



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

Yes – Gaps up to 0.020" (0.5 mm)

No – Gaps to 0.015" (0.4 mm)

Will the parts be dismantled later for maintenance? e.g. bearings, sprockets, and sheaves

Yes

No

Temperatures above 300°F (150°C)?

Yes to 400°F (200°C)

No

Oil Contamination or other?

No

Yes

Low Strength

Medium Strength

Semi-Solid

Liquid

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

Strength Required	High	Low	Medium	Medium	High	High	High
Shear Strength	3,335 psi	1,700 psi	2,300 psi	1,870 psi	3,800 psi	2,800 psi minimum	3,770 psi
Diametrical Clearance	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)
Temperature Resistance	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)
Cure Time (Setup / Full Strength)	20 min./24 hr.	20 min./24 hr.	10 min./24 hr.	30 min./24 hr.	30 min./24 hr.	10 min./24 hr.	10 min./24 hr.
Common Sizes / Part Number	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	9 g stick – 39147 19 g stick – 39148 38 g stick – 39149	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

* Requires heat cure to achieve temperature resistance

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.

Primer is optional with: Active surfaces: Brass, copper, bronze, iron, soft steel, nickel.

Primer is required with: 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 semi-solid stick – **1069256**



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.

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.



Loctite® QuickStix™ 668™ Retaining Compound

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.



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



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.



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



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