

# BEARING GRADE ADHESIVE



Product Code: D22

## Curing Properties

Handling Cure Time	<b>30 minutes</b>
Functional Cure Time	<b>2 - 4 hours</b>
Full Cure Time	<b>24 hours</b>
Breakaway Torque	<b>None</b>



## Key Benefits

- ✓ High Strength
- ✓ Allows controlled disassembly
- ✓ Gap filling upto 0.2mm
- ✓ Vibration resistant

## Product Overview

D22 is a medium-viscosity, medium-strength anaerobic retaining compound designed for securing bearings, bushes, and cylindrical parts in industrial assemblies. It cures between close-fitting metal surfaces to create a reliable, load-bearing bond while allowing controlled disassembly when required.

## Technical Properties

COMPOSITION	<b>Methacrylate Ester</b>
COLOUR	<b>Yellow</b>
VISCOSITY	<b>1000 cps at 25°C</b>
SPECIFIC GRAVITY	<b>1.07</b>
MAX THREAD SIZE	<b>&gt; 100°C</b>
TEMPERATURE RANGE	<b>-55°C to 150°C</b>

Storage: Store below 25°C • Safety: See SDS for full details • [www.delta-adhesives.co.uk](http://www.delta-adhesives.co.uk)

# Applications



- ✓ Cylindrical Assembling
- ✓ Shaft and Housing Fittings
- ✓ Bush and Seal Fitting
- ✓ Bearing Retention

## Chemical Resistance

CHEMICAL	500 HOURS	1000 HOURS
Aceton	100%	100%
Ethanol	100%	100%
Motor Oil (125°C)	100%	100%
Gasoline	100%	100%
Break Fluid	100%	100%
Water/Glycol (87°C)	80%	95%

## Instructions of Use

**For Assembly** (Parts should not be disturbed until sufficient handling strength is achieved)

- 1. Prepare surfaces** - Clean all surfaces with D406 Surface Prep Cleaner and allow solvent to evaporate
- 2. Apply sealant**
  - a. For slip fitted assemblies** apply adhesive around the leading edge of the pin and the inside of the collar, and use a rotating motion to ensure good coverage
  - b. For press fitted assemblies** apply adhesive thoroughly to bond surfaces and apply high pressure
  - c. For shrink fitted assemblies** coat the adhesive onto the pin and then heat

**For disassembly** Apply localised heat to the assembly to approx 250°C. Disassemble while hot.

## Storage

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

## Health & Safety

- Classification: Xi irritant
- Keep out of reach of children
- Keep away from face and eyes

## 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.