

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/mm²

Cure Speed: 24 hours
Fixture Time: 15 minutes*



641™

Medium Strength



Temperature Resistance:
150°C



Strength: 6.5 N/mm²

Cure Speed: 24 hours
Fixture Time: 25 minutes*



648™

High Strength



Temperature Resistance:
180°C



Strength: 31 N/mm²

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 ²)	Fixture Time [min]	Temperature Range
GAP SIZE - UP TO 0.15 mm								
609™	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						
640™	135521	250 ml	Green	High Strength, slow fixture, Mil-R-46082B / ASTM D5363 tested	600	22	30	-55°C to 180°C
641™	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						
648™	1800518	50 ml	Green	High strength, primerless, fast fixturing	500	25*	3	-55°C to 180°C
GAP SIZE - UP TO 0.25 mm								
635™	135516	50 ml	Green	High strength, Mil-R-46082B / ASTM D5363 tested	2000	20	30	-55°C to 150°C
	135517	250 ml						
638™	1878045	50 ml	Green	High strength for slip-fitted parts, primerless	2500	25**	4	-55°C to 180°C

* Increase to 31 N/mm² after 7 days cure

** Increase to 29 N/mm² after 7 days cure