



**Product Description**

Vibra-TITE 535 Gel Retaining Compound is an anaerobic retaining adhesive for all types of cylindrical assemblies. Cured performance shows controlled high strength with good temperature and solvent resistance against water and non-polar solvents. This product cures rapidly on plated, oily metal surfaces or inactive surfaces.

**Typical Applications**

Replaces press fit assemblies and keyways. Used on gear box bolts/drive shaft, bearing applications.

**Instructions for Use**

Ensure parts are clean, dry and free from oil and grease.

**Procedure for Application**

Product is normally hand applied from the bottle onto threaded parts.

**Compatible Primers**

Primers such as Vibra-TITE Excel 611 (Primer N) or Excel 612 (Primer T) can be used. The use of primers can result in lower strength and performance should be tested after full cure.

**Technical Features**

Resin:.....Modified acrylate  
Color:.....Green  
Fixture Speed w/Primer.....<1 seconds  
Fixture Speed w/o Primer 5-10 min @ 77°F  
Viscosity.....Gel  
Gap Fill.....0.015"  
Max. Operating Temp..... -65°F to +300°F

**Cured Performance**

Full Cure Time: 24 hours @ 68°F  
Typical Breakaway Strength:  
    3/8 Phos-oil 170 – 300 lb-ins  
Typical Prevailing Strength:  
    3/8 Phos-oil 100 – 350 lb-ins

**Presentation**

Tubes.....50ml, 250ml

**General Information**

**Storage**

Product should be stored in a cool and dry location at temperatures between 14°F (-10°C) to 86°F (30°C). Shelf life is 2 years from date of manufacture when stored at 72±8°F (22±4°C).

**Note**

Using Vibra-TITE 535 is easy, the product is color coded green and once cured, it seals and vibration proofs the assembly, giving high compressive shears.