

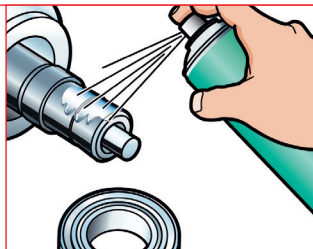
Retaining Compounds

How to apply LOCTITE® 603, 638, 660

1. Preparation

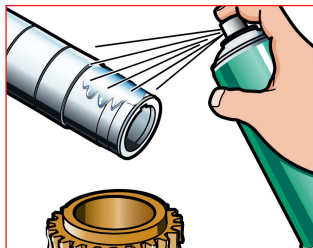
Cleaning

- Use LOCTITE® 7200 for easier removal of residues in case of old retaining adhesive
- It is recommended to use LOCTITE® 7063 to degrease and clean surfaces prior to applying the adhesive
- For larger gaps than 0,5 mm or worn out shafts, bearing seats or keyways, use LOCTITE® metal-filled compounds (see chapter **Metal-filled Compounds**)



Activation

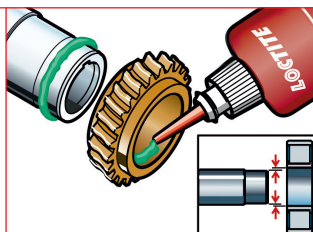
If cure speed is too slow due to passive metals or low temperature (below 5 °C), use activator Loctite® 7240 or Loctite® 7649 (see cure speed vs. activator graph in the TDS).



2. Application

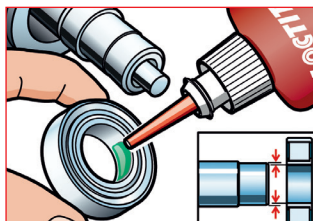
A For slip fitted assemblies: LOCTITE® 603, 638, 660

Apply adhesive around the leading edge of the male component and the inside of the female component and use rotating motion during assembly to ensure good coverage.



B For press fitted assemblies: LOCTITE® 603

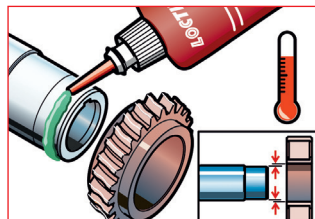
Apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.



C For shrink fitted assemblies:

Apply the adhesive onto the pin, heat the collar to create sufficient clearance for free assembly.

For product selection contact your Henkel Technical Service Team.

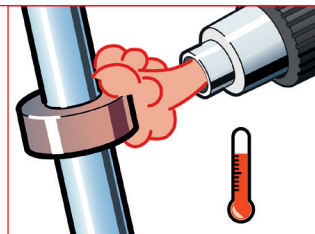


Equipment

Recommended dispensing equipment: IDH 608966 or IDH 88631 (see chapter **Equipment**).

3. Disassembly

- Apply localised heat to approximately 250 °C, disassemble while hot
- For corroded or seized parts, use LOCTITE® 8040 Freeze & Release



For detailed information please refer to the Technical Datasheet or contact your Henkel Technical Service Team.