



# Retaining

## Securing Cylindrical Assemblies

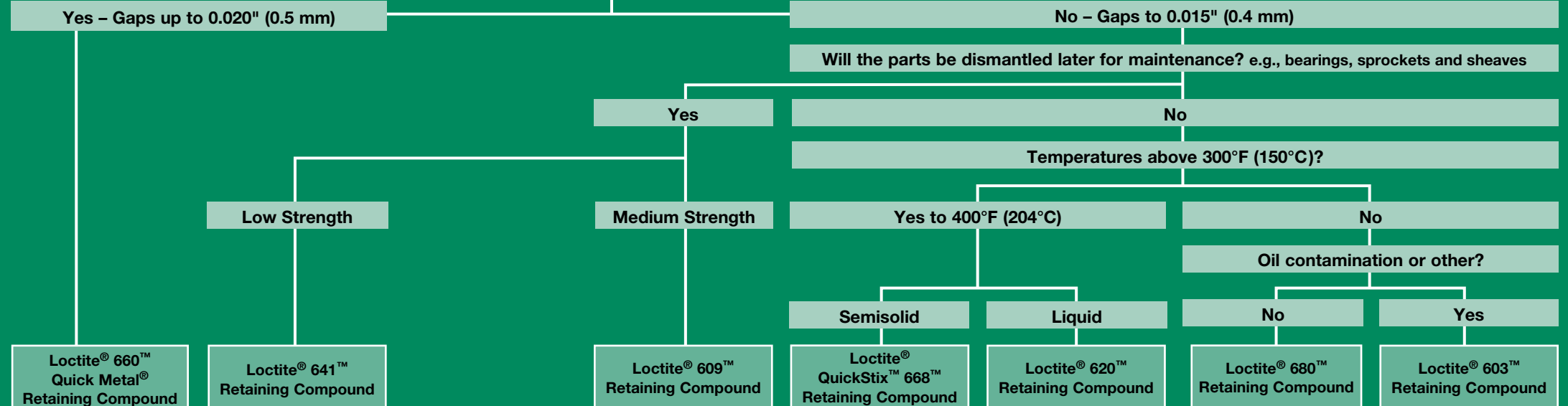
- Bond non-threaded cylindrical metal assemblies
- High and moderate strength products – can carry high loads and eliminate fretting
- Fill all voids – prevent corrosion
- Reduce the need for close tolerances
- 100% contact – load and stress are distributed evenly over the joint



### IS THE ASSEMBLY BADLY WORN?

#### Helpful Hints:

- If the retaining compound will be applied below 40°F (5°C), pre-treat with Loctite® 7649™ Primer N™ or Loctite® QuickStix™ 7088™ Primer.
- All parts must be clean and dry before sealing – use Loctite® ODC-Free Cleaner & Degreaser.
- If the parts have been in contact with washing or cutting fluids containing nitrates, wash with hot water.



#### Solution

	Loctite® 660™ Quick Metal® Retaining Compound	Loctite® 641™ Retaining Compound	Loctite® 609™ Retaining Compound	Loctite® QuickStix™ 668™ Retaining Compound	Loctite® 620™ Retaining Compound	Loctite® 680™ Retaining Compound	Loctite® 603™ Retaining Compound
<b>Strength Required</b>	High	Low	Medium	Medium	High	High	High
<b>Shear Strength</b>	3,335 psi	1,700 psi	2,300 psi	1,870 psi	3,800 psi	2,800 psi minimum	3,770 psi
<b>Diametrical Clearance</b>	Up to 0.020" (0.5 mm)	Up to 0.006" (0.15 mm)	Up to 0.005" (0.1 mm)	Up to 0.005" (0.1 mm)	Up to 0.015" (0.4 mm)	Up to 0.015" (0.4 mm)	Up to 0.005" (0.1 mm)
<b>Temperature Resistance</b>	300°F (150°C)	300°F (150°C)	300°F (150°C)	400°F (204°C)	450°F (232°C)*	300°F (150°C)	300°F (150°C)
<b>Cure Time (Setup/Full Strength)</b>	20 min./24 hrs.	20 min./24 hrs.	10 min./24 hrs.	30 min./24 hrs.	30 min./24 hrs.	10 min./24 hrs.	10 min./24 hrs.
<b>Common Sizes/Part Number</b>	6 ml tube – 66010 50 ml tube – 66040	10 ml bottle – 28802 50 ml bottle – 21458	10 ml bottle – 60921 50 ml bottle – 60931 250 ml bottle – 60941	19 g stick – 39148	10 ml bottle – 62015 50 ml bottle – 62040 250 ml bottle – 62070	10 ml bottle – 68015 50 ml bottle – 68035 250 ml bottle – 68060	10 ml bottle – 21440 50 ml bottle – 21441 250 ml bottle – 21442

#### Use Loctite® 7649™ Primer N™ or Loctite® QuickStix™ 7088™ Primer:

1. Activate inactive surfaces.
2. Speed cure times for faster return to service.
3. Speed curing through larger gaps and deep threads.
4. Substantially speed cure times on cold parts.

**Active surfaces:** Brass, copper, bronze, iron, soft steel, nickel.

**Inactive surfaces:** Aluminum, stainless steel, magnesium, zinc, black oxide, cadmium, titanium, others.

**Package Size/** 7649™ Primer N™ – 1.75 fl. oz. bottle – 38402

**Part Number:** 7649™ Primer N™ – 4.5 oz. aerosol – 21348

QuickStix™ 7088™ – 17 g solventless semisolid stick – 1069258



#### Loctite® 660™ Quick Metal® Retaining Compound

Used for repairing worn coaxial parts without remachining; enables re-use of worn bearing seats, keys, splines, tapers, or for retaining shims. CFIA Approved.



#### Loctite® 641™ Retaining Compound

A controlled strength retaining compound that is ideal for cylindrical parts that require disassembly. CFIA Approved.



#### Loctite® 609™ Retaining Compound – Press Fit/General Purpose

Recommended for parts that will need subsequent dismantling, i.e., retention of bearings onto shafts and into housings. Mil-Spec (R-46082B) Type I.



#### Loctite® QuickStix™ 668™ Retaining Compound

A high temperature retaining compound in a revolutionary semisolid 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® 620™ Retaining Compound – Slip Fit/High Temperature

Recommended for high temperature retaining of parts with a clearance or interference fit, i.e., retaining bushes, bearings, seals, fans, and liners. Requires heat cure to achieve temperature resistance. ABS Approved.



#### Loctite® 680™ Retaining Compound – Slip Fit/High Strength

Gives best resistance to dynamic, axial and radial loads. Recommended for retaining shafts, gears, pulleys and similar cylindrical parts. NSF/ANSI 61 Approved. ABS Approved.



#### Loctite® 603™ Retaining Compound – Press Fit/Oil Tolerant

For retaining close-fitting cylindrical parts, up to 0.005" (0.1 mm) gap, and for use on cylindrical fitting parts where thorough degreasing is not possible. Applications include retaining roller bearings or oil-impregnated bushings into housings.