



1001 Trout Brook Crossing  
Rocky Hill, CT 06067-3910  
Telephone: (860) 571-5100  
FAX: (860) 571-5465

## Product Description Sheet

### Product 635

Industrial Products, December 2000

#### PRODUCT DESCRIPTION

LOCTITE® Product 635 is a high strength, high viscosity, single component anaerobic retaining adhesive for cylindrical joints. The product cures when confined in the absence of air between close fitting metal surfaces.

#### TYPICAL APPLICATIONS

Used to bond cylindrical fitting parts. Typical applications include rotor to shafts in fractional and subfractional horsepower motors. Locks bearings in place, preventing spin out. Locks bushings and sleeves in housings on shafts. Augments press fits.

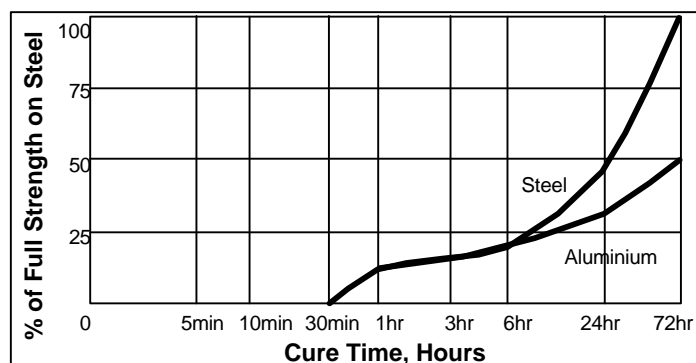
#### PROPERTIES OF UNCURED MATERIAL

	Value	Typical Range
Chemical Type	Methacrylate Ester	
Appearance	Green Liquid	
Specific Gravity @ 25°C	1.1	
Viscosity @ 25°C, mPa.s (cP)		
Brookfield RVT		
Spindle No. 3, 20 rpm	2000	1500 to 2500
Flash Point (TCC), °C	>93	

#### TYPICAL CURING PERFORMANCE

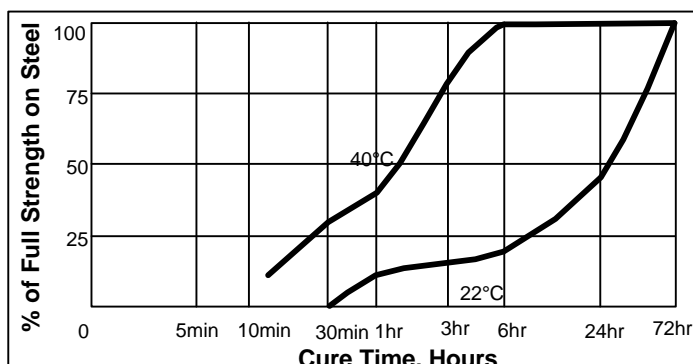
##### Cure speed vs. substrate

The rate of cure will depend on substrate used. The graph below shows shear strength developed with time on steel pins and collars compared to different materials and tested according to ISO-10123.



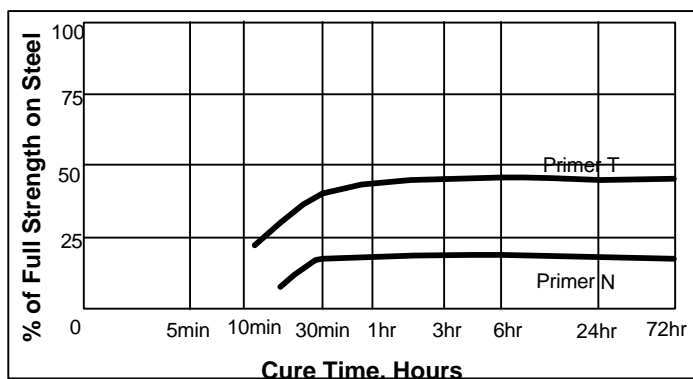
##### Cure speed vs. temperature

The rate of cure will depend on the ambient temperature. The graph below shows shear strength developed with time on steel pins and collars at different temperatures and tested according to ISO-10123.



##### Cure speed vs. primer

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows shear strength developed with time using Primer N and T on zinc dichromated steel pins and collars and tested according to ISO-10123.



#### TYPICAL PROPERTIES OF CURED MATERIAL

##### Physical Properties

Coefficient of thermal expansion, ASTM D696, K <sup>-1</sup>	0.1
Coefficient of thermal conductivity, ASTM C177, W.m <sup>-1</sup> K <sup>-1</sup>	0.1
Specific Heat, kJ.kg <sup>-1</sup> K <sup>-1</sup>	0.3
% Elongation at Break, ASTM D412	<2

#### PERFORMANCE OF CURED MATERIAL

(Heat Cured for 1 hr at 93°C, tested at 22°C on steel)

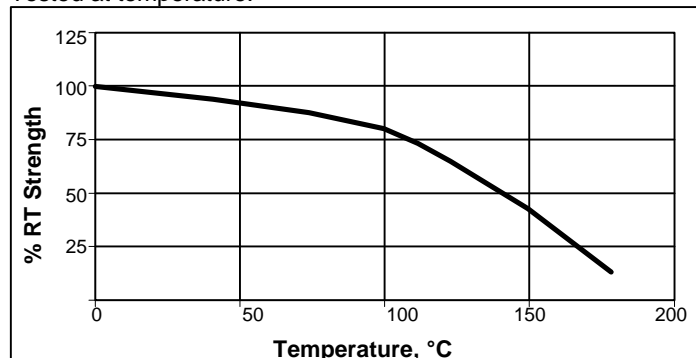
	Value	Typical Range
Shear Strength, DIN 54452, N/mm <sup>2</sup> (psi)	30.8 (4500)	minimum minimum

## TYPICAL ENVIRONMENTAL RESISTANCE

Test Procedure : Shear Strength, ISO-10123  
 Substrate: Steel Pins and Collars  
 Cure procedure: 1 week at 22°C

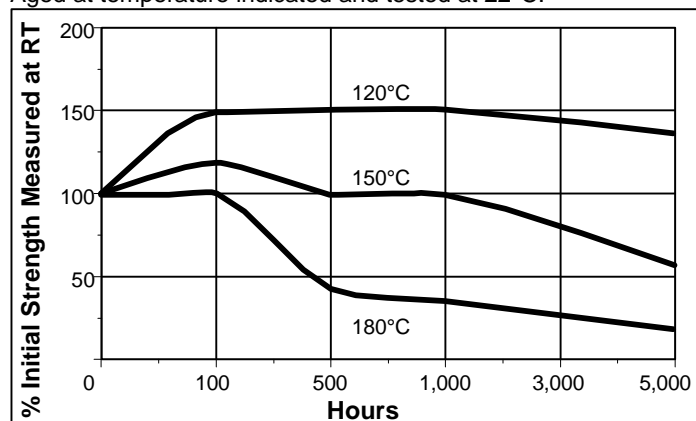
### Hot Strength

Tested at temperature.



### Heat Aging

Aged at temperature indicated and tested at 22°C.



### Chemical / Solvent Resistance

Aged under conditions indicated and tested at 22°C.

Solvent	Temp.	% Initial Strength retained at		
		100 hr	500 hr	1000 hr
Motor Oil	125°C	100	100	100
Unleaded Gasoline	22°C	100	90	85
Brake Fluid	22°C	100	90	80
Water/Glycol (50%/50%)	87°C	95	80	80
Ethanol	22°C	100	100	75
Acetone	22°C	90	90	90

## GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). It is recommended to confirm the compatibility of the product with such substrates.

### Directions for use

For best performance surfaces should be clean and free of grease. Ensure joint is completely filled with adhesive. For slip fitted assemblies this is achieved by applying adhesive around the pin and the leading edge of the collar and using a rotating motion during assembly to ensure good coverage. For press fitted assemblies adhesive should be applied thoroughly to both bond surfaces and assembled at high press on rates. For shrink fitted assemblies the adhesive should be coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly. Parts should not be disturbed until sufficient handling strength is achieved. This grade will develop temperature resistance after exposure to a heat cure of one hour at 180°C or longer times at temperatures above 120°C in service. For more detailed information on using retaining adhesives contact your local technical service center.

### Storage

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact your local Technical Service Center.

### Data Ranges

The data contained herein may be reported as a typical value and/or range (based on the mean value  $\pm 2$  standard deviations). Values are based on actual test data and are verified on a periodic basis.

### Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.