

## LOCTITE® 668™

August 2018

### PRODUCT DESCRIPTION

LOCTITE® 668™ provides the following product characteristics:

|                             |                                        |
|-----------------------------|----------------------------------------|
| <b>Technology</b>           | Acrylic                                |
| <b>Chemical Type</b>        | Methacrylate ester                     |
| <b>Appearance (uncured)</b> | Green, wax consistency <sup>LMS</sup>  |
| <b>Appearance (form)</b>    | Stick                                  |
| <b>Fluorescence</b>         | Positive under UV light <sup>LMS</sup> |
| <b>Components</b>           | One component - requires no mixing     |
| <b>Cure</b>                 | Anaerobic                              |
| <b>Secondary Cure</b>       | Activator                              |
| <b>Application</b>          | Retaining                              |
| <b>Strength</b>             | Medium to High                         |

LOCTITE® 668™ is designed for the bonding of cylindrical fitting parts. As with liquid anaerobic products, this material develops its cured properties in the absence of air when confined between close fitting metal surfaces. It is supplied as a wax-like semi-solid, conveniently packaged in a self-feeding stick applicator. It is particularly well suited for applications where a liquid product may be too fluid to stay on a part or be difficult to apply. It stores easily and allows for direct contact to metal parts during application to ensure even coverage.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

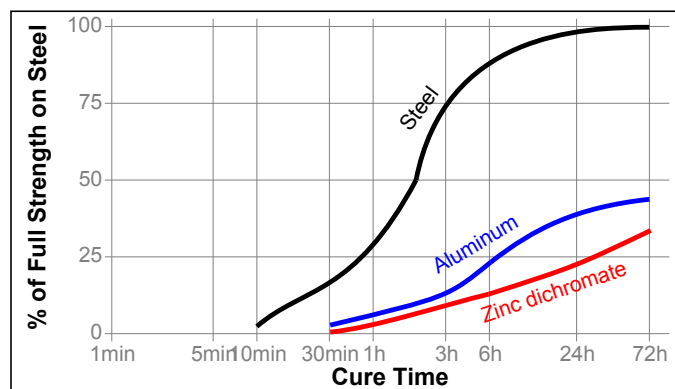
Flash Point - See SDS

Unworked Penetration, ISO 2137, 1/10 mm 70 to 130<sup>LMS</sup>

### TYPICAL CURING PERFORMANCE

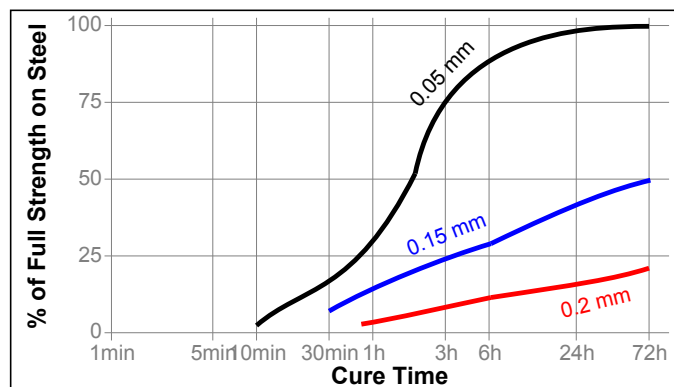
#### Cure Speed vs. Substrate

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.



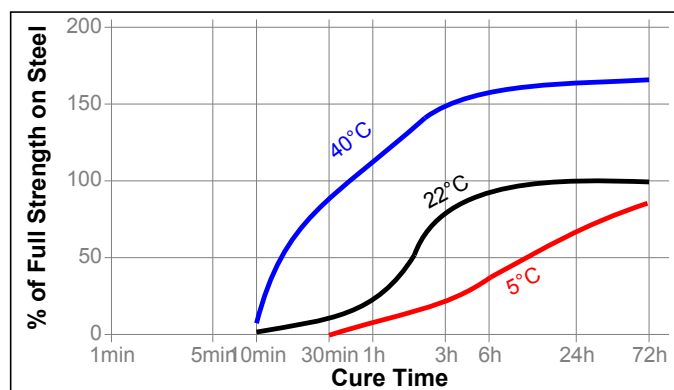
#### Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graph shows shear strength developed with time on steel pins and collars at different controlled gaps and tested according to ISO 10123.



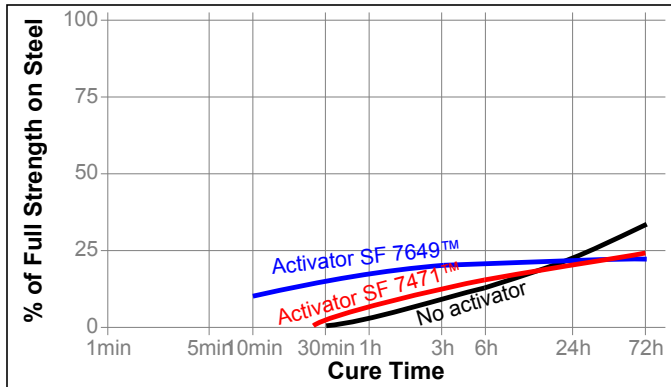
#### Cure Speed vs. Temperature

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 SF 7471™ or SF 7649™ and tested according to ISO 10123.



## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties:

Coefficient of Thermal Expansion,  $61 \times 10^{-6}$   
ISO 11359-2, K<sup>-1</sup>

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

Cured for 24 hours @ 22 °C

Compressive Shear Strength, ISO 10123:  
Steel pins and collars  $\text{N/mm}^2 \geq 7^{\text{LMS}}$   
(psi) ( $\geq 1,015$ )

Cured for 24 hours @ 22 °C, followed by 24 hours @ 177 °C, tested @ 22 °C

Compressive Shear Strength, ISO 10123:  
Steel pins and collars  $\text{N/mm}^2 \geq 18^{\text{LMS}}$   
(psi) ( $\geq 2,610$ )

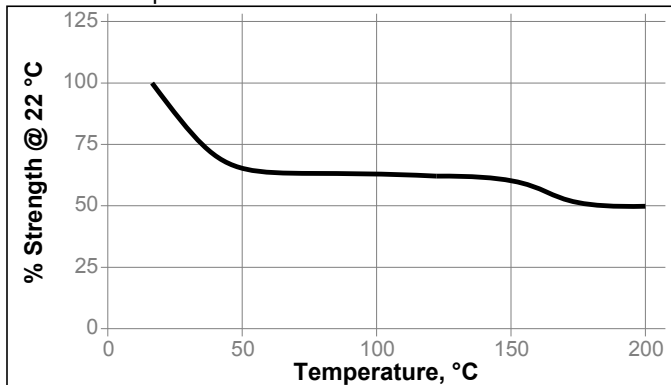
## TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 1 week @ 22 °C

Compressive Shear Strength, ISO 10123:  
Steel pins and collars

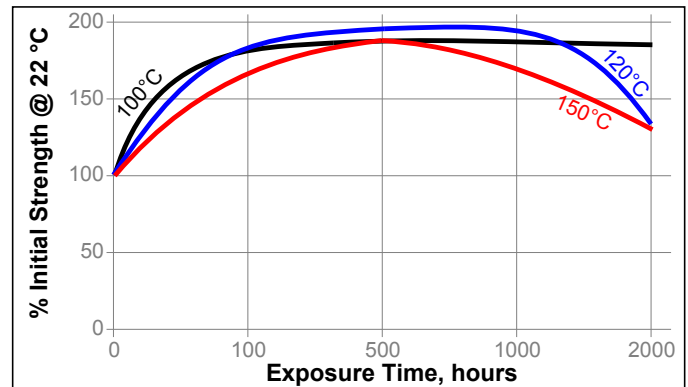
## Hot Strength

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 | 170                   | 160   | 180    |
| Unleaded gasoline       | 22  | 85                    | 80    | 85     |
| Brake fluid             | 22  | 110                   | 80    | 90     |
| Water/glycol 50/50      | 87  | 145                   | 155   | 160    |
| Ethanol                 | 22  | 90                    | 75    | 70     |
| Acetone                 | 22  | 80                    | 55    | 55     |

## 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 Safety Data Sheet (SDS).

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

- For best results, clean all surfaces (external and internal) with a LOCTITE® cleaning solvent and allow to dry.
- Advance only enough product to use at the time of application.
- If present, remove any visible contaminants on the top of the stick prior to application.
- For Slip Fitted Assemblies**
  - For applications with a diameter less than approximately 40 mm, apply product to the pin (inner component) around the entire circumference of the surface being bonded (e.g. pin exterior). Product should be applied at the point where the bonded components will ultimately be positioned. For best results, rotate either part during assembly to ensure full coverage of the product in the engagement area.
  - For applications with a diameter greater than approximately 40 mm, it is recommended to apply stick product around the entire circumference of both surfaces being bonded (e.g. pin and collar). Product should be applied at the point where the bonded

components will ultimately be positioned. For best results, rotate either part during assembly to ensure full coverage of the product in the engagement area.

5. **For Press Fitted Assemblies**, apply product thoroughly to both bond surfaces and assemble at high press rates to avoid premature curing during assembly.
6. **For Shrink Fitted Assemblies**, apply product around the entire circumference of the innermost surface being bonded (i.e. pin). Product should be applied at the point where the bonded components will ultimately be mated. Heat collar to achieve sufficient clearance for free assembly of the parts. Position parts and allow to cool.
7. 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 August 11, 2004. 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

(°C x 1.8) + 32 = °F  
 kV/mm x 25.4 = V/mil  
 mm / 25.4 = inches  
 µm / 25.4 = mil  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 N/mm² x 145 = psi  
 MPa x 145 = psi  
 N·m x 8.851 = lb·in  
 N·m x 0.738 = lb·ft  
 N·mm x 0.142 = oz·in  
 mPa·s = cP

#### Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any

liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

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, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel 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 Henkel 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.

**Trademark usage:** [Except as otherwise noted] All trademarks in this document are trademarks and/or registered trademarks of Henkel and its affiliates in the U.S. and elsewhere.

Reference 2.1