

Vibra-TITE™

Anaerobic RETAINING COMPOUNDS

- Increases the shear strength on non-threaded cylindrical metal assemblies
- Fills voids between close-fitting metal assemblies
- Creates a solid one-piece assembly
- Seals joints against leakage
- Prevents corrosion



Vibra-TITE Part #	Available Sizes	Loctite® Part#	Product Description	Color	Approx. Viscosity (cP)	Max Gap (Fill, in)	Shear Strength (PSI)	Temp Range	Fixture Time (min)	Specific Gravity	Suggested Primer	Specs Met
530		675™/609™	GENERAL PURPOSE									
53002	2 mL Bullet		General purpose for: rotors, augment press fits, shafts, bushings, bearings and pulleys.	Green	125	0.005	2000+	-65°F to 300°F	10 - 20	1.10	N or T	MIL-R-46082 ASTM D-5363 GM-1183024
53010	10 mL Bottle	60921										
53050	50 mL Bottle	60931										
53025	250 mL Bottle	60941/67541										
53000	1 L Jug	60943										
538		638™	HIGH STRENGTH									
53850	50 mL Bottle	21448	High strength for loose fitting parts.	Green	2500	0.015	4000+	-65°F to 300°F	5	1.09	N or T	
53825	250 mL Bottle	21449										
53800	1 L Jug											
541		680™	HIGH STRENGTH - SLIP FIT									
54110	10 mL Bottle	68015	High strength gap filling. Permanently retains slip-fit. For: rotors, shafts, impellers, and splines.	Green	1200	0.015	3000+	-65°F to 300°F	20-40	1.11	T	NSF Non-Food
54150	50 mL Bottle	68035										
54125	250 mL Bottle	68060										
54100	1 L Jug	68090										
542		635™	HIGH STRENGTH - LARGE GAP									
54210	10 mL Bottle		High viscosity permits larger machine tolerances. For: rotors, shafts, impellers and splines.	Green	2000	0.015	4000+	-65°F to 300°F	20-40	1.05	T	MIL-R-46082 ASTM D-5363
54250	50 mL Bottle	63531										
54225	250 mL Bottle	63541										
54200	1 L Jug											
546		N/A	IMPACT RESISTANT									
54650	50 mL Bottle		Flexible for impact resistance.	Green	600	0.015	2000+	-65°F to 300°F	20-40	1.09	N	
54625	250 mL Bottle											
54600	1 L Jug											
548		648™	RAPID CURING									
54850	50 mL Bottle	21444	Fast fixturing for close fitting parts, high strength for stainless steel.	Green	500	0.007	3500+	-65°F to 350°F	5	1.09	N or T	
54825	250 mL Bottle	21445										
54800	1 L Jug											
550		11358™	CORE PLUG SEALANT									
55050	50 mL Bottle			Blue	8500	0.02	2300+	-65°F to 300°F	10 - 20	1.09	N	
55000	1 L Jug	11358										
560		640™	HIGH TEMPERATURE - FAST SET									
56010	10 mL Bottle		High temperature fast setting for: rotors, shafts, bushings, bearings and pulleys.	Green	600	0.007	3000+	-65°F to 400°F	5 - 60	1.12	N or T	MIL-R-46082 ASTM D-5363
56050	50 mL Bottle	64031										
56025	250 mL Bottle	64041										
56000	1 L Jug											
567		620™	HIGH TEMPERATURE - LARGE GAP									
56710	10 mL Bottle	62015	High temperature gap filling for: rotors, shafts, bushings, bearings and pulleys.	Green	7000	0.015	3500+	-65°F to 450°F	20 - 30	1.16	N or T	GM-1183024
56750	50 mL Bottle	62040										
56725	250 mL Bottle	62070										
56700	1 L Jug	62085										

Loctite is a registered trademark and 675, 609, 638, 680, 635, 648, 11358, 640 and 620 are trademarks of Henkel Corp. USA.

Vibra-TITE™

Anaerobic Retaining Compounds

Vibra-TITE 530 General Purpose Retaining Compound bonds metal assemblies. A low viscosity retaining compound recommended for diametral gap distances up to 0.005" to augment press fits. Withstands temperatures of up to 300° F providing a shear strength of 3,000psi after 24 hours with a fixture time of 10 minutes. Typical uses: Rotors, shafts, bushings, bearings, and pulleys. **COMPARE TO LOCTITE® 609™/675™**

Vibra-TITE 538 High Strength Retaining Compound provides maximum strength for use where high dynamic force or cyclic loading is anticipated. **COMPARE TO LOCTITE® 638™**

Vibra-TITE 541 High Strength Retaining Compound cures in room temperatures filling diametral gaps up to 0.015". Typical uses include fitted cylindrical parts replacing set screws, clamp rings, and snap rings. It provides a shear strength greater than 3,000psi after 24 hours with a fixture time of 10 minutes. **COMPARE TO LOCTITE® 680™**

Vibra-TITE 542 High Strength Retaining Compound is a high viscosity retaining compound that allows parts to be adjusted during assembly. It provides a shear strength greater than 4,000psi. Typical uses include slip fit components, rotors, shafts, impellers, and splines. **COMPARE TO LOCTITE® 635™**

Vibra-TITE 546 Substantial Impact Resistance flexible for high shock/impact performance from hub to rotor.

Vibra-TITE 548 Press Fit / Rapid Cure works with continuous operating temperatures up to 350°F. Provides a shear strength greater than 3,500psi. **COMPARE TO LOCTITE® 648™**

Vibra-TITE 550 Core Plug Sealant **COMPARE TO LOCTITE® 11358™**

Vibra-TITE 560 High Temperature Retaining Compound is a high temperature (400°F / 204°C), high strength adhesive for retention of cylindrical components, where disassembly is not required on press-fit assemblies. It provides a shear strength greater than 3,000psi. Typical uses: Rotors, shafts, bushings, bearings, and pulleys with temperatures up to 400°F. **COMPARE TO LOCTITE® 640™**

Vibra-TITE 567 High Temperature Retaining Compound locks metal cylindrical assemblies with diametral clearances up to 0.015". Provides a shear strength greater than 3,500 psi on steel sealing against leakage while preventing corrosion. Typical uses: Rotors, shafts, bushings, bearings, and pulleys. **COMPARE TO LOCTITE® 620™**

Benefits:

- Reduce machining costs
- Press/Shrink fits can be replaced with slip fits
- No expensive finishes required
- Increase mechanical strength of the assembly
- 100% surface contact
- Retains and seals, eliminates corrosion and seizure
- Restore fit to worn or out-of-tolerance assemblies
- Eliminate part replacement
- Part distortion is eliminated

Typical Applications:

- Mount bearings in housings or shafts
- Mount motors, gears, sprockets and pulleys on shafts
- Retain cylindrical linings
- Replace keys and set screws
- Augment slip fits
- Lock keyways
- Secure splines, bushings, bearings, oil seals, water pumps core plugs and more

Vibra-Tite Anaerobic Retaining Compounds are designed to increase shear strength on non-threaded, cylindrical metal assemblies. The liquid anaerobic material fills voids between close-fitting metal assemblies. It cures to a toughened thermoset-plastic which creates a solid one piece assembly. Retaining compounds seal joints against leakage and prevent corrosion. These materials have gained wide acceptance as a standard method for assembling press-fit and slip-fitted parts.



Vibra-TITE™
RETAINING COMPOUNDS