

# Gap Size - 0.15 mm to 0.25 mm

## RETAINING COMPOUNDS

|   |   |   |   |
|---|---|---|---|
| <br><b>232™</b><br>High Lubricity        | <br><b>620™</b><br>High Temperature        | <br><b>680™</b><br>General Purpose       | <br><b>638™</b><br>High Strength         |
|  <b>Temperature Resistance:</b><br>150°C |  <b>Temperature Resistance:</b><br>230°C** |  <b>Temperature Resistance:</b><br>180°C |  <b>Temperature Resistance:</b><br>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<br><b>Fixture Time:</b> 5 hours*  | <b>Cure Speed:</b> 24 hours<br><b>Fixture Time:</b> 60 minutes*   | <b>Cure Speed:</b> 24 hours<br><b>Fixture Time:</b> 4 minutes*  | <b>Cure Speed:</b> 24 hours<br><b>Fixture Time:</b> 4 minutes*  |

# Gap Size - 0.25 mm to 0.5 mm

|  |   |
|--|---|
| <br><b>635™</b><br>Mil-Spec               | <br><b>660™</b><br>Badly Worn Assemblies<br>Use with LOCTITE SF 7649 |
|  <b>Temperature Resistance:</b><br>150°C |  <b>Temperature Resistance:</b><br>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<br><b>Fixture Time:</b> 30 minutes*  | <b>Cure Speed:</b> 24 hours<br><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