

# Retaining



## PRESS FIT REPAIR

### LOCTITE® 603™ RETAINING COMPOUND

#### *Oil Tolerant*

A retaining compound tolerant of oil and other contamination. Seals and secures cylindrical assemblies up to 0.005" diametral clearance. Fixtures in 10 minutes. Prevents fretting and corrosion of metal assemblies.

### LOCTITE® 609™ RETAINING COMPOUND

#### *General Purpose*

A low viscosity, fast curing adhesive used for bonding rigid metal assemblies. Ideal for gap distances up to 0.005" (0.13 mm). Loctite® 609™ fixtures in just 10 minutes and provides shear strength of 3,000 psi after 24 hours. It easily joins dissimilar metals and withstands temperatures up to 300°F (149°C).

### LOCTITE® 660™ QUICK METAL® RETAINING COMPOUND

A creamy, non-running gel that is applied onto cylindrical parts to fill surface imperfections and repair worn areas. It contains no metal, but once assembled hardens to a strength that often doubles that of a press fit. Use Loctite® 660™ to salvage worn metallic parts, or to keep machinery running until new parts arrive. Use to 300°F (149°C).

## SLIP FIT

### LOCTITE® 620™ RETAINING COMPOUND

#### *High Temperature*

A high temperature adhesive that has the capability to operate at 450°F (232°C) for long periods. Loctite® 620™ fixtures in 30 minutes at room temperature, but requires a secondary heat cure to generate the high temperature resistance. Used to bond cylindrical parts with gaps up to 0.015" (0.35 mm). Loctite® 620™ provides a shear strength of 3,800 psi on steel after 24 hours.

### LOCTITE® 680™ RETAINING COMPOUND

#### *High Strength*

A high strength, room-temperature-curing adhesive used to join fitted cylindrical parts. It fixtures in 10 minutes and provides a shear strength of 4,000 psi after 24 hours. Capable of filling diametral gaps up to 0.015" (0.27 mm). Loctite® 680™ allows relaxed machining tolerances and replaces clamp rings, set screws, and snap rings.

## GENERAL PURPOSE

### LOCTITE® QUICKSTIX™ 668™ RETAINING COMPOUND

**NEW**

A high temperature retaining compound in a revolutionary semi-solid formula. Patented, no-mess package offers added convenience and portability. Ideal for gaps up to 0.005" on the diameter. Withstands temperatures to 400°F (204°C).

## Loctite® Brand Retaining Compounds Properties Chart

PRODUCT	Item Number	Container	COLOR/APPEARANCE	MAXIMUM GAP FILL (DIAMETER)	SHEAR STRENGTH STEEL/STEEL* (PSI)	TEMPERATURE RANGE	SET-UP TIME	RECOMMENDED PRIMER	AGENCY APPROVALS
PRESS FIT	603™	21440 10 ml bottle 21441 50 ml bottle 21442 250 ml bottle	Green Liquid	0.005"	3,770 psi	-65°F to 300°F (-54°C to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	N/A
	609™	60921 10 ml bottle 60931 50 ml bottle 60941 250 ml bottle	Green Liquid	0.005"	2,300 psi minimum	-65°F to 300°F (-54°C to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	CFIA, Conforms to MIL-R-46082B for existing designs, ASTM D-5363 for new designs
	660™ Quick Metal®	66010 6 ml tube 66040 50 ml tube	Silver Paste	0.020"	3,335 psi	-65°F to 300°F (-54°C to 149°C)	Set-up: 20 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	CFIA
SLIP FIT	620™	62015 10 ml bottle 62040 50 ml bottle 62070 250 ml bottle	Green Liquid	0.015"	3,800 psi	-65°F to 450°F (-54°C to 232°C)	Set-up: 30 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	ABS, CFIA
	680™	68015 10 ml bottle 68035 50 ml bottle 68060 250 ml bottle	Green Liquid	0.015"	2,800 psi minimum	-65°F to 300°F (-54°C to 149°C)	Set-up: 10 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	ABS, NSF/ANSI 61
GENERAL PURPOSE	QuickStix™ 668™ <b>NEW</b>	39147 9 g stick 39148 19 g stick 39149 39 g stick	Green Stick	0.005"	1,870 psi	-65°F to 400°F (-54°C to 204°C)	Set-up: 30 minutes Full strength: 24 hrs.	7649™ Primer N™ or 7471™ Primer T™	N/A

