerobic on zinc-phosphated screws</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 - 4 min</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>until initial strength</th>
<th>at rt approx. +23 °C</th>
<th>with DELO-QUICK 5002 on V2A screws</th>
</tr>
</thead>
<tbody>
<tr>
<td>20 min</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Processing
Processing time

<table>
<thead>
<tr>
<th>in standard climate +23 °C / 50 % r. h.</th>
<th>28 d</th>
</tr>
</thead>
</table>

Storage life in unopened original container

<table>
<thead>
<tr>
<th>up to &lt;= 600 ml</th>
<th>at 0 °C to +25 °C</th>
<th>6 month(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>up to &lt;= 600 ml</td>
<td>at 0 °C to +10 °C</td>
<td>12 month(s)</td>
</tr>
</tbody>
</table>

Technical properties

<table>
<thead>
<tr>
<th>Color in uncured condition</th>
<th>green</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color in cured condition in 0.1 mm layer thickness</td>
<td>green</td>
</tr>
</tbody>
</table>

Parameters

<table>
<thead>
<tr>
<th>Density</th>
<th>liquid</th>
<th>1.1 g/cm³</th>
</tr>
</thead>
</table>
TECHNICAL DATASHEET

Viscosity
liquid | Viscosimeter
300 mPa·s

Off-torque
by the criteria of ISO 10964 | Stainless steel | Stainless steel | liquid
50 N·m

Tensile shear strength
by the criteria of DIN EN 1465 | Al | Al | Pretreatment: sand-blasted | liquid
11 MPa

Tensile shear strength
by the criteria of DIN EN 1465 | Steel | Steel | Pretreatment: sand-blasted | liquid
16 MPa

Compression shear strength
by the criteria of ISO 10123 | Steel shaft | Steel hub | 1 h
28 MPa

Compression shear strength
by the criteria of ISO 10123 | Steel shaft | Steel hub | at approx. +23 °C | 72 h
33 MPa

Compression shear strength after thermal storage, based on ISO 10123

Compression shear strength measured at the stated temperatures

Compression shear strength for determining the curing process
shock-to-hub bonding, substrates: steel-shaft/steel-hub, based on ISO 10123

Substrates: steel shaft / steel hub

at room temperature (approx. +23 °C)
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.

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All products provided by DELO are subject to DELO’s General Terms of Business. Verbal ancillary agreements are deemed not to exist.

Instructions for use

You can find further details in the instructions for use.

The instructions for use are available on 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

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