

## LOCTITE® Bonding Products - Retaining Compounds

### LOCTITE® 603 - Retaining Compound, High Strength, Oil-Tolerant



Ordering details: e.g.: Product No. 140 732 02, Loctite 603, Cont. 10 ml

Product No.	Contents in ml	Packaging Type	Weight in g
140 732 02	10	Bottle	20
140 732 03	50	Bottle	83

#### Specifications

- Strength: High.
- Handling strength (at room temperature on steel): after 8 min.
- Functional strength (Typical value at +22°C): min. 12 hrs.
- Bondline gap: to 0.1 mm.
- Temperature resistance: -55°C to +150°C.
- Danger (1, 3) H315, H317, H318, H335, H412.

#### Approvals

- P1 NSF Reg. No.: 123003.
- Tested and recommended by leading roller bearing manufacturers.

Oil-tolerant, universal bonding product for metal. Tolerates oil-based contaminations. Especially suited for the mounting of bearings (bondline gap to 0.1 mm). Rapid setting with high strength. When disassembling the parts, the connection should be heated to +250°C.

#### Applications

Bonding of bushes, bearings etc. in housings and on shafts with small bondline gap (to 0.1 mm).

### LOCTITE® 638 - Retaining Compound, High Strength, for Large Gaps



Ordering details: e.g.: Product No. 140 732 07, Loctite 638, Cont. 10 ml

Product No.	Contents in ml	Packaging Type	Weight in g
140 732 07	10	Bottle	20
140 732 08	50	Bottle	83

#### Specifications

- Strength: High.
- Handling strength (at room temperature on steel): after 4 min.
- Functional strength (Typical value at +22°C): min. 6 hrs.
- Bondline gap: To 0.25 mm.
- Temperature resistance: -55°C to +180°C.
- Danger (1, 3) H315, H317, H318, H335, H412.

#### Approvals

- WRC approval (BS 6920): 1307537.
- DVGW approval.
- P1 NSF Reg. No.: 123010.

Special bonding product for metal highly capable of filling gaps and fast reached handling strength. For gaps up to 0.25 mm. Temperature resistant to +150°C. Handling strength after only 4 minutes. When disassembling the parts, the connection should be heated to +250°C.

#### Applications

Bonding of bushes, bearings etc. in housings and on shafts with large bondline gap to 0.25 mm.

### LOCTITE® 648 - Retaining Compound, High Strength, with High Temperature Resistance



Ordering details: e.g.: Product No. 140 732 13, Loctite 648, Cont. 10 ml

Product No.	Contents in ml	Packaging Type	Weight in g
140 732 13	10	Bottle	20
140 732 14	50	Bottle	83

#### Specifications

- Strength: High.
- Handling strength (at room temperature on steel): after 3 min.
- Functional strength (Typical value at +22°C): min. 6 hrs.
- Bondline gap: To 0.15 mm.
- Temperature resistance: -55°C to +180°C.
- Danger (1, 3) H315, H317, H318, H335, H412.

Universal bonding product for metal, temperature resistant to +175°C. Capable of filling gaps up to 0.15 mm. Handling strength after only 3 minutes. When disassembling the parts, the connection should be heated to 250°C.

#### Applications

Bonding of bushes, bearings etc. in housings and on shafts, in applications where high operating temperatures prevail.

H315 Causes skin irritation.  
 H317 May cause an allergic skin reaction.  
 H318 Causes serious eye damage.  
 H335 May cause respiratory irritation.  
 H412 Harmful to aquatic life with long lasting effects.



Safety Data Sheets at [www.maedler.de](http://www.maedler.de) in the section Downloads