

**Retaining Compounds**

**Loctite® 680™ Retaining Compound Slip Fit/High Strength**



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 diametrical gap distances up to 0.015".



Part No.	Mfg. No.	Container Size	Color	Type	Gap Fill
0151009	68005	0.5 mL	Green	Retaining Compound	0.015"
0121779	68015	10 mL	Green	Retaining Compound	0.015"
0121780	68035	50 mL	Green	Retaining Compound	0.015"
0151010	68060	250 mL	Green	Retaining Compound	0.015"

**Loctite® 648™ Retaining Compound - Press Fit/High Strength/Rapid Cure**

This is a high strength retaining compound recommended for continuous working temperatures up to 300°F. It fills gaps up to 0.006" diametrical clearance. Fixtures in 5 minutes.

Uses: Holding gears and sprockets onto gearbox shafts and rotors on electric motor shafts.



Part No.	Mfg. No.	Container Size	Color	Type	Gap Fill
0150376	21443	10 mL	Green	Retaining Compound	0.006"
0150377	21444	50 mL	Green	Retaining Compound	0.006"
0150378	21445	250 mL	Green	Retaining Compound	0.006"

**Loctite® 638™ Retaining Compound Slip Fit/Maximum Strength**

A maximum strength retaining compound for use where high dynamic force or cyclic loading is expected. Locks cylindrical assemblies up to 0.010" diametral clearance. Fixtures in 5 minutes.



Part No.	Mfg. No.	Container Size	Color	Type	Gap Fill
0150380	21447	10 mL	Green	Retaining Compound	0.015"
0150381	21448	50 mL	Green	Retaining Compound	0.015"
0150382	21449	250 mL	Green	Retaining Compound	0.015"

**Loctite® 635™ Retaining Compound Slip Fit/High Strength/Slow Cure**

A high viscosity, high strength retaining compound with slow cure speed to permit readjustment of parts during assembly.



Part No.	Mfg. No.	Container Size	Color	Type
0151002	63531	50 mL	Green	Retaining Compound

**Loctite® 640™ Retaining Compound Medium Strength/High Temperature**

A high temperature anaerobic adhesive that secures slip and press fit assemblies.

- Adds up to 3,000 psi holding power.
- Restores fit to worn or out-of-tolerance assemblies.
- Prevents surface corrosion.
- Works to 400°F.



Part No.	Mfg. No.	Container Size	Color	Type
0151005	64031	50 mL	Green	Retaining Compound

**Loctite® 609™ Retaining Compound - Press Fit/General Purpose**

A low viscosity, rapid-curing anaerobic adhesive that augments the strength of press fit assemblies or slip fit assemblies up to 0.005" in diameter. Adds up to 3,000 psi holding power.



Part No.	Mfg. No.	Container Size	Color	Type	Gap Fill
62414	60941	250 mL	Green	Retaining Compound	0.005"

**Vibra-TITE® 53050 General Purpose Retaining Compound**



Vibra-Tite 530 General Purpose Retaining Compound bonds metal assemblies. A low viscosity retaining compound recommended for diametral gap distances up to 0.005" to augment press fits. Withstands temperatures of up to 300°F providing a shear strength of 3,000 psi after 24 hours with a fixture time of 10 minutes. Typical uses: Rotors, shafts, bushings, bearings, and pulleys.



Part No.	Mfg. No.	Container Size	Color	Viscosity cP	Gap Fill
0120877	53050	50 mL	Green	125	0.005"

**Vibra-TITE® 54150 High Strength Retaining Compound**

High Strength Retaining Compound that cures in room temperatures filling diametral gaps up to 0.015". Typical uses include fitted cylindrical parts replacing set screws, clamp rings, and snap rings. It provides a shear strength greater than 3,000psi after 24 hours with a fixture time of 10 minutes.



Part No.	Mfg. No.	Container Size	Color	Viscosity cP	Gap Fill
0120888	54150	50 mL	Green	1200	0.015"

**CHEMICALS & PAINTS**