




Gap Size - 0.15 mm to 0.25 mm

RETAINING COMPOUNDS

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

Gap Size - 0.25 mm to 0.5 mm

 635™ Mil-Spec	 660™ Badly Worn Assemblies Use with LOCTITE SF 7649
 Temperature Resistance: 150°C	 Temperature Resistance: 150°C
 Strength: 20 N/mm ²	 Strength: 17.2 N/mm ²
Cure Speed: 24 hours Fixture Time: 30 minutes*	Cure Speed: 24 hours Fixture Time: 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 ²)	Fixture Time [min]	Temperature Range
GAP SIZE - UP TO 0.25 mm								
680™	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						
620™	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						
232™	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
GAP SIZE - 0.5 mm								
660™	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/mm² after 7 days cure