LOCTITE®

LOCTITE® 648

ANAEROBIC RETAINING COMPOUND

Room temperature curing retaining compound for bonding of cylindrical fitting parts like bearings, sprockets and gears onto shafts, including rotors onto electric motor shafts. The material provides high resistance to dynamic loads and can even reduce premature failure of spline assemblies by unitizing the assembly. This product cures when confined between close fitting metal surfaces in the absence of air.

Benefits

- High temperature resistance
  - › Service temperature from -55 - 180°C
- High strength
  - › Shear strength >27 N/mm² (3900 psi) on steel
- Suitable for passive substrates such as stainless steel and plated surfaces
- Works on slightly oily surfaces with lubrication, anti-corrosion, and protection fluids
- Low viscosity
  - › 500.0 mPa.s (cP)
- Resistant to oils, gasoline, brake fluids

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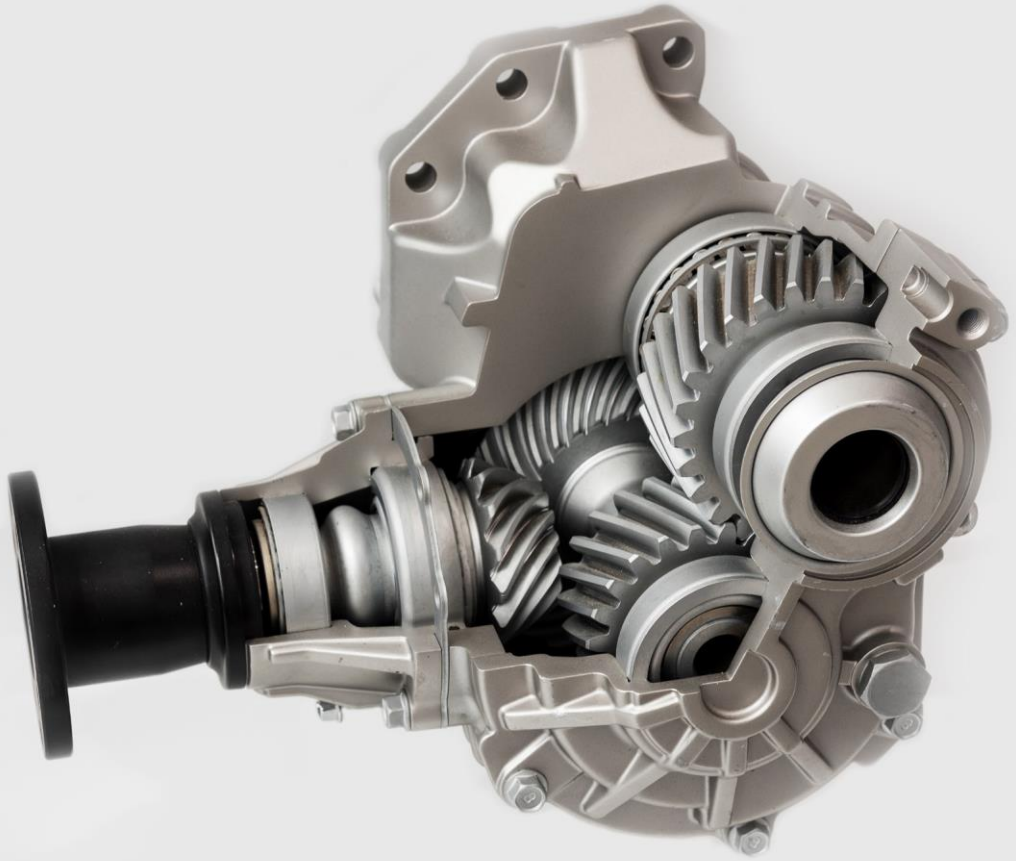

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Areas of application

Transmission, gearbox, electric motors

- Bearings, sprockets and gears on shafts
- Rotors on electric motor shafts
- Spline assemblies

Performance Characteristics

Outstanding strength and resistance enables more compact and lighter design of gears and drivetrain components without compromising performance or durability

Technical Data

Product family	Anaerobic acrylic
Color	Green
Fluorescence	Positive under UV light
Viscosity (Brookfield) at 25°C (mPa·s)	500
Compressive Shear Strength (N/mm^2), ISO 10123	≥ 27 (Steel, Stainless Steel)
Compressive Shear Strength (N/mm^2), ISO 10123	18 (Aluminum)
Operating temperature (°C)	Up to 180

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