LOCTITE® 680™ provides the following product characteristics:

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Technology</td>
<td>Acrylic</td>
</tr>
<tr>
<td>Chemical Type</td>
<td>Methacrylate ester</td>
</tr>
<tr>
<td>Appearance (uncured)</td>
<td>Green liquid&lt;sup&gt;1&lt;/sup&gt;</td>
</tr>
<tr>
<td>Fluorescence</td>
<td>Positive under UV light&lt;sup&gt;1&lt;/sup&gt;</td>
</tr>
<tr>
<td>Components</td>
<td>One component - requires no mixing</td>
</tr>
<tr>
<td>Viscosity</td>
<td>Medium</td>
</tr>
<tr>
<td>Cure</td>
<td>Anaerobic</td>
</tr>
<tr>
<td>Secondary Cure</td>
<td>Activator</td>
</tr>
<tr>
<td>Application</td>
<td>Retaining</td>
</tr>
<tr>
<td>Strength</td>
<td>High</td>
</tr>
</tbody>
</table>

LOCTITE® 680™ is designed for the bonding of cylindrical fitting parts, particularly where low viscosity is required. The product cures when confined in the absence of air between close fitting metal surfaces and prevents loosening and leakage from shock and vibration. LOCTITE® 680™ provides robust curing performance. It not only works on active metals (e.g. mild steel) but also on passive substrates such as stainless steel and plated surfaces. The product offers high temperature performance and oil tolerance. It tolerates minor surface contaminations from various oils, such as cutting, lubrication, anti-corrosion and protection fluids.

This Technical Data Sheet is valid for LOCTITE® 680™ manufactured from the dates outlined in the "Manufacturing Date Reference" section.

NSF International
Certified to ANSI/NSF Standard 61 for use in commercial and residential potable water systems not exceeding 82° C. Note: This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

TYPICAL PROPERTIES OF UNCURED MATERIAL

<table>
<thead>
<tr>
<th>Property</th>
<th>Specific Gravity</th>
<th>Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):</th>
<th>Viscosity, Cone &amp; Plate, 25 °C, mPa·s (cP):</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>@ 25 °C</td>
<td>Spindle 3, speed 20 rpm 750 to 1,750&lt;sup&gt;1&lt;/sup&gt;</td>
<td>Shear rate 129 s&lt;sup&gt;-1&lt;/sup&gt; 650 to 1,850</td>
</tr>
<tr>
<td>Flash Point</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
</tbody>
</table>

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.
Cure Speed vs. Activator

The graph below shows the shear strength developed with time on stainless steel pins and collars using Activator SF 7471™, SF 7649™ and SF 7091™ and tested according to ISO 10123.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:
Coefficient of Thermal Expansion, ISO 11359-2, K⁻¹
52×10⁻⁶

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties
Cured for 1 hour @ 93 °C, tested @ 22 °C
Compressive Shear Strength, ISO 10123:
Steel pins and collars
N/mm²  ≥24.1MS
(psi)  (≥3,500)

Cured for 24 hours @ 22 °C
Compressive Shear Strength, ISO 10123:
Steel pins and collars
N/mm²  ≥19.3MS
(psi)  (≥2,800)

Cured for 7 days @ 22 °C

Hot Strength
Tested at temperature

Cold Strength
This product has been tested to -75°C (-100 F). This product
may work below this temperature, but has not been tested.

**Heat Aging**
Aged at temperature indicated and tested @ 22 °C

<table>
<thead>
<tr>
<th>Temperature, °C</th>
<th>% Initial Strength</th>
<th>% Initial Strength</th>
<th>% Initial Strength</th>
</tr>
</thead>
<tbody>
<tr>
<td>120</td>
<td>150</td>
<td>180</td>
<td>200</td>
</tr>
</tbody>
</table>

**Chemical/Solvent Resistance**
Aged under conditions indicated and tested @ 22 °C.

<table>
<thead>
<tr>
<th>Environment</th>
<th>Temperature, °C</th>
<th>100 h</th>
<th>500 h</th>
<th>1000 h</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor oil (5W40 -Synthetic)</td>
<td>125</td>
<td>135</td>
<td>160</td>
<td>145</td>
</tr>
<tr>
<td>Unleaded gasoline</td>
<td>22</td>
<td>85</td>
<td>95</td>
<td>110</td>
</tr>
<tr>
<td>Brake fluid</td>
<td>22</td>
<td>85</td>
<td>100</td>
<td>110</td>
</tr>
<tr>
<td>Water/glycol 50/50</td>
<td>87</td>
<td>115</td>
<td>135</td>
<td>135</td>
</tr>
<tr>
<td>Ethanol</td>
<td>22</td>
<td>85</td>
<td>105</td>
<td>100</td>
</tr>
<tr>
<td>Acetone</td>
<td>22</td>
<td>75</td>
<td>105</td>
<td>100</td>
</tr>
<tr>
<td>B100 Bio-Diesel</td>
<td>22</td>
<td>90</td>
<td>110</td>
<td>110</td>
</tr>
<tr>
<td>DEF (AdBlue®)</td>
<td>22</td>
<td>95</td>
<td>105</td>
<td>110</td>
</tr>
<tr>
<td>E85 Ethanol fuel</td>
<td>22</td>
<td>85</td>
<td>105</td>
<td>105</td>
</tr>
<tr>
<td>Sodium Hydroxide, 20%</td>
<td>22</td>
<td>90</td>
<td>90</td>
<td>90</td>
</tr>
<tr>
<td>Phosphoric Acid, 10%</td>
<td>22</td>
<td>85</td>
<td>75</td>
<td>80</td>
</tr>
</tbody>
</table>

**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. To accelerate cure speed or where large gaps are present, use activator 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 part to produce a smooth, even film of material. If heating the hub for assembly, coat the pin. If the pin is to be cooled for assembly, coat the hub. If both heating and cooling is to be done, apply material to cooled part. Avoid condensation on cooled parts.
6. Parts should not be disturbed until sufficient handling strength is achieved.

**For Disassembly**
1. Remove with standard hand tools.
2. If needed, apply localized heat to the assembly to approximately 250 °C. Disassemble while hot.
3. If this temperature is not possible, heat as much as possible and use mechanical aids.

**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**
LMS dated August 6, 2013. 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

\[(°C \times 1.8) + 32 = °F\]

\[kV/mm \times 25.4 = V/mil\]

\[\text{mm} / 25.4 = \text{inches}\]

\[\mu m / 25.4 = \text{mil}\]

\[N \times 0.225 = \text{lb}\]

\[N/mm \times 5.71 = \text{lb/in}\]

\[N/mm^2 \times 145 = \text{psi}\]

\[\text{MPa} \times 145 = \text{psi}\]

\[N\cdot m \times 8.851 = \text{lb}\cdot\text{in}\]

\[N\cdot m \times 0.738 = \text{lb}\cdot\text{ft}\]

\[N\cdot \text{mm} \times 0.142 = \text{oz}\cdot\text{in}\]

\[\text{mPa}\cdot s = \text{cP}\]

Manufacturing Date Reference

This Technical Data Sheet is valid for LOCTITE® 680™ manufactured from the dates below:

<table>
<thead>
<tr>
<th>Made in</th>
<th>First manufacturing date</th>
</tr>
</thead>
<tbody>
<tr>
<td>U.S.A.</td>
<td>September 2013</td>
</tr>
<tr>
<td>EU</td>
<td>Pending</td>
</tr>
<tr>
<td>China</td>
<td>August 2013</td>
</tr>
<tr>
<td>Brazil</td>
<td>November 2013</td>
</tr>
<tr>
<td>India</td>
<td>Pending</td>
</tr>
</tbody>
</table>

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.

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Reference 1.5