



RETAINING COMPOUND

Loctite Corporation, the pioneer of anaerobic adhesives, has applied this technology to create retaining compounds that increase the shear strength of cylindrical, non-threaded assemblies. Finding wide acceptance as a standard method for assembling press and slip-fitted parts, Loctite[®] Retaining Compounds fill the "inner space" between components and cure to form a strong precision assembly. Formulated in a selection of viscosities, gap filling ability, flexibility and strength characteristics, Loctite[®] Retaining Compounds can be applied with automated process equipment or dispensed manually.

609 Retaining Compound General Purpose

A low viscosity retaining compound that bonds rigid metal assemblies. Ideal for gap distances up to 0.005" diameter. Fixtures in 10 minutes and provides a shear strength of 3,000 psi after 24 hours. Easily joins dissimilar metals. Withstands temperatures to 300°F.

620 Retaining Compound High Temperature

A high temperature (450°F), high viscosity liquid retaining compound. Provides a shear strength of over 3,500 psi on steel. Locks and secures metal cylindrical assemblies up to .015" diameter clearance. Prevents metal fretting and corrosion. Seals against leakage.

660 Quick Metal[®] Retaining Compound Press Fit Repair

A creamy, non-running adhesive/sealant. Repairs worn machine parts. Restores correct fit to mating assemblies. Fills gaps up to 0.020" diameter clearance.

680 Retaining Compound High Strength/High Viscosity

A retaining compound for joining fitted cylindrical parts. Fixtures in 10 minutes and provides a shear strength of 4,000 psi on steel after 24 hours. Fills diametral gap distances up to 0.015".

Series	Spaenaur No.	Mfg. No.	Container	Typical Use	Colour	Gap Fill (Diametral)	Viscosity cP	Shear Strength Steel/Steel (PSI)*	Temp. Range	Cure Speed @ 25°C	Recomm. Primer	Key Specs.
609	800-212	60905	.5 ml capsule	1st generation to augment press fits	Green	.005"	125	3,000	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	T	Mil-Spec (R-46082B) Type I
	800-038	60921	10 ml bottle									
	800-039	60931	50 ml bottle									
	800-040	60941	250 ml bottle									
620	800-213	62005	.5 ml capsule	For high temperature applications	Green	.015"	8,500/22,000 Thixotropic	3,800	-65°F to 450°F	Fixture - 1 hr. Full - 24 hrs.	N	-
	800-214	62015	10 ml bottle									
	800-041	62040	50 ml bottle									
	800-042	62070	250 ml bottle									
660	800-043	66010	6 ml tube	For repair of worn machinery parts	Silver	.020"	250,000/1,500,000	3,335	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	N	Agriculture Canada approved
	800-044	66040	50 ml tube									
	800-215	30287	250 ml tube									
680	800-216	68005	.5 ml capsule	High strength for slip fitted parts	Green	.015"	1,250	4,000	-65°F to 300°F	Fixture - 10 min. Full - 24 hrs.	T	NSF/ANSI 61 approved
	800-217	68015	10 ml bottle									
	800-045	68035	50 ml bottle									
	800-046	68060	250 ml bottle									

*Varies with substrates

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