### DELO-ML* anaerobic-curing adhesives

**Product code number**

<table>
<thead>
<tr>
<th>Low strength</th>
<th>Medium strength</th>
<th>High strength</th>
<th>Heat-resistant</th>
<th>Adhesive</th>
<th>Anaerobic light curing</th>
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<tbody>
<tr>
<td>S149</td>
<td>S198</td>
<td>S228</td>
<td>S249</td>
<td>S298</td>
<td>S302</td>
</tr>
<tr>
<td>S449</td>
<td>S549</td>
<td>S584</td>
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**Colour**
- yellow (0.5 mm)
- red (0.5 mm)
- brown (0.5 mm)

**Gap which can be bridged**
- 0.1 mm

**Final strength**
- ≥ 200 °C

**Compression/shear strength at joint connections**
- ≤ 10 MPa

**Curing at room temperature**
- 3 days

**Compliance with**
- DIN 54 525
- DIN 54 525
- DIN 54 525

**Explanation of the product code numbers**

1. **position**
2. **position**
3. **position**

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**Explanation of the adhesive layer thickness**
- Approximately 0.5 mm

**Explanation of adhesive layer thickness**
- Approx. 0.5 mm

**Advantage**
- High bond strength
- Long-term stability
- Easy handling
- Environmentally friendly

**Improvement**
- Delayed or no curing
- No adhesive residues

**Curing**
- Anaerobic light-curing adhesives
- In a highly stress-sensitive environment

**Material**
- Non-ferrous metals, e.g. copper, brass, bronze; low-alloy steel

**Curing**
- Delayed or no curing

**Applications and properties**
- Anaerobic light-curing adhesives
- For all threads

**Compression**
- ≤ 10 MPa

**Surface pretreatment**
- Chemical cleaning
- Thermal treatment

**Processing**
- Low viscosity
- Fast curing

**Surface treatment**
- Epoxy and polyester

**Surface tension**
- 3.2 mN/m

**Temperature range of use**
- ≤ 100 °C

**Surface treatment**
- Chemical cleaning
- Thermal treatment

**Surface tension**
- 3.2 mN/m

**Temperature range of use**
- ≤ 100 °C
Examples of Applications

**Recommended Standard Products**

- **Locking screws**
  - DELO-ML 5249, coefficient of friction as at an oiled screw, removable, especially optimized for screw locking

- **Sealing flanges and large threads**
  - DELO-ML 5286, removable, run-resistant
  - DELO-ML 5336, easily removable, run-resistant

- **Pipe connections**
  - DELO-ML 5308, removable
  - DELO-ML 5336, hard to remove

- **Shaft/hub connections**
  - DELO-ML 5327, DELO-ML 5328, hard to remove, high-strength bonding, long-term strength even at high dynamic stresses

- **Fixing of reassembled parts**
  - DELO-ML 5302, hard to remove, capillary in tightest gaps
  - DELO-ML 5336, also suitable for sealing porous parts and weld seams

- **Grinded and galvanized surfaces**
  - DELO-ML 5327, DELO-ML 5549, hard to remove, high adhesive effect on surfaces having low surface roughness (Rz < 10 µm)

- **Fast fixing of parts**
  - DELO-ML 5549, hard to remove

- **Use at gas-operated facilities**
  - DELO-ML 5249, DIN EN-DVGW-Reg.-Nr. 0146 BL 0234, removable
  - DELO-ML 5336, DIN EN-DVGW-Reg.-Nr. 0146 BL 0234, hard to remove
  - Curing sealing material for threaded connections of fittings and gas-operated equipment

- **Use at high temperature**
  - DELO-ML 5327, DELO-ML 5449, suitable for permanent use at temperatures of up to 200 °C

**Selection Chart**

- **1-part methacrylates**
  - anaerobic-curing
  - DELO-PHOTOBOND®
  - DELO-KATIOBOND®
  - DELO-MONOPOX® – adhesives
  - – casting resins
  - – fillers
  - DELO-MONOPOX®
  - DELO-DUOPOX® – adhesives
  - – casting resins
  - – fillers
  - DELO-ML®
  - DELO-CA®
  - DELO-GUM®
  - DELO-PUR®
  - DELO-THEN®
  - DELOMAT®
  - DELOLUX®

- **1-part acrylates**
  - UV-curing · light-curing
  - DELO-PHOTOBOND®

- **1-part epoxies**
  - UV-curing · light-activated
  - 1-part epoxies
  - heat-curing · tough-hard
  - DELO-MONOPOX®

- **1-part epoxies**
  - heat-curing
  - 2-part epoxies
  - cold-curing
  - DELO-MONOPOX®

- **2-part epoxies**
  - cold-curing
  - 1-part cyanoacrylates
  - fast curing
  - DELO-DUOPOX®

- **1- and 2-part silicones**
  - highly flexible
  - DELO-DUOPOX®

- **1- and 2-part polyurethanes**
  - cold-curing · tough-elastic
  - DELO-THEN®

- **Cleaners**
  - CFC-free
  - DELO-THEN®

- **Dispensing systems**
  - precise
  - DELO-THEN®

- **Micro metering valve**
  - fast · versatile · precise
  - DELOMAT®

- **Light systems**
  - intensive
  - DELOLUX®