

# HIGH STRENGTH RETAINING ADHESIVE



Product Code: D55

## Curing Properties

|                      |                    |
|----------------------|--------------------|
| Handling Cure Time   | <b>5 minutes</b>   |
| Functional Cure Time | <b>1 - 3 hours</b> |
| Full Cure Time       | <b>24 hours</b>    |
| Breakaway Torque     | <b>None</b>        |



## Key Benefits

- ✓ High Strength
- ✓ Allows controlled disassembly
- ✓ Gap filling upto 0.25mm
- ✓ Fast Curing

## Product Overview

D55 Retaining Compound is a fast-curing, high-strength anaerobic adhesive designed for cylindrical metal parts. It fills bond gaps up to 0.25mm (0.01”), ensuring maximum stability. This single-component formula develops rapid high strength when confined between closefitting metal surfaces in the absence of air.

## Technical Properties

|                   |                              |
|-------------------|------------------------------|
| COMPOSITION       | <b>Urethane Methacrylate</b> |
| COLOUR            | <b>Green</b>                 |
| VISCOSITY         | <b>2500 cps at 25°C</b>      |
| SPECIFIC GRAVITY  | <b>1.09</b>                  |
| MAX THREAD SIZE   | <b>&gt; 93°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)

- Sealing and Thread Locking     Bush and Seal Fitting     Shaft and Housing Fittings

## 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. If the material is inactive metal or the cure speed is too slow, spray with Anaerobic Activator D405 & allow to dry
- 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

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