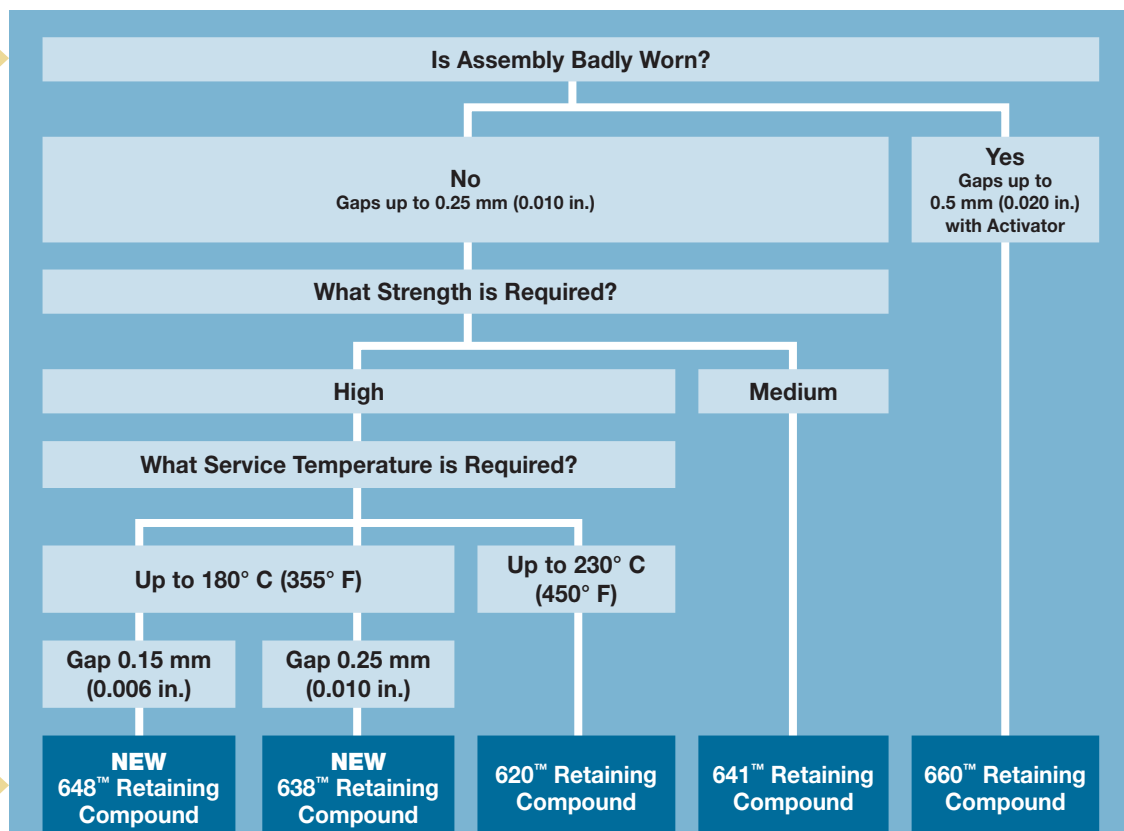


# Choosing a LOCTITE® Retaining Compound

## Your Application

- Increase the shear strength of cylindrical, non-threaded assemblies
- An industry standard for assembling press- and slip-fitted parts
- Fill the “inner space” between components and cure to form a strong precision assembly
- Formulated in a variety of viscosities, gap fills, flexibility and strength characteristics
- Can be applied with automated process equipment or dispensed manually

## Solution



Strength Required	High	High	High	Medium	High
Shear Strength	3,900 psi	4,500 psi	3,800 psi	1,700 psi	3,335 psi
Clearance	Up to 0.15 mm (0.006 in.)	Up to 0.25 mm (0.010 in.)	Up to 0.2 mm (0.008 in.)	Up to 0.15 mm (0.006 in.)	Up to 0.5 mm (0.020 in.)
Temperature Resistance	180°C (355°F)	180°C (355°F)	230°C (450°F)	150°C (300°F)	150°C (300°F)
Cure Time (Setup/Full Strength)	3 min. / 24 hrs.	4 min. / 24 hrs.	60 min. / 24 hrs.	20 min. / 24 hrs.	20 min. / 24 hrs.
Recommended Activator	Not required	Not required	7088™, 7649™, 7471™	7088™, 7649™, 7471™	7088™, 7649™, 7471™

## Product Description

### NEW LOCTITE® 648™ Retaining Compound General Purpose/High Strength/Rapid Cure

Best performance for clearance or interference fit parts. Excellent performance for dynamic, axial and radial loads. Bonds through contaminants including oils, cutting and corrosion protection fluids. Cures on metals without an activator. Globally available product.

#### NSF P1-Certified

P/N	Package Size
1844659	0.5 ml capsule
1835922	10 ml bottle
1835920	50 ml bottle
1835918	250 ml bottle
1865917	1 liter bottle

### NEW LOCTITE® 638™ Retaining Compound Slip Fit/High Strength

Recommended for slip fit parts with larger gaps. Excellent performance for dynamic, axial and radial loads. Bonds through contaminants including oils, cutting and corrosion protection fluids. Cures on metals without an activator. Globally available product.

#### NSF P1-Certified

P/N	Package Size
1835937	10 ml bottle
1835936	50 ml bottle
1835925	250 ml bottle
1835924	1 liter bottle

### LOCTITE® 620™ Retaining Compound Slip Fit/High Temperature

Recommended for high temperature retaining of parts with a clearance or interference fit, i.e., retaining bushings, bearings, seals, fans and liners. Requires heat cure to achieve temperature resistance.

#### ABS-Approved.

P/N	Package Size
62005	0.5 ml bottle
62015	10 ml bottle
62040	50 ml bottle
62070	250 ml bottle
62085	1 liter bottle

### LOCTITE® 641™ Retaining Compound

A controlled-strength retaining compound that is ideal for cylindrical parts that require disassembly.

#### CFIA-Approved.

P/N	Package Size
28802	10 ml tube
21458	50 ml tube

### LOCTITE® 660™ Retaining Compound

Used for repairing worn coaxial parts without remachining; enables reuse of worn bearing seats, keys, splines, tapers or for retaining shims.

#### CFIA-Approved.

P/N	Package Size
66010	6 ml tube
66040	50 ml tube