



**LOCTITE® 635™**

January 2010

**PRODUCT DESCRIPTION**

LOCTITE® 635™ provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Dimethacrylate ester
<b>Appearance (uncured)</b>	Green opaque liquid <sup>LMS</sup>
<b>Fluorescence</b>	Positive under UV light <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Viscosity</b>	Medium
<b>Cure</b>	Anaerobic
<b>Secondary Cure</b>	Activator
<b>Application</b>	Retaining
<b>Strength</b>	High

LOCTITE® 635™ is designed for the bonding of cylindrical fitting parts. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. Typical applications include rotor to shafts in fractional and subfractional horsepower motors. Locks bushings and sleeves in housings on shafts. Augments press fits.

**Mil-R-46082B**

LOCTITE® 635™ is tested to the lot requirements of Military Specification Mil-R-46082B. **Note:** This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

**ASTM D5363**

Each lot of adhesive produced in North America is tested to the general requirements defined in paragraphs 5.1.1 and 5.1.2 and to the Detail Requirements defined in section 5.2.

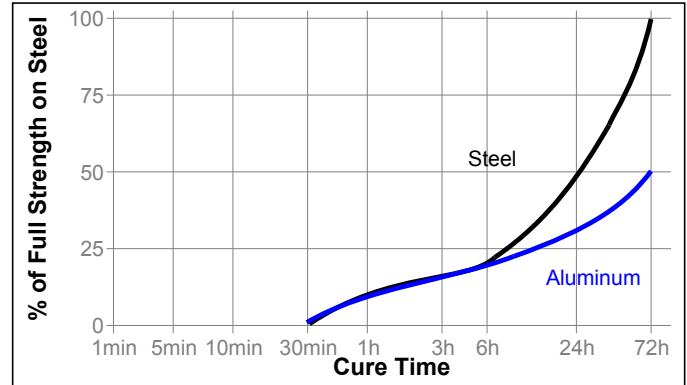
**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Specific Gravity @ 25 °C	1.1
Flash Point - See MSDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 3, speed 20 rpm	1,500 to 2,500 <sup>LMS</sup>

**TYPICAL CURING PERFORMANCE**

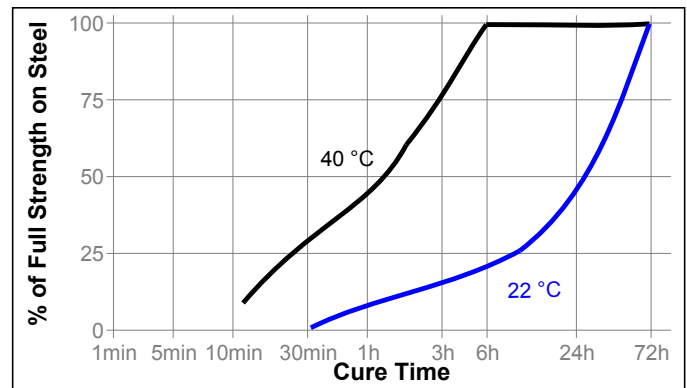
**Cure Speed vs. Substrate**

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



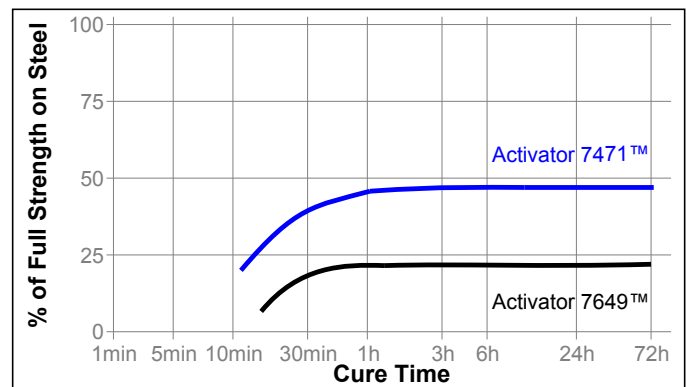
**Cure Speed vs. Temperature**

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



**Cure Speed vs. Activator**

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the shear strength developed with time on zinc dichromate steel pins and collars using Activator 7471™ and 7649™ and tested according to ISO 10123.



**TYPICAL PROPERTIES OF CURED MATERIAL****Physical Properties:**

Coefficient of Thermal Expansion, ISO 11359-2, K <sup>-1</sup>	80×10 <sup>-6</sup>
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Specific Heat, kJ/(kg·K)	0.3
Elongation, at break, ISO 37, %	<2

**TYPICAL PERFORMANCE OF CURED MATERIAL****Adhesive Properties**

Cured for 30 minutes @ 22 °C, Activator 7471™ on 1 side

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm <sup>2</sup>	≥13.8 <sup>LMS</sup>
	(psi)	(≥2,001)

Cured for 24 hours @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm <sup>2</sup>	≥20 <sup>LMS</sup>
	(psi)	(≥2,900)

Cured for 1 hour @ 93 °C, tested @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm <sup>2</sup>	≥31 <sup>LMS</sup>
	(psi)	(≥4,495)

Cured for 1 hour @ 93 °C, followed by 1 hour @ 149 °C, tested @ 149 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm <sup>2</sup>	≥9.6 <sup>LMS</sup>
	(psi)	(≥1,392)

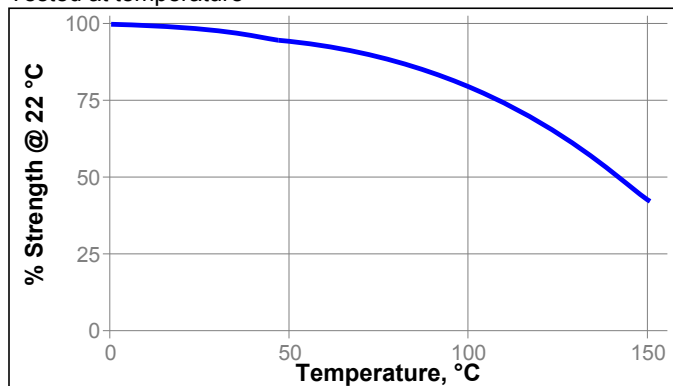
**TYPICAL ENVIRONMENTAL RESISTANCE**

Cured for 1 week @ 22 °C

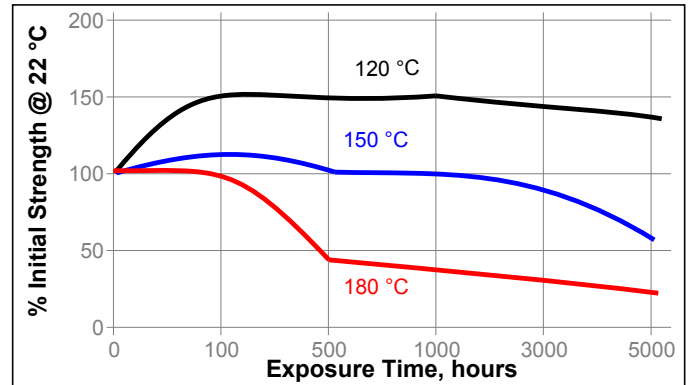
Compressive Shear Strength, ISO 10123: Steel pins and collars
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**Hot Strength**

Tested at temperature

**Heat Aging**

Aged at temperature indicated and tested @ 22 °C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Motor oil (MIL-L-46152)	125	100	100	100
Brake fluid	22	100	90	80
Ethanol	22	100	100	75
Acetone	22	90	90	90
Water/glycol 50/50	87	95	80	80
Unleaded gasoline	22	100	90	85

**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). Users are recommended to confirm compatibility of the product with such substrates.

**Directions for use:****For Assembly**

1. For best results, clean all surfaces (external and internal) with a LOCTITE® cleaning solvent and allow to dry.
2. If the material is an inactive metal or the cure speed is too slow, spray with Activator 7471™ or 7649™ and allow to dry.
3. **For Slip Fitted Assemblies**, apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.

4. **For Press Fitted Assemblies**, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.
5. **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.
6. Parts should not be disturbed until sufficient handling strength is achieved.

#### For Disassembly

1. Apply localized heat to the assembly to approximately 250 °C. Disassemble while hot.

#### For Cleanup

1. Cured product can be removed with a combination of soaking in a Loctite solvent and mechanical abrasion such as a wire brush.

#### Loctite Material Specification<sup>LMS</sup>

LMS dated March 25, 1997. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

#### Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

#### Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

#### Note

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Reference 2.3

