

## Loctite® 648 High Strength/Rapid Cure Retaining Compound

Category : Polymer , Adhesive , Thermoset

### Material Notes:

RetainersLoctite Corporation, the pioneer of anaerobic adhesives, has applied this technology to create retaining compounds that increase the shear strength of cylindrical, non-threaded assemblies. Finding wide acceptance as a standard method for assembling press and slip-fitted parts, Loctite® Retaining Compounds fill the "inner space" between components and cure to form a strong precision assembly. Formulated in a selection of viscosities, gap filling ability, flexibility and strength characteristics, Loctite® Retaining Compounds can be applied with automatic process equipment or dispensed manually.Loctite® 648 High Strength/Rapid Cure Retaining CompoundA retaining compound recommended for continuous working temperatures up to 300°F. Fills gaps up to 0.006" diameter clearance. Fixtures in 5 minutes. Recommended Primer: 7649 (N). Typical Use: Fast fixturing for close fitting parts

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Loctite-648-High-StrengthRapid-CureRetaining-Compound.php](http://www.lookpolymers.com/polymer_Loctite-648-High-StrengthRapid-CureRetaining-Compound.php)

| Physical Properties | Metric    | English                   | Comments |
|---------------------|-----------|---------------------------|----------|
| Density             | 1.13 g/cc | 0.0408 lb/in <sup>3</sup> |          |
| Viscosity           | 500 cP    | 500 cP                    |          |

| Mechanical Properties  | Metric   | English  | Comments                            |
|------------------------|----------|----------|-------------------------------------|
| Adhesive Bond Strength | 26.9 MPa | 3900 psi | Steel/Steel; Varies with substrates |

| Thermal Properties               | Metric   | English  | Comments |
|----------------------------------|----------|----------|----------|
| Maximum Service Temperature, Air | 149 °C   | 300 °F   |          |
| Minimum Service Temperature, Air | -53.9 °C | -65.0 °F |          |

| Processing Properties | Metric               | English              | Comments         |
|-----------------------|----------------------|----------------------|------------------|
| Cure Time             | 5.00 min             | 0.0833 hour          |                  |
|                       | 1440 min             | 24.0 hour            | Full Cure; Steel |
|                       | @Temperature 25.0 °C | @Temperature 77.0 °F |                  |

| Descriptive Properties | Value     | Comments  |
|------------------------|-----------|-----------|
| Color                  | Green     |           |
| Gap Fill               | 0.006 in. | Diametral |

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