

## RETAINING COMPOUNDS

Find the right product for your application



### GAP SIZE

#### Gap Size Up To 0.15 mm

LOCTITE® 609™  
LOCTITE® 641™  
LOCTITE® 648™

#### Gap Size 0.15 to 0.25 mm

LOCTITE® 232™  
LOCTITE® 620™  
LOCTITE® 638™  
LOCTITE® 635™  
LOCTITE® 680™

#### Gap Size 0.25 to 0.5 mm

LOCTITE® 660™

## Gap Size up to 0.15 mm

### RETAINING COMPOUNDS



**609™**

General Purpose



Temperature Resistance:  
150°C



Strength: 15.8 N/mm<sup>2</sup>

Cure Speed: 24 hours  
Fixture Time: 15 minutes\*



**641™**

Medium Strength



Temperature Resistance:  
150°C



Strength: 6.5 N/mm<sup>2</sup>

Cure Speed: 24 hours  
Fixture Time: 25 minutes\*



**648™**

High Strength

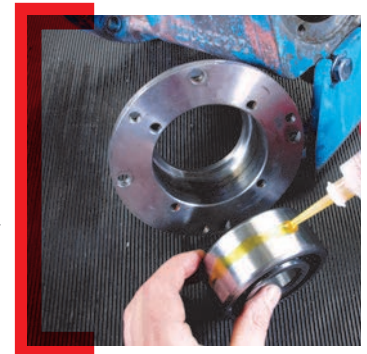


Temperature Resistance:  
180°C



Strength: 31 N/mm<sup>2</sup>

Cure Speed: 24 hours  
Fixture Time: 3 minutes\*



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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 0.15 mm</b>								
<b>609™</b>	471311	10 ml	Green	Medium strength - excellent load transmission capabilities, augment press fits	120	15.8	15	-55°C to 150°C
	234551	50 ml						
	234549	250 ml						
<b>640™</b>	135521	250 ml	Green	High Strength, slow fixture, Mil-R-46082B / ASTM D5363 tested	600	22	30	-55°C to 180°C
<b>641™</b>	469090	10 ml	Green	Controlled strength - ideal for cylindrical parts that require disassembly	600	6.5	20	-55°C to 150°C
	1496887	10 ml (automotive)						
	1496859	50 ml						
	1496874	250 ml						
<b>648™</b>	1800518	50 ml	Green	High strength, primerless, fast fixturing	500	25*	3	-55°C to 180°C
<b>GAP SIZE - UP TO 0.25 mm</b>								
<b>635™</b>	135516	50 ml	Green	High strength, Mil-R-46082B / ASTM D5363 tested	2000	20	30	-55°C to 150°C
	135517	250 ml						
<b>638™</b>	1878045	50 ml	Green	High strength for slip-fitted parts, primerless	2500	25**	4	-55°C to 180°C

\* Increase to 31 N/mm<sup>2</sup> after 7 days cure

\*\* Increase to 29 N/mm<sup>2</sup> after 7 days cure