

Vibra-TITE® 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
- UV / Blacklight indicator



Vibra-Tite Part #	Available Sizes	LOCTITE® Part#	Product Description	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 - GREEN								
53002	1.8 mL Bullet		General purpose for: rotors, augments, press fits, shafts, bushings, bearings and pulleys.	125	0.005	2300+	-65°F to 300°F	10 - 20	1.10	611 or 612	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									
535			GENERAL PURPOSE GEL - GREEN								
53502	50 mL Tube		High strength no drip anaerobic gel with good temperature and solvent resistance.	Gel	0.015		-65°F to 300°F	5 - 10	1.09	611 or 612	
53525	250 mL Tube										
538		638™	HIGH STRENGTH - GREEN								
53850	50 mL Bottle	21448	High strength for loose fitting parts.	2500	0.015	4000+	-65°F to 300°F	5	1.09	611 or 612	
53825	250 mL Bottle	21449									
53800	1 L Jug										
541		680™	HIGH STRENGTH - SLIP FIT - GREEN								
54102	1.8 mL Bullet		High strength gap filling. Permanently retains slip-fit. For: rotors, shafts, impellers, and splines.	1200	0.015	3000+	-65°F to 300°F	20-40	1.11	612	NSF Non-Food
54110	10 mL Bottle	68015									
54150	50 mL Bottle	68035									
54125	250 mL Bottle	68060									
54100	1 L Jug	68090									
542		635™	HIGH STRENGTH - LARGE GAP - GREEN								
54202	1.8 mL Bullet		High viscosity permits larger machine tolerances. For: rotors, shafts, impellers and splines.	2000	0.015	4000+	-65°F to 300°F	20-40	1.05	612	MIL-R-46082 ASTM D-5363
54210	10 mL Bottle										
54250	50 mL Bottle	63531									
54225	250 mL Bottle	63541									
54200	1 L Jug										
546		N/A	IMPACT RESISTANT - GREEN								
54650	50 mL Bottle		Flexible for impact resistance.	600	0.015	2000+	-65°F to 300°F	20-40	1.09	611	
54625	250 mL Bottle										
54600	1 L Jug										
548		648™	RAPID CURING - GREEN								
54850	50 mL Bottle	21444	Fast fixturing for close fitting parts, high strength for stainless steel.	500	0.007	3500+	-65°F to 350°F	5	1.09	611 or 612	
54825	250 mL Bottle	21445									
54800	1 L Jug										
550		540™	CORE PLUG SEALANT - BLUE								
55050	50 mL Bottle		Designed to be used on freeze, core, and cup plug applications.	8500	0.02	2300+	-65°F to 300°F	10 - 20	1.09	611	
55000	1 L Jug	11358									
560		640™	HIGH TEMPERATURE - FAST SET - GREEN								
56002	1.8 mL Bullet		High temperature fast setting for: rotors, shafts, bushings, bearings and pulleys.	600	0.007	3000+	-65°F to 400°F	5 - 60	1.12	611 or 612	MIL-R-46082 ASTM D-5363
56010	10 mL Bottle	64031									
56050	50 mL Bottle	64041									
56025	250 mL Bottle										
56000	1 L Jug										
566		660™	GAP FILLING - FOR WORN PARTS - GREY								
56650	50 mL Tube		High viscosity, press-fit, slip-fit.	Paste	0.020	2400+	-65°F to 350°F	30-45	1.04	611 or 612	
567		620™	HIGH TEMPERATURE - LARGE GAP - GREEN								
56702	1.8 mL Bullet		High temperature gap filling for: rotors, shafts, bushings, bearings and pulleys.	7000	0.015	3500+	-65°F to 450°F	20 - 30	1.16	611 or 612	GM-1183024
56710	10 mL Bottle	62015									
56750	50 mL Bottle	62040									
56725	250 mL Bottle	62070									
56700	1 L Jug	62085									

Vibra-TITE[®]

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 3,000 psi after 24 hours with a fixture time of 10 minutes. Typical uses: Rotors, shafts, bushings, bearings, and pulleys. **COMPETES WITH LOCTITE[®] 609™/675™**

Vibra-Tite 538 High Strength Retaining Compound provides maximum strength for use where high dynamic force or cyclic loading is anticipated. **COMPETES WITH 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 3,000 psi after 24 hours with a fixture time of 10 minutes. **COMPETES WITH 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 4,000 psi. Typical uses include slip fit components, rotors, shafts, impellers, and splines. **COMPETES WITH 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 3,500 psi. **COMPETES WITH LOCTITE[®] 648™**

Vibra-Tite 550 Core Plug Sealant is designed to be used on freeze, core, and cup plug applications. A thixotropic formula, it lends itself well to vertical dispensing. **COMPETES WITH LOCTITE[®] 540™**

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 3,000 psi. Typical uses: Rotors, shafts, bushings, bearings, and pulleys with temperatures up to 400°F. **COMPETES WITH LOCTITE[®] 640™**

Vibra-Tite 566 Gap Filling Compound is designed for use on worn cylindrical parts where tolerances are poor. **COMPETES WITH LOCTITE[®] 660™**

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. **COMPETES WITH 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