

Loctite® Retaining Compounds Properties Chart

PRODUCT	Item Number	Package Type & Size	TYPICAL USE	COLOR	MAXIMUM GAP FILL (DIAMETER)	VISCOSITY (cP)	SHEAR STRENGTH STEEL/STEEL* (psi)	TEMPERATURE RANGE	CURE SPEED*	RECOMMENDED PRIMER	SPECIFIC GRAVITY	AGENCY APPROVALS	
CLOSE-FITTING PARTS	232™	18607 27863	1 liter bottle 250 ml bottle	Medium strength for heavy press fits	Brown	0.015"	5,000	1,350 psi* (2 hr. heat cure)	-65°F to 300°F	Fixture – > 1 hour Full – 24 hours	7088™, N™ or T™	1.02	N/A
	603™	21440 21441 21442	10 ml bottle 50 ml bottle 250 ml bottle	For close-fitting parts with light contamination	Green	0.005"	125	3,770	-65°F to 300°F	Fixture – 10 minutes Full – 24 hours	7088™, N™ or T™	1.10	N/A
	609™	60905 60921 60931 60941 60943	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	1st generation to augment press fits	Green	0.005"	125	2,300 (min.)	-65°F to 300°F	Fixture – 10 minutes Full – 24 hours	7088™, N™ or T™	1.10	MIL-R-46082B for existing designs, ASTM D-5363**, CFIA
	648™	21443 21444 21445	10 ml bottle 50 ml bottle 250 ml bottle	Fast fixturing for close-fitting parts, high strength for stainless steel	Green	0.006"	500	3,900	-65°F to 350°F	Fixture – 5 minutes Full – 24 hours	7088™, N™ or T™	1.13	N/A
	675™	67541	250 ml bottle	1st generation for close-fitting parts	Green	0.005"	125	3,000	-65°F to 300°F	Fixture – 20 minutes Full – 24 hours	7088™, N™ or T™	1.09	MIL-R-46082B for existing designs, ASTM D-5363**
GENERAL PURPOSE	QuickStix™ 668™	39147 39148 39149	9 g stick 19 g stick 39 g stick	General purpose, high temperature	Green Stick	0.005"	Semisolid	3,800	-65°F to 400°F	Fixture – 30 minutes Full – 24 hours	7088™, N™ or T™	1.122 8	N/A
HIGH TEMPERATURE	620™	62005 62015 62040 62070 62085	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	For high temperature applications	Green	0.015"	8,500	3,800	-65°F to 450°F	Fixture – 30 minutes Full – 24 hours	7088™, N™ or T™	1.16	CFIA, ABS
	640™	64031 64041	50 ml bottle 250 ml bottle	For high temperature applications	Green	0.007"	600	3,000	-65°F to 400°F	Fixture – 1 hour Full – 24 hours	7088™, N™ or T™	1.12	MIL-R-46082B for existing designs, ASTM D-5363**
LOOSE-FITTING PARTS	635™	63531 63541	50 ml bottle 250 ml bottle	1st generation high strength for slip fits	Green	0.010"	2,000	4,500	-65°F to 300°F	Fixture – 1 hour Full – 24 hours	7088™, N™ or T™	1.05	MIL-R-46082B for existing designs, ASTM D-5363**
	638™	21447 21448 21449	10 ml bottle 50 ml bottle 250 ml bottle	High strength for loose-fitting parts	Green	0.015"	2,500	4,500	-65°F to 300°F	Fixture – 5 minutes Full – 24 hours	7088™, N™ or T™	1.09	CFIA
	680™	68005 68015 68035 68060 68090	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength for slip-fitted parts	Green	0.015"	1,250	2,800	-65°F to 300°F	Fixture – 10 minutes Full – 24 hours	7088™, N™ or T™	1.11	NSF / ANSI 61, ABS
MEDIUM STRENGTH	641™	28802 21458	10 ml bottle 50 ml bottle	Medium strength for easier disassembly	Yellow	0.008"	525 / 1,950 Thixotropic	1,700	-65°F to 300°F	Fixture – 20 minutes Full – 24 hours	7088™, N™ or T™	1.07	CFIA
MACHINERY REPAIR	660™ Quick Metal®	66010 66040 30287	6 ml tube 50 ml tube 250 ml tube	For repair of worn machinery parts	Silver	0.020"	250,000 / 1,500,000 Thixotropic	3,335	-65°F to 300°F	Fixture – 20 minutes Full – 24 hours	7088™, N™ or T™	1.13	CFIA

* Varies with substrates.

** For new designs.



Indicates worldwide availability.



Indicates TOP CHOICE products.