



DELTA 22

Bearing Grade Adhesive

TECHNICAL DATA SHEET
 EDITION: 19/08/08
 PRODUCT CODE: D22

PRODUCT DESCRIPTION

Delta 22 is a medium viscosity, medium strength anaerobic bearing compound for continuous working temperatures up to 150°C.

APPLICATIONS

- Ideal to fill gaps up to 0.008" diameter clearance.
- High performance, controlled strength, versatile bearing compound.
- Used for fitting bearings, bushes and oil seals. Ideal for cylindrical parts that require disassembling. Permits sliding fit and eliminates distortion.
- Excellent retaining, sealing and thread locking compound.

ADHESIVE PROPERTIES	
Composition	Methacrylate Ester
Colour	Yellow
Viscosity <small>Brookfield RVT Spindle 4 @20 rpm</small>	1,000 cps at 25°C
Specific Gravity	1.07
Flash Point	>100°C
Solvent Content	None
Shelf Life	1 year

CURING PROPERTIES	
Handling Cure Time	30 minutes
Functional Cure Time	2 - 4 hours
Full Cure Time	24 hours
Compressive Shear Strength (ISO 10123)	
After 24 hours at 22°C	
Steel Pins & Collars	>12 N/mm ²
	> 1,500 psi
Temperature Range	-55°C to 150°C

PHYSICAL PROPERTIES	
Coefficient of Thermal Expansion ASTM D 696, K-1	80 x 10 ⁻⁶
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	100
Ethanol	22°C	100	100
Motor Oil	125°C	100	100
Gasoline	22°C	100	100
Brake Fluid	22°C	100	100
Water/Glycol	87°C	100	95

DIRECTIONS FOR USE

For Assembly

- 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.
- **For slip Fitted Assemblies** apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.
- **For Press Fitted Assemblies** apply adhesive thoroughly to bond surfaces and assemble at high press on rates.
- **For Shrink Fitted Assemblies** the adhesive should be coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly.
- Parts should not be disturbed until sufficient handling strength is achieved.

For Disassembly

- Apply localised heat to the assembly to approximately 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 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.

ANAEROBIC ADHESIVES
Retaining Series