

DELO®-ML DB136

Anaerobic- and light curing adhesive

Base

- Modified urethane acrylate
- one-component, solvent-free
- dual-curing adhesive

Use

- bonding: metals, small surfaces and with a high fitting accuracy
- fixing: coaxial components, e. g., bearings or sockets
- adhesive leaking from the bonding gap can be cured in seconds with visible light
- therefore, firmness to touch can be reached faster
- easy application control due to fluorescent color
- if one of the components to be bonded is translucent, non-metals can also be bonded through polymerization
- DELO curing lamps generating radiation adjusted to the adhesives are available to initiate this reaction
- suitable for small casting applications, if cured with DELO curing lamps. The top, open adhesive surface exposed to air remains tacky
- also suitable for the bonding of components with dissimilar coefficients of expansion due to flexibilized and tension-equalizing nature
- the cured product is normally used in a temperature range of -60 °C to +180 °C; depending on the application, other limits may be more reasonable
- successfully tested according to UL 94 HB
- compliant with RoHS directive 2015/863/EU
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Processing

- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- DELOTHEN cleaners are recommended for the optimal preparation of bonding areas
- thread connections must be tightened well
- the adhesive is good to dispense from original containers or by means of dispensing systems suitable for anaerobic-curing adhesives

Curing

- anaerobic, i.e., by exclusion of air and under metal influence at room temperature with small gap
- the curing may be assisted by application of heat, use of activator and/or light, e.g. if the curing speed is too slow or if it comes to larger gaps
- the build-up of strength depends on the components and the geometry joined. The initial strength is achieved after just a few minutes. Significant acceleration is possible by using an activator and/or applying heat
- curing with UV light in a wavelength range of 320 – 450 nm. DELOLUX LED curing lamps are especially suitable as per the chart below. All standard DELOLUX HID discharge lamps are also suitable
- when using light fixation, an intensity at the adhesive of 700 mW/cm² should not be exceeded. Application related, higher intensities can be useful
- both curing mechanisms can be used in combination or separately

Lamp type	DELOLUX 20 / 50 / 80		
Wavelength [nm]	365	400	460
Suitability	++	++	-

- not suitable + suitable ++ especially suitable

Properties

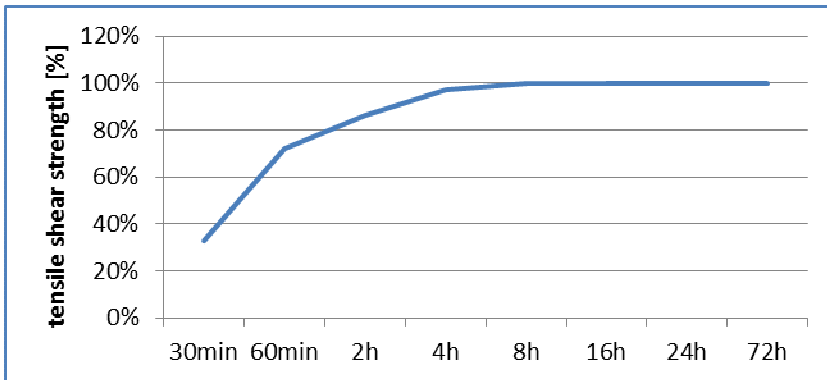
- fluorescent variant of DELO-ML DB135
- low-viscous setting
- light-curing and anaerobic-curing
- visible adhesive in boundary areas can be cured with visible light
- high strength, difficult to remove
- very good strengths and low roughness depth of the bonding areas

Technical data

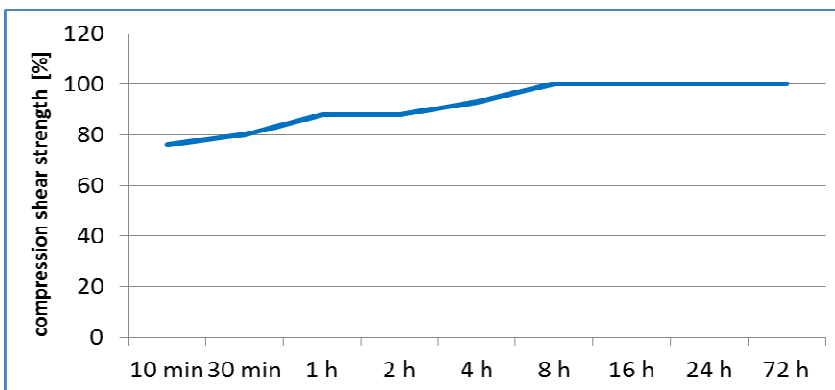
<i>Color</i>	clear- yellowish and fluorescent
preferred clearance [mm]	0,05-0,1
clearance with heat or activator [mm]	up to 0,3-0,4
clearance with light curing [mm]	4
Density [g/cm ³] at room temperature (approx. 23 °C)	1.1
Viscosity [mPas] at 23 °C, Brookfield spm 3/10	1200
<i>Curing time until initial strength</i> [min] at room temperature (approx. 23 °C), anaerobic on zinc-phosphated screws	approx. 2- 4

curing progress

compression shear strength shaft-hub joint
 based on initial value at room temperature
 measured at room temperature (approx. 23 °C)
 according to ISO 10123



compression shear strength shaft-hub joint with activator DELO-QUICK 5006
 based on initial value at room temperature
 measured at room temperature (approx. 23 °C)
 according to ISO 10123

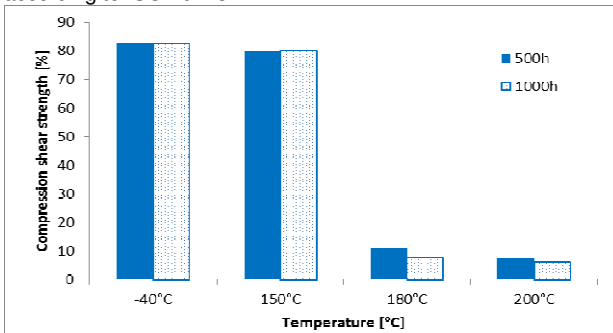


Minimal irradiation time [s] DELO Standard 23, UVA intensity: 60 mW/cm ² , DELOLUXcontrol	10
Curable layer thickness [mm] DELO Standard 20 curing lamp DELOLUX 03 S UVA intensity: 55 - 60 mW/cm ² DELOLUXcontrol	4
Compression shear strength after 1 h [MPa] according to ISO 10123	30
Compression shear strength [MPa] according to ISO 10123	40
Compression shear strength glass/glass [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	30
Compression shear strength stainless steel/PA [MPa] DELO Standard 5 curing: 24h at room temperature with DELO-QUICK 5002	7

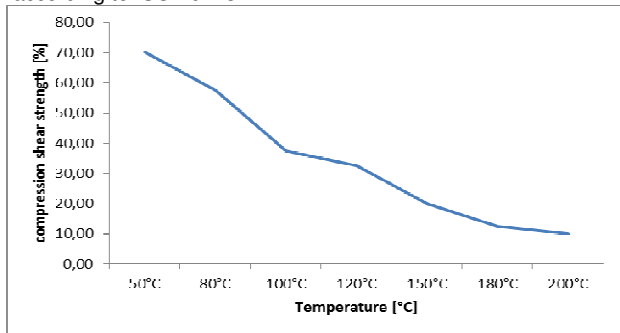
compression shear strength stainless steel/PPA [MPa] DELO Standard 5 curing: 24h at room temperature with DELO-QUICK 5002	7
compression shear strength stainless steel/PPS [MPa] DELO Standard 5 curing: 24h at room temperature with DELO-QUICK 5002	5
Tensile shear strength Al/Al [MPa] DIN EN 1465	6
Tensile shear strength St/St [MPa] DIN EN 1465	12
Tensile strength [MPa] according to DIN EN ISO 527	27
Elongation at tear [%] according to DIN EN ISO 527	30
Young's modulus [MPa] according to DIN EN ISO 527	1000
Shore hardness D according to DIN EN ISO 868	74
Glass transition temperature [°C] rheometer	110
Coefficient of linear expansion [ppm/K] TMA, temperature range: +30 to +70 °C	130
Coefficient of linear expansion [ppm/K] TMA, temperature range: +90 to +160 °C	193
Shrinkage [vol. %] DELO Standard 13	7.4
Water absorption [%]	1.25

Performance under temperature influence

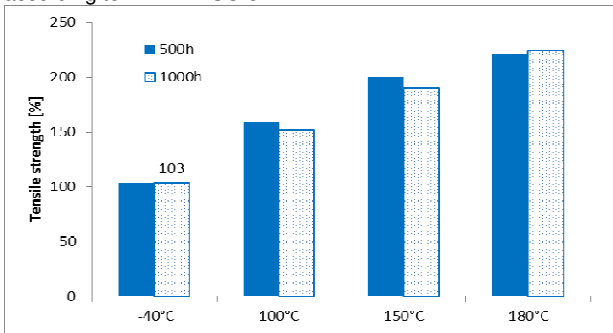
compression/shear strength shaft -hub joint
after temperature storage
based on initial value at room temperature
measured at room temperature (approx. 23 °C)
according to ISO 10123



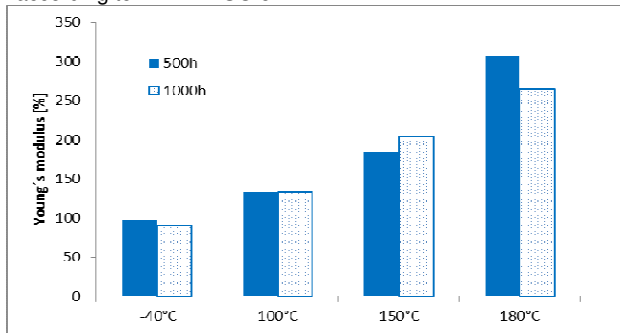
compression/shear strength shaft-hub joint at temperature
based on initial value at room temperature
measured at determined temperature
according to ISO 10123



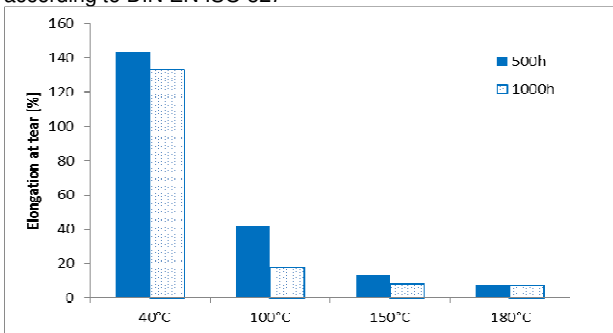
tensile strength after temperature storage
based on initial value at room temperature
measured at room temperature (approx. 23 °C)
according to DIN EN ISO 527



Young's modulus after temperature storage
based on initial value at room temperature
measured at room temperature (approx. 23 °C)
according to DIN EN ISO 527



elongation at tear after temperature storage
based on initial value at room temperature
measured at room temperature (approx. 23 °C)
according to DIN EN ISO 527



Storage life

at 0 °C to +10 °C in unopened original container

6 months

Storage life

In unopened original container up to 600 ml at room temperature (0-25 °C)

3 months

Instructions and advice

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

The instructions for use of DELO-ML are available on: www.DELO.de. We will be pleased to send them to you on demand.

Occupational health and safety

see material safety data sheet

Specification

The properties in italics are part of the specification. Ranges with clear limits are defined for them and others, where applicable. In the course of the QA test, each batch is tested for these properties and the maintenance of the limits is ensured. The measuring methods used can deviate from those specified in the data sheet. Details can be found in the QA test report.