

## Loctite® 609 General Purpose Retaining Compound

Category : Polymer , Adhesive , Thermoset

### Material Notes:

**Retainers:** Loctite 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® 609 General Purpose Retaining Compound A low viscosity retaining compound that bonds rigid metal assemblies. Ideal for gap distances up to 0.005" diameter. Fixtures in 10 minutes and provides a shear strength of 3,000 psi after 24 hours. Easily joins dissimilar metals. Withstands temperatures to 300°F. Recommended Primer: 7471 (T). Mil-Spec (R-46082B) Type I Typical Use: 1st generation to augment press fits

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Loctite-609-General-PurposeRetaining-Compound.php](http://www.lookpolymers.com/polymer_Loctite-609-General-PurposeRetaining-Compound.php)

Physical Properties	Metric	English	Comments
Density	1.10 g/cc	0.0397 lb/in <sup>3</sup>	
Viscosity	125 cP	125 cP	

Mechanical Properties	Metric	English	Comments
Adhesive Bond Strength	20.7 MPa	3000 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	10.0 min	0.167 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	0.005 in.	Diametral

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