Technical Data Sheet

LOCTITE® 660™

December 2009

PRODUCT DESCRIPTION

LOCTITE® 660™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Urethane methacrylate
Appearance (uncured)	Metallic gray paste
Fluorescence	No
Components	One component - requires no mixing
Viscosity	High
Cure	Anaerobic
Secondary Cure	Activator
Application	Retaining
Strength	High

LOCTITE® 660™ is designed for the bonding of cylindrical fitting parts, particularly where bond gaps can approach 0.50 mm (0.02 in.)The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibrationThis product possesses excellent gap cure characteristicsTypical applications include restoring correct fits on worn shafts, spun bearings, and damaged keyways

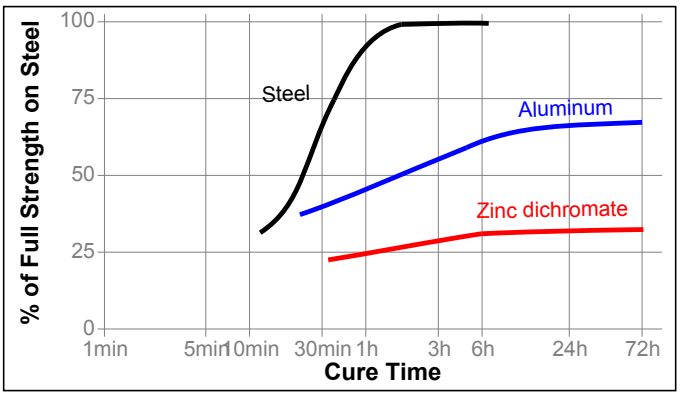
NSF International
Registered to NSF Category P1 for use as a sealant where there is no possibility of food contact in and around food processing areas. **Note:** This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

TYPICAL PROPERTIES OF UNCURED MATERIAL

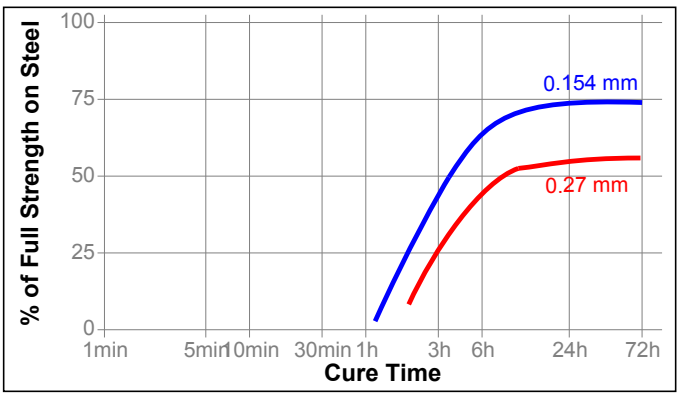
Specific Gravity @ 25 °C	1.13
Flash Point - See SDS	
Viscosity, Brookfield - HBT, 25 °C, mPa·s (cP):	
Spindle TB, speed 0.5 rpm, 1,000,000 to 2,000,000 Helipath	
Spindle TB, speed 5.0 rpm, 150,000 to 350,000 Helipath	

TYPICAL CURING PERFORMANCE

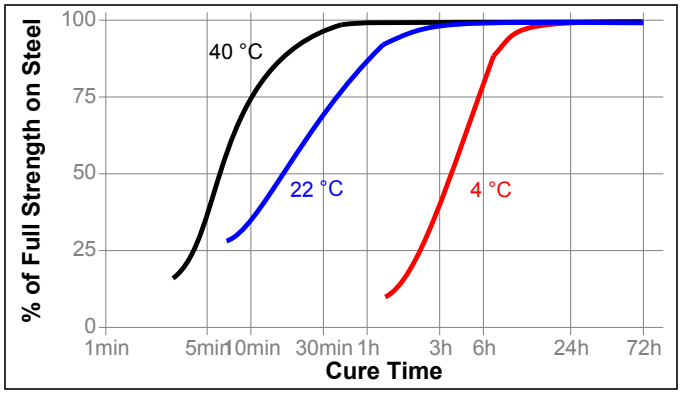
Cure Speed vs. Substrate
The rate of cure will depend on the substrate usedThe graph below shows the shear strength developed with time on steel pins and collars compared to different materials and tested according to ISO 10123



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

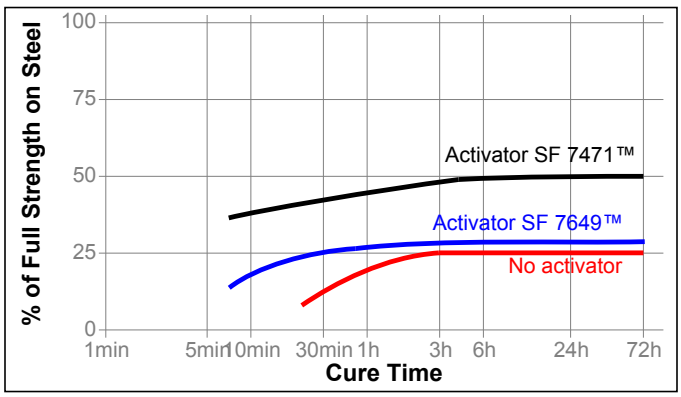


Cure Speed vs. Temperature
The rate of cure will depend on the temperatureThe graph below shows the shear strength developed with time at different temperatures on steel pins and collars and tested according to ISO 10123



Cure Speed vs. Activator

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speedThe 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, ISO 11359-2, K^{-1}	80×10^{-6}
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

After 24 hours @ 22 °C

Compressive Shear Strength, ISO 10123:

Steel pins and collars	N/mm²	≥17.2
	(psi)	(2,490)

TYPICAL ENVIRONMENTAL RESISTANCE

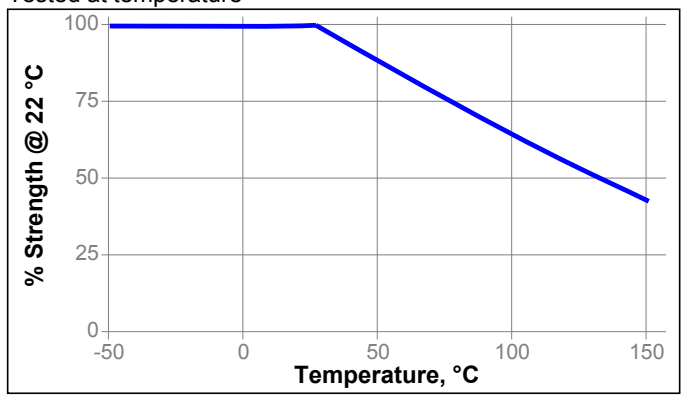
Cured for 1 week @ 22 °C

Compressive Shear Strength, ISO 10123:

Steel pins and collars

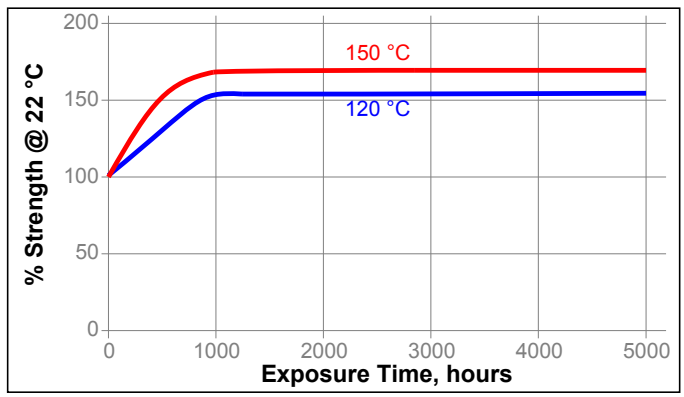
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 23 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 23 °C.

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

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

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 LOCTITE® SF 7471™ or LOCTITE® SF 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

Clean-up

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[LMS]
LMS dated September 1, 1995. 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 Henkel 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

Disclaimer
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, 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 of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.5

This document was created and digitally signed by Henkel at 2025-06-30T18:11:34.191Z