



LOCTITE
Retaining Compounds

Retaining compounds fill the space between parts to hold them in place with a high-strength bond. They harden in the absence of air (called anaerobic adhesives). Full cure in 24 hr.

Low-Viscosity—Bond rigid metal assemblies. Fixture in 10 min. Agency approvals: CFIA, MIL-R-46082B for existing designs, ASTM-D-5363 for new designs.

High-Temperature—High-viscosity for repairing valve sleeves, retaining valve seats, and affixing cylindrical liners. Fixture in 30 min. CFIA listed.

Note: Require a secondary heat cure at 356°F (180°C) to generate high-temp. resistance.

High-Strength—Room temp.-curing adhesives are for pulleys, cams, flywheels, and rotor-to-shaft bonds. Fixture in 10 min. NSF/ANSI-61 certified, ABS approved, and CFIA listed.

Specialty—Nonrun paste fills metal surface imperfections and repairs worn areas to keep machinery running. Repairs worn shafts, splines, keyways, and housings. Fixtures in 20 min. CFIA listed.



Loctite 609
4KM29



Loctite 660
5E227

Description	Shear Strength (psi)	Filling Gap Size	Max. Temp. (°F)	10mL Item No.	50mL Item No.	250mL Item No.
Low-Viscosity						
Loctite® 609	2,300 psi	Up to 0.006"	300°F	4KM29	4KM30	—
High-Temperature						
Loctite® 620	3,800 psi	Up to 0.015"	450°F	4KM32	4KM33	4KM34
High-Strength						
Loctite® 680	4,000 psi	Up to 0.015"	300°F	4KM40	—	3KE51

Trade Name	Shear Strength (psi)	Filling Gap Size	Max. Temp. (°F)	Size	Item No.
Specialty					
Loctite® 660™	3,335 psi	Up to 0.020"	300°F	6ml 50ml	2TRL2 5E227

Vibra-TITE LOCTITE

Devcon 3M

Primers, Activators, and Accelerators

Anaerobic adhesives cure in the absence of air and in the presence of metal ions. When assembling inactive metal parts, which are low in metal ions, primers are recommended to ensure proper adhesion. Use with anaerobic threadlockers, retaining compounds, pipe sealants, and gasketing materials.

Primer Is Recommended for Inactive Metals	Primer Is Optional for Active Metals
Aluminum - Anodized (Aldine, Irridite) and Pure, Black Oxide - Natural or Chemical, Cadmium, Gold, Inconel, Magnesium, Plated Parts, Silver, Stainless Steel, Steel - Galvanized and Magnette, Titanium, and Zinc	Brass, Bronze, Copper, Iron, Kovar, Manganese, Monel, Nickel, and Plain Steel



6V556



2VRL9



2VFK6



2JCA4



49CH77

Description	For Use With	Type	Size	Dry Time	Viscosity	Color	Brand	Mfr. Model	Item No.	
Primers										
61100	Anaerobics Adhesives	Acetone-Based	1 gal. Can	30 to 70 sec	2 cps	Light Green	Vibra-Tite	61100	49CH60	
61102	Anaerobics Adhesives	Acetone-Based	2 oz. Can	30 to 70 sec	2 cps	Light Green	Vibra-Tite	61102	49CH61	
61108	Anaerobics Adhesives	Acetone-Based	8 oz. Can	30 to 70 sec	2 cps	Light Green	Vibra-Tite	61108	49CH62	
61202	Anaerobics Adhesives	Acetone/Isopropanol-Based	2 oz. Can	30 to 70 sec	2 cps	Amber	Vibra-Tite	61202	49CH64	
61208	Anaerobics Adhesives	Acetone/Isopropanol-Based	8 oz. Can	30 to 70 sec	2 cps	Amber	Vibra-Tite	61208	49CH65	
625	Cyanoacrylates	Heptane-Based	4 oz. Can	Less Than 30 sec	1 cps	Light Amber	Vibra-Tite	62504	49CH80	
	Cyanoacrylates	Acetone-Based	1 gal. Can	Less Than 30 sec	1 cps	Light Amber	Vibra-Tite	62600	49CJ75	
626	Cyanoacrylates	Acetone-Based	4 oz. Can	Less Than 30 sec	1 cps	Light Amber	Vibra-Tite	62604	49CJ73	
	Cyanoacrylates	Acetone-Based	8 oz. Can	Less Than 30 sec	1 cps	Light Amber	Vibra-Tite	62608	49CJ72	
7090	Loctite Anaerobics to Ensure The Cure of Inactive Surfaces and Speed the Cure of Machinery Adhesives.	—	1L	Does Not Dry	17.5 cps	—	Loctite	88068	36D061	
Flexane Primer										
	—	Promotes Adhesion to Metal Parts	4-oz. Can	5 to 15 min	10 cps	Blue	Devcon	15980	6V556	
	—	Promotes Adhesion to Concrete, Rubber, and Wood	4-oz. Can	30 min	10 cps	Orange	Devcon	15985	6V557	
Loctite 7088										
	Anaerobics	Semisolid	17g Stick	Does Not Dry	Semisolid	Teal	Loctite	1069258	2VRL9	
	Anaerobic Adhesives	Aerosol	4.5 oz. Aerosol	30 to 70 sec	2 cps	—	Loctite	209715	4KL21	
Loctite 7649										
	Anaerobic Adhesives	Aerosol Can	25g Aerosol	30 to 70 sec	2 cps	Green	Loctite	231020	2VFK7	
	Anaerobic Adhesives	—	—	30 to 70 sec	2 cps	Light Green	Loctite	135286	4KL11	
	Anaerobic Adhesives	Bottle	1.75 oz. Bottle	30 to 70 sec	2 cps	Amber	Loctite	135285	2VFK6	
Loctite SF 7471										
	Anaerobic Adhesives And Sealants On Inactive Metals	—	4.5 oz. Aerosol	30 to 70 sec	2 cps	—	Loctite	135337	3HV17	
Loctite SF 770										
	Safety Walk	—	—	8 to 9 sec	0.62 cps	—	Loctite	2759219	794F22	
	Primer	3M™ Safety-Walk™ Slip-Resistant Tapes and Treads	Solvent-Based	1 qt.	15 min	900 to 1,500 cps	—	3M	19339	21YT80

Description	Size	Container Type	Color	Brand	Mfr. Model	Item No.	Base Type	Viscosity	Size	On-Part Life	Color	Brand	Mfr. Model	Item No.
Activators														
7387, For use with Depend Adhesive	1.75-oz. Bottle	Bottle	Yellow	Loctite	135276	2VFK3	Acetone/Heptane-Based	1 cps	2 oz. Can	24 hr	Clear	Vibra-Tite	62102	49CH67
	4.5-oz. Aerosol	Aerosol Can	Yellow	Loctite	209714	2VFK4		1 cps	4 oz. Can	24 hr	Clear	Vibra-Tite	62104	49CH68
	32 oz. Bottle	Bottle	Clear	3M	56533	2JCA3		1 cps	8 oz. Can	24 hr	Clear	Vibra-Tite	62108	49CH69
Fastbond 2000 NF	1L	Bottle	Clear	3M	1	2JCA4	Acetone-Based	0.4 cps	—	5 min	—	Loctite	2765219	794F23
	5 gal.	Pail	Clear	3M	1	2JBR3		0.4 cps	1.75 fl. oz. Bottle	24 hr	Clear	Loctite	135294	19TT66
Accelerators														
Acetone/Heptane-Based														
	1 cps	2 oz. Can	1 min	Light Amber	Vibra-Tite	62302		1 cps	2 oz. Can	1 min	Light Amber	Vibra-Tite	62302	49CH71
	1 cps	4 oz. Can	1 min	Light Amber	Vibra-Tite	62304		1 cps	4 oz. Can	1 min	Light Amber	Vibra-Tite	62304	49CH72
	1 cps	8 oz. Can	1 min	Light Amber	Vibra-Tite	62308		1 cps	8 oz. Can	1 min	Light Amber	Vibra-Tite	62308	49CH73
Heptane-Based														
	1 cps	2 oz. Can	1 min	Light Amber	Vibra-Tite	62402		1 cps	2 oz. Can	1 min	Light Amber	Vibra-Tite	62402	49CH75
	1 cps	4 oz. Can	1 min	Light Amber	Vibra-Tite	62404		1 cps	4 oz. Can	1 min	Light Amber	Vibra-Tite	62404	49CH76
	1 cps	8 oz. Can	1 min	Light Amber	Vibra-Tite	62408		1 cps	8 oz. Can	1 min	Light Amber	Vibra-Tite	62408	49CH77
Isopropanol-Based														
	1 cps	0.7 fl. oz. Spray	1 min	Clear	Loctite	229783		1 cps	0.7 fl. oz. Spray	1 min	Clear	Loctite	229783	2VFJ9
	1 cps	1.75 fl. oz. Bottle	1 min	Clear	Loctite	135316		1 cps	1.75 fl. oz. Bottle	1 min	Clear	Loctite	135316	2VFJ8