



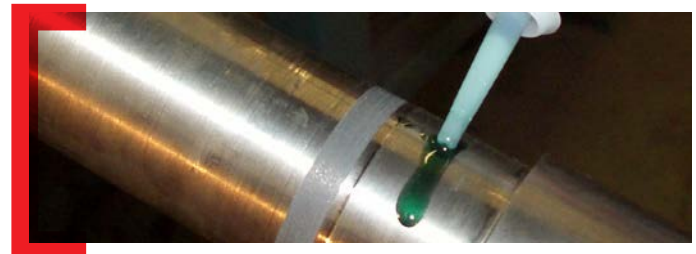
# Gap Size - 0.15 mm to 0.25 mm

## RETAINING COMPOUNDS

 <b>232™</b> High Lubricity	 <b>620™</b> High Temperature	 <b>680™</b> General Purpose	 <b>638™</b> High Strength
 <b>Temperature Resistance:</b> 150°C	 <b>Temperature Resistance:</b> 230°C**	 <b>Temperature Resistance:</b> 180°C	 <b>Temperature Resistance:</b> 180°C
 <b>Strength:</b> 7 N/mm <sup>2</sup>	 <b>Strength:</b> 17.2 N/mm <sup>2</sup>	 <b>Strength:</b> 26 N/mm <sup>2</sup>	 <b>Strength:</b> 29 N/mm <sup>2</sup>
<b>Cure Speed:</b> 24 hours <b>Fixture Time:</b> 5 hours*	<b>Cure Speed:</b> 24 hours <b>Fixture Time:</b> 60 minutes*	<b>Cure Speed:</b> 24 hours <b>Fixture Time:</b> 4 minutes*	<b>Cure Speed:</b> 24 hours <b>Fixture Time:</b> 4 minutes*

# Gap Size - 0.25 mm to 0.5 mm

 <b>635™</b> Mil-Spec	 <b>660™</b> Badly Worn Assemblies Use with LOCTITE SF 7649
 <b>Temperature Resistance:</b> 150°C	 <b>Temperature Resistance:</b> 150°C
 <b>Strength:</b> 20 N/mm <sup>2</sup>	 <b>Strength:</b> 17.2 N/mm <sup>2</sup>
<b>Cure Speed:</b> 24 hours <b>Fixture Time:</b> 30 minutes*	<b>Cure Speed:</b> 24 hours <b>Fixture Time:</b> 15 minutes *



\* Fixture time measured at room temperature on steel joints  
 \*\* After 30 min. heat cure at 180°C

## RETAINING COMPOUNDS

Product	Item Number	Pack Size	Colour	Features	Viscosity [cP]	Compressive Shear Strength, Steel to Steel, psi (N/mm <sup>2</sup> )	Fixture Time [min]	Temperature Range
<b>GAP SIZE - UP TO 0.25 mm</b>								
<b>680™</b>	1878433	50 ml	Green	High strength, fast fixturing, primerless, best resistance to dynamic, axial, and radial loads. Potable water approval AS/NZS 4020:2018 PST20158	1300	19***	4	-55°C to 180°C
	1878498	250 ml						
<b>620™</b>	234772	10 ml	Green	High strength, slow fixture, high temperature and heat aging resistance	8,000	17	60	-55°C to 230°C
	234776	50 ml						
	135515	250 ml						
<b>232™</b>	1381765	250 ml	Brown	High lubricity to facilitate smooth assembly of heavy interference / press fits, Prevents galling and metal pick-up during assembly	6,200	7	5 hrs	-55°C to 150°C
<b>GAP SIZE - 0.5 mm</b>								
<b>660™</b>	473167	6 ml	Silver	High Strength, large gap fill for repairing worn coaxial parts without remachining	250,000	17	15	-55°C to 150°C
	473166	50 ml						

\*\*\* Increase to 26 N/mm<sup>2</sup> after 7 days cure