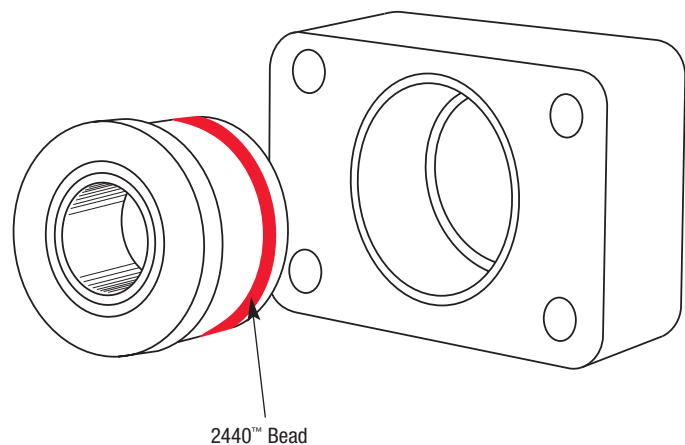


HOUSED COMPONENTS

RETAINING COMPOUNDS

SEALING/RETAINING – METALLIC SEAL



1. Clean the housing I.D. and seal O.D. with Loctite® ODC-Free Cleaner & Degreaser.
2. Spray both the housing and seal with Loctite® 7649™ Primer N™.
3. Apply a bead of Loctite® 2440™ (QuickStix™ 248™) Threadlocker to the leading edge of metallic seal O.D.

Note: Virtually any Loctite® Threadlocking product will work here. Medium strength liquid is recommended due to normal gap and strength requirement.

4. Install as usual.
5. Wipe off excess.
6. Allow to cure 30 minutes.

Note:

- Loctite® 2440™ (QuickStix™ 248™) Threadlocker is normally used with worn seal housings to prevent leakage or slippage.
- It is not generally necessary to remove pre-applied sealant from seal O.D.

LOCTITE® RETAINING COMPOUND QUICK SELECTOR

Application	Loctite® Product	Loctite® Primer
Shaft Mount – Press fit		
Medium Strength	609™ (QuickStix™ 668™) Retaining Compound	NONE
	641™ Retaining Compound	N™
Shaft Mount – Shrink fit		
Medium Strength	641™ Retaining Compound	NONE
Shaft Mount – Slip Fit		
Small Gap (.002" Radial max.)	609™ (QuickStix™ 668™) Retaining Compound	N™
Larger Gap (.010" Radial max.)	660™ Quick Metal® Retaining Compound	N™
Maximum Strength (.010" Radial max.)	680™ Retaining Compound	N™
Maximum Temperature (400°F) (.008" Radial max.)	620™ Retaining Compound	N™
Medium Strength	641™ Retaining Compound	N™
Housing Mount – Press Fit		
Maximum Strength	609™ (QuickStix™ 668™) Retaining Compound	NONE
Medium Strength	641™ Retaining Compound	N™
Low Strength	2440™ Threadlocker	NONE
Housing Mount – Slip Fit		
Maximum Strength	680™ Retaining Compound	NONE
High Strength	660™ Quick Metal® Retaining Compound	NONE
Controlled Strength	660™ Quick Metal® Retaining Compound	N™
Medium Strength	641™ Retaining Compound	N™
Low Strength	2440™ (QuickStix™ 648™) Threadlocker	N™

- Note:**
- Softer metals (Aluminum, Bronze, etc.) provide lower shear strengths than ferrous components.
 - Excessive gap reduces shear strengths.
 - Ideal surface finish – 50 to 80 rms.

Refer to Technical Data Sheets for more information.