

# DELO<sup>®</sup>-ML 5327

**modified acrylate | 1C | anaerobic-curing**

free of solvents | unfilled, high-strength

### Special features of product

- compliant with RoHS Directive 2015/863/EU
- compliant with limits of VOC content in adhesive acc. to GB33372-2020

### Typical area of use

- -60 - 200 °C
- screw locking and thread sealing

### Curing

Curing time

<i>until initial strength at rt approx. +23 °C anaerobic on zinc-phosphated screws</i>	2 - 4	min
--	-------	-----

<i>until initial strength at rt approx. +23 °C with DELO-QUICK 5002 on V2A screws</i>	20	min
---	----	-----

### Processing

Processing time

<i>in standard climate +23 °C / 50 % r. h.</i>	28	d
--	----	---

Storage life in unopened original container

<i>up to &lt;= 600 ml at 0 °C to +25 °C</i>	6	month(s)
---	---	----------

<i>up to &lt;= 600 ml at 0 °C to +10 °C</i>	12	month(s)
---	----	----------

### Technical properties

Color in uncured condition	green
----------------------------	-------

Color in cured condition in 0.1 mm layer thickness	green
--	-------

### Parameters

Density <i>liquid</i>	1.1	g/cm <sup>3</sup>
--------------------------	-----	-------------------

Viscosity 300 mPa·s  
*liquid | Viscosimeter*

Off-torque 50 N·m  
*by the criteria of ISO 10964 | **Stainless steel** | **Stainless steel** | liquid*

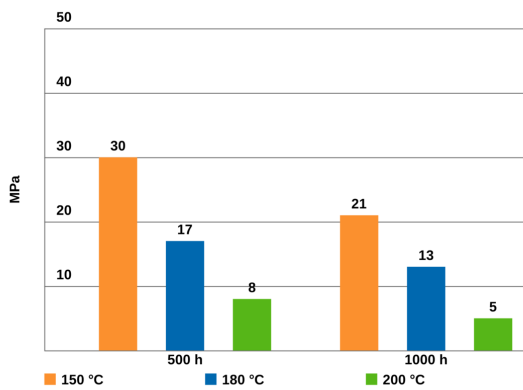
Tensile shear strength 11 MPa  
*by the criteria of DIN EN 1465 | **Al** | **Al** | Pretreatment: sand-blasted | liquid*

Tensile shear strength 16 MPa  
*by the criteria of DIN EN 1465 | **Steel** | **Steel** | Pretreatment: sand-blasted | liquid*

Compression shear strength 28 MPa  
*by the criteria of ISO 10123 | **Steel shaft** | **Steel hub** | 1 h*

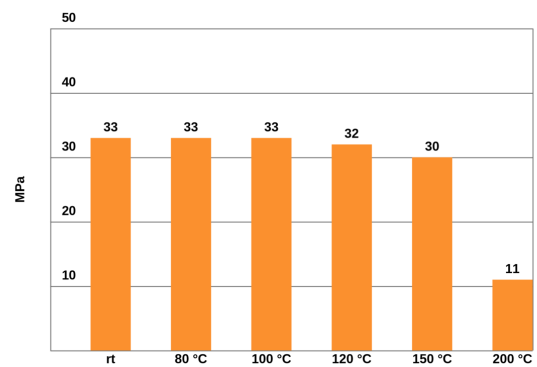
Compression shear strength 33 MPa  
*by the criteria of ISO 10123 | **Steel shaft** | **Steel hub** | at approx. +23 °C | 72 h*

Compression shear strength after thermal storage, based on ISO 10123



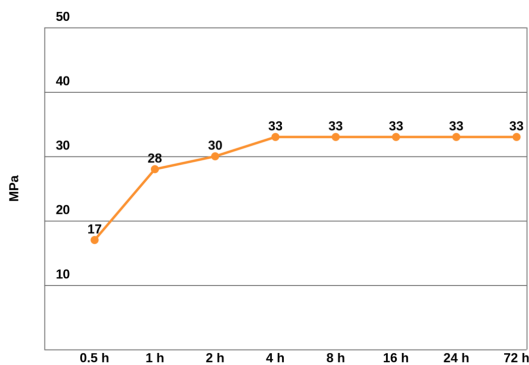
Substrates: steel shaft/ steel hub

Compression shear strength measured at the stated temperatures



Substrates: steel shaft / steel hub

Compression shear strength for determining the curing process  
 shaft-to-hub bonding, substrates: steel shaft/steel hub, based on ISO 10123



at room temperature (approx. +23 °C)

**Converting table**

°F	= (°C x 1.8) + 32	1 MPa	= 145.04 psi
1 inch	= 25.4 mm	1 GPa	= 145.04 ksi
1 mil	= 25.4 µm	1 cP	= 1 mPa·s
1 oz	= 28.3495 g	1 N	= 0.225 lb

---

**General curing and processing information**

The curing time stated in the technical data was determined in the laboratory. It can vary depending on the adhesive quantity and component geometry and is therefore a reference value. Values measured after 24 h at approx. 23 °C / 50 % r.h., unless otherwise specified.

**General**

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this. It is the customer's responsibility to test the suitability of a product for the intended purpose by considering all specific requirements and by applying standards the customer deems suitable (e. g. DIN 2304-1). Type, physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions. The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for a specific purpose.

Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.

All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist.

**Instructions for use**

You can find further details in the instructions for use.

The instructions for use are available on [www.DELO-adhesives.com](http://www.DELO-adhesives.com).

We will be pleased to send them to you on demand.

**Occupational health and safety**

See material safety data sheet.

**Specification**

Nothing contained in this Technical Datasheet shall be interpreted as any express warranty or guarantee. This Technical Datasheet is for reference only and does not constitute a product specification. Please ask our responsible Sales Engineer for the applicable product specification which includes defined ranges. DELO is

neither liable for any values and content of this Technical Datasheet nor for oral or written recommendations regarding the use, unless otherwise agreed in writing. This limitation of liability is not applicable for damages resulting from intent, gross negligence or culpable breach of cardinal obligations, nor shall it apply in case of death or personal injury or in case of liability under any applicable compulsory law.

## CONTACT

DELO-ML 5327 | as of 07.03.2023 12:19 | Page 4 of 4

**DELO** Industrial Adhesives  
Headquarters

▶ Germany · Windach / Munich ... [www.DELO-adhesives.com](http://www.DELO-adhesives.com)

ADHESIVES

DISPENSING

CURING

CONSULTING