

Your Source RETAINING COMPOUNDS SELECTOR GUIDE

WHAT TYPE OF PARTS ARE BEING ASSEMBLED?

Worn Parts Up to 0.020 in. Gap

Loctite® 660™ Quick Metal™ Retaining Compound

- Item # 66010 6 ml tube
- Item # 66040 50 ml tube

Loose-Fitting Parts Between 0.010 in. to 0.015 in. Gap

TEMPERATURES ABOVE 300°F (149°C)

Loctite® 620™ Retaining Compound

- Item # 62005 0.5 ml capsule
- Item # 62015 10 ml bottle
- Item # 62040 50 ml bottle
- Item # 62070 250 ml bottle
- Item # 62085 1 liter bottle

300°F (149°C) MAXIMUM TEMPERATURE

Loctite® 232™ Retaining Compound

- Item # 18607 1 liter bottle
 - Item # 27863 250 ml bottle
- LOW STRENGTH**

Loctite® 641™ Retaining Compound

- Item # 28802 10 ml bottle
 - Item # 21458 50 ml bottle
- MEDIUM STRENGTH**

Loctite® 638™ Retaining Compound

- Item # 21447 10 ml bottle
 - Item # 21448 50 ml bottle
 - Item # 21449 250 ml bottle
- HIGH STRENGTH 5-MINUTE FIXTURE**

Loctite® 680™ Retaining Compound

- Item # 68005 0.5 ml capsule
 - Item # 68015 10 ml bottle
 - Item # 68035 50 ml bottle
 - Item # 68060 250 ml bottle
 - Item # 68090 1 liter bottle
- HIGH STRENGTH 10-MINUTE FIXTURE**

Loctite® 635™ Retaining Compound

- Item # 63531 50 ml bottle
 - Item # 63541 250 ml bottle
- HIGH STRENGTH 1-HOUR FIXTURE**

Close-Fitting Parts Up to 0.010 in. Gap

400°F (204°C) MAXIMUM TEMPERATURE

Loctite® QuickStix® 668™ Retaining Compound

- Item # 39148 19 g stick

450°F (232°C) MAXIMUM TEMPERATURE

Loctite® 640™ Retaining Compound

- Item # 64031 50 ml bottle
- Item # 64041 250 ml bottle

300°F (149°C) MAXIMUM TEMPERATURE

Oil Contamination

YES

Loctite® 603™ Retaining Compound

- Item # 21440 10 ml bottle
- Item # 21441 50 ml bottle
- Item # 21442 250 ml bottle

NO

Loctite® 609™ Retaining Compound

- Item # 60905 0.5 ml capsule
 - Item # 60921 10 ml bottle
 - Item # 60931 50 ml bottle
 - Item # 60941 250 ml bottle
 - Item # 60943 1 liter bottle
- MEDIUM STRENGTH**

Loctite® 648™ Retaining Compound

- Item # 21443 10 ml bottle
 - Item # 21444 50 ml bottle
 - Item # 21445 250 ml bottle
- HIGH STRENGTH 5-MINUTE FIXTURE**

Loctite® 675™ Retaining Compound

- Item # 67541 250 ml bottle
- HIGH STRENGTH 20-MINUTE FIXTURE**

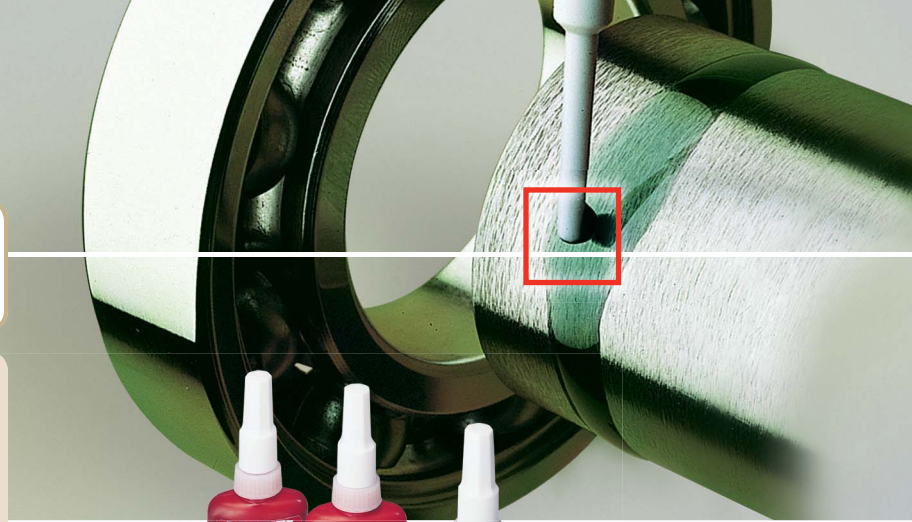


AUTHORIZED DISTRIBUTOR

1-800-448-0406

Your Source for **RETAINING** **RETAINING COMPOUNDS**

- Increases the shear strength of cylindrical, non-threaded assemblies
- An industry standard for assembling press- and slip-fitted parts
- Fills the “inner space” between components and cures 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



[Close-Fitting Parts]

Loctite® 232™ Retaining Compound

HEAVY PRESS FIT/MEDIUM STRENGTH

A medium viscosity, medium strength retaining compound with slow cure and lubricity for heavy press fits and highly torqued threaded assemblies.

Item #	18607	1 liter bottle
	27863	250 ml bottle

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 in. diametral clearance. Fixtures in 10 minutes. Prevents fretting and corrosion of metal assemblies.

Item #	21440	10 ml bottle
	21441	50 ml bottle
	21442	250 ml bottle

Source's PICK

Loctite® 609™ Retaining Compound

PRESS FIT/GENERAL-PURPOSE

NEW

A low viscosity retaining compound that bonds rigid metal assemblies. Ideal for gap distances up to 0.006 in. diametral. Fixtures in 10 minutes and provides a shear strength of 3,000 psi after 24 hours. Easily joins dissimilar metals. Withstands temperatures to 300°F (149°C).

Item #	60905	0.5 ml capsule
	60921	10 ml bottle
	60931	50 ml bottle
	60941	250 ml bottle
	60943	1 liter bottle

Loctite® 648™ Retaining Compound

PRESS FIT/HIGH STRENGTH/ RAPID CURE

A retaining compound recommended for continuous working temperatures up to 300°F (149°C). Fills gaps up to 0.006 in. diametral clearance. Fixtures in 5 minutes.

Item #	21443	10 ml bottle
	21444	50 ml bottle
	21445	250 ml bottle

[General-Purpose]

Loctite® QuickStix® 668™ Retaining Compound

A high temperature retaining compound in a revolutionary semisolid formula. Patented, no-mess package offers added convenience and portability. Ideal for gaps up to 0.005 in. in diameter. Withstands temperatures to 400°F (204°C).

Item #	39148	19 g stick
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[Medium Strength]

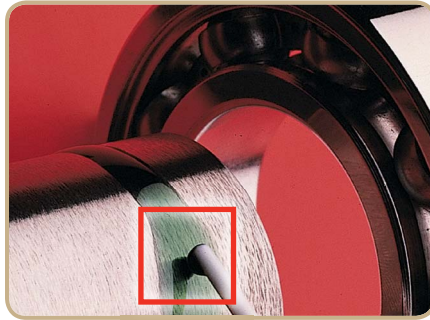
Loctite® 641™ Retaining Compound

PRESS & SLIP FIT/ CONTROLLED STRENGTH

A controlled strength retaining compound that is ideal for cylindrical parts that require disassembly. Recommended for maximum diametral clearance of 0.008 in. Fixtures in 20 minutes.

Item #	28802	10 ml bottle
	21458	50 ml bottle

Sources REVEALED



INDUSTRIES

[Industries]

- Pulp and Paper
- Power Generation

- Steel Mills
- Automotive

[High Temperature]

Source's PICK

Loctite® 620™ Retaining Compound

SLIP FIT/HIGH TEMPERATURE

A high temperature (450°F/232°C), high viscosity liquid retaining compound. Provides a shear strength of over 3,800 psi on steel. Locks and secures metal cylindrical assemblies up to 0.015 in. diametral clearance. Prevents metal fretting and corrosion. Seals against leakage.

Item #	62005	0.5 ml capsule
	62015	10 ml bottle
	62040	50 ml bottle
	62070	250 ml bottle
	62085	1 liter bottle

[Loose-Fitting Parts]

Loctite® 635™ Retaining Compound

SLIP FIT/HIGH STRENGTH/SLOW CURE

A high viscosity, high strength retaining compound with slow cure speed to permit readjustment of parts during assembly.

Item #	63531	50 ml bottle
	63541	250 ml bottle

Source's PICK

Loctite® 638™ Retaining Compound

SLIP FIT/MAXIMUM STRENGTH

A maximum strength retaining compound for use where high dynamic force or cyclic loading is expected. Locks cylindrical assemblies up to 0.010 in. diametral clearance. Fixtures in 5 minutes.

Item #	21447	10 ml bottle
	21448	50 ml bottle
	21449	250 ml bottle

Loctite® 680™ Retaining Compound

SLIP FIT/HIGH STRENGTH

A high strength, high viscosity room temperature curing adhesive used to join fitted cylindrical parts. It fixtures in 10 minutes and provides a shear strength of 4,000 psi. Capable of filling diametral gaps up to 0.015 in. (0.38 mm). Loctite® 680™ allows relaxed machining tolerances, and replaces clamp rings, set screws, and snap rings.

Item #	68005	0.5 ml capsule
	68015	10 ml bottle
	68035	50 ml bottle
	68060	250 ml bottle
	68090	1 liter bottle

[Machinery Repair]

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).

Item #	66010	6 ml tube
	66040	50 ml tube



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