



Use Loctite® brand liquid or paste retaining compounds to bond non-threaded, cylindrical metal assemblies. Fill the inner voids in close-fitting press fits, keyways, and splines. Mount bearings and bushings, and make press fits even stronger.

RETAINING

Loctite® 609™ Retaining Compound

Press Fit/General Purpose

A low viscosity, fast curing adhesive used for bonding rigid metal assemblies. Ideal for gap distances up to 0.005" (0.13 mm). Loctite® 609™ fixtures in just 10 minutes and provides shear strength of 3,000 psi after 24 hours. It easily joins dissimilar metals and withstands temperatures up to 300°F (149°C).

Loctite® 603™ Retaining Compound

Press Fit/Oil Tolerant

A retaining compound tolerant of oil and other contamination. Seals and secures cylindrical assemblies up to 0.005" radial clearance. Fixtures in 10 minutes. Prevents fretting and corrosion of metal assemblies.

Loctite® 620™ Retaining Compound

Slip Fit/High Temperature

A high temperature adhesive that has the capability to operate at 450°F (232°C) for long periods. Loctite® 620™ fixtures in 30 minutes at room temperature, but requires a secondary heat cure to generate the high temperature resistance. Used to bond cylindrical parts with gaps up to 0.015" (0.35 mm). 620 provides a shear strength of 3,800 psi on steel after 24 hours.

Loctite® 660™ Quick Metal® Retaining Compound

Press Fit Repair

A creamy, non-running gel that is applied onto cylindrical parts to fill surface imperfections and repair worn areas. It contains no metal, but once assembled hardens to a strength that often doubles that of a press fit. Use Loctite® 660™ to salvage worn metallic parts, or to keep machinery running until new parts arrive. Use to 300°F (149°C).

Loctite® 680™
Retaining Compound

Slip Fit/High Strength

A high strength, room-temperature-curing adhesive used to join fitted cylindrical parts. It fixtures in 10 minutes and provides a shear strength of 4,000 psi after 24 hours. Capable of filling diametral gap distances up to 0.015" (0.27 mm). Loctite® 680™ allows relaxed machining tolerances and replaces clamp rings, set screws, and snap rings.

For technical information and/or product availability, call 1-800-LOCTITE or on the web

Visit www.loctite.com

LOCTITE® BRAND
RETAINING COMPOUNDS
PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance	Maximum Gap Fill (Diametral)	Shear Strength Steel/Steel (psi)*	Temperature Range	Set-Up Time	Recommended Primer	Agency Approvals
603™	21440 21441 21442	10 ml bottle 50 ml bottle 250 ml bottle	Green Liquid	.005"	3,770 psi	-65° to 300°F (-54° to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	-
609™	60921 60931 60941	10 ml bottle 50 ml bottle 250 ml bottle	Green Liquid	.005"	2,300 psi minimum	-65° to 300°F (-54° to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	CFIA, Conforms to MIL-R-46082B for existing designs
620™	62015 62040 62070	10 ml bottle 50 ml bottle 250 ml bottle	Green Liquid	.015"	3,800 psi	-65° to 450°F (-54° to 232°C)	Set-up: 30 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	ABS, CFIA
660™ Quick Metal®	66010 66040	6 ml tube 50 ml tube	Silver Paste	.020"	3,335 psi	-65° to 300°F (-54° to 149°C)	Set-up: 20 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	CFIA
680™	68015 68035 68060	10 ml bottle 50 ml bottle 250 ml bottle	Green Liquid	.015"	2,800 psi minimum	-65° to 300°F (-54° to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	ABS, NSF/ANSI 61

*Varies with substrates.

ADDITIONAL OFFERINGS

Loctite® Hand Pumps are ideal for dispensing liquid from all 50 ml and 250 ml anaerobic bottles. See page 106 for more information.

