

LOCTITE® Products

Retaining Compounds

LOCTITE® 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 Activator	Agency Approvals	
CLOSE-FITTING PARTS	232™	1 liter bottle 250 ml bottle	Medium strength for heavy press fits	Brown	0.38 mm (0.015")	5,000	1,350* (2 hrs. heat cure)	-54°C to 150°C (-65°F to 300°F)	Fixture – 1 hr. Full – 24 hrs.	7088™, 7649™ or 7471™	N/A	
	609™	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	Augments press fit parts	Green	0.15 mm (0.006")	125	2,300 (minimum)	-54°C to 150°C (-65°F to 300°F)	Fixture – 10 min. Full – 24 hrs.	7088™, 7649™ or 7471™	MIL-R-46082B for existing designs, ASTM D-5363**, CFIA	
	NEW 648™	1844659 1835922 1835920 1835918 1865917	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength, primerless, oil tolerant, general purpose	Green	0.15 mm (0.006")	500	3,900	-54°C to 180°C (-65°F to 355°F)	Fixture – 3 min. Full – 24 hrs.	Not required	NSF/ANSI 61, CFIA
LOOSE-FITTING PARTS	NEW 638™	1835937 1835936 1835925 1835924	10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength, primerless, oil tolerant, for slip-fitted parts	Green	0.25 mm (0.010")	2,500	4,500	-54°C to 180°C (-65°F to 355°F)	Fixture – 4 min. Full – 24 hrs.	Not required	NSF P1, CFIA
	NEW 680™	1835212 1835205 1835201 1835196 1835206	0.5 ml capsule 10 ml bottle 50 ml bottle 250 ml bottle 1 liter bottle	High strength, primerless, oil tolerant, for slip-fitted parts	Green	0.38 mm (0.015")	1,250	4,000	-54°C to 180°C (-65°F to 355°F)	Fixture – 4 min. Full – 24 hrs.	Not required	NSF/ANSI 61, ABS, CFIA
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	0.2 mm (0.008")	8,500	3,800	-54°C to 230°C (-65°F to 450°F)	Fixture – 1 hr. Full – 24 hrs.	7088™, 7649™ or 7471™	CFIA, ABS
MEDIUM STRENGTH	641™	28802 21458	10 ml bottle 50 ml bottle	Medium strength for easier disassembly	Yellow	0.2 mm (0.008")	525/1,950 Thixotropic	1,700	-54°C to 150°C (-65°F to 300°F)	Fixture – 20 min. Full – 24 hrs.	7088™, 7649™ or 7471™	CFIA
MACHINERY REPAIR	660™	66010 66040	6 ml tube 50 ml tube	For repair of worn machinery parts	Silver	0.5 mm (0.020")	250,000/ 1,500,000 Thixotropic	3,335	-54°C to 150°C (-65°F to 300°F)	Fixture – 20 min. Full – 24 hrs.	7088™, 7649™ or 7471™	CFIA

Activators

LOCTITE® PRODUCT	Item Number	Package Type & Size	Color	Viscosity (cP)	Base	On-Part Life	Dry Time	Application	Agency Approvals	
ACTIVATORS	7088™ PRIMER	1069258	17 g stick	Teal	Semisolid	No solvent	30 days	None	Anaerobics	N/A
	7090™ PRIMER	19368 12695	1 fl. oz. bottle 1 liter bottle	Dark Blue	17.5	No solvent	1 hour	<10 minutes	Anaerobics	N/A
	7471™ PRIMER T	19267 22477 19268	1.75 fl. oz. bottle 4.5 oz. net wt. aerosol can 1 gallon can	Amber	2	Acetone/ Isopropanol	7 days	30 to 70 seconds	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs
	7649™ PRIMER N	19269 21347 21348 19266	1.75 fl. oz. glass bottle 25 g net wt. aerosol can 4.5 oz. net wt. aerosol can 1 gallon can	Clear/ Green	2	Acetone	30 days	30 to 70 seconds	Anaerobics	MIL-S-22473E for existing designs, ASTM D-5363 for new designs, NSF/ANSI 61, NSF P1, CFIA

Cleaner & Degreaser

LOCTITE® PRODUCT	Item Number	Package Type & Size	Drying Time	Residue/Tinsability	Odor	Agency Approvals
ODC-FREE CLEANER & DEGREASER	22355 20162	15 oz. net wt. aerosol 16 fl. oz. pump spray	Equivalent to the evaporation rate of water. Wiping or blowers will accelerate dry time.	No rinse and no residue	Mild Citrus	NSF K1

Items in Red = Top Pick = Indicates Worldwide Availability * Varies with substrates. ** For new designs.