

**PRODUCT DESCRIPTION**

Delta 444 is an anaerobic gasket sealant, which develops medium strength in a short time. The compound cures in the absence of air between close fitting metals surfaces.

Delta 444 is a semi rigid, fast curing gasketing/sealant; seals close fitting joints between rigid metal faces and flanges. Provides resistance to low pressure immediately after assembly of flanges.

**APPLICATIONS**

- Typically used as a form-in-place on rigid flanged connections e.g. gearbox and engine castings, etc.
- Thixotropic nature reduces the migration of liquid product after application.

**ADHESIVE PROPERTIES**

Composition	Dimethacrylate Ester
Colour	Orange
Viscosity Brookfield RVT Spindle 7 @20 rpm	30,000 to 100,000 cps Thixotropic
Specific Gravity	1.10
Maximum diameter of Thread/Gap Filling	>0.20mm
Flash Point	> 93°C
Solvent content	None

**CURING PROPERTIES**

<b>Handling Cure Time</b>	
Unprimed Surfaces	1 to 12 hours
Primed Surfaces	15 mins to 2 hours
Compressive Shear Strength, ISO 10123: <b>After 24 hours at 22°C</b> Steel pins and collars	>6.0 N/mm <sup>2</sup> >870 psi
Lap Shear Strength, ISO 4587 Steel (grit blasted)	8.5 N/mm <sup>2</sup> 1,230 psi
Tensile Strength, ISO 6922 Steel (grit blasted)	5 N/mm <sup>2</sup> 725 psi
Temperature Range	-50°C to 200°C

PHYSICAL PROPERTIES	
Coefficient of Thermal Expansion ASTM D 696, K-1	80 x 10 <sup>-6</sup>
Coefficient of Thermal Conductivity ASTM C 177, W/(m-K)	0.10
Specific Heat, kJ/(kg-K)	0.30

CHEMICAL RESISTANCE			
Chemical	Temp	% Initial Strength Retained	
		500 hours	1000 hours
Acetone	22°C	100	95
Ethanol	22°C	90	90
Motor Oil	125°C	100	100
Gasoline	22°C	75	75
Brake Fluid	22°C	95	95
Water/Glycol	87°C	85	85

**DIRECTIONS FOR USE**

- For best results, clean all surfaces (external and internal) with D406 Surface Prep Cleaner and allow solvent to evaporate.
- If the material is inactive metal or the cure speed is too slow spray with Anaerobic Activator D405 and allow to dry.
- Apply manually as a continuous bead or by screen-printing to one of the surface flanges.
- Low pressure can be used when testing to confirm a complete seal immediately after assembly.
- Flanges should be tightened as soon as possible after assembly to avoid shimming.

**STORAGE**

Anaerobic adhesives shall be ideally stored in a cool, dry place in unopened containers at a room temperature between 5°C to 25°C. Please do not return any unused material in its original container.

**HEALTH & SAFETY**

- Classification: Xi irritant
- Keep out of reach of children
- Refer to product Material Safety Data Sheet (MSDS).

**LEGAL NOTE**

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Delta Adhesives Limited accepts no liability arising out of the use of this information or the products described herein.

Delta Adhesives Limited, Units 39-40 Claycliffe Business Park,  
Cannon Way, Barugh Green, Barnsley, South Yorkshire, S75 1JU,  
Tel: +44 (0) 1226 381 571 email: [sales@delta-adhesives.co.uk](mailto:sales@delta-adhesives.co.uk)

