



PARSON ADHESIVES, INC.

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SONLOK™ 3640 **Retaining Compound**

SONLOK 3640 is a fast curing; medium viscosity, high strength anaerobic retaining compound for bonding rigid assemblies. This adhesive used to increase the strength of mechanical assemblies.

SONLOK 3640 retaining compound is a single component anaerobic adhesive, which develops high strength rapidly when confined in the absence of air between close fitting surfaces.

Applications:

- Retains bushings and sleeves in housings and on shafts.
- Retains bearings in place, preventing spin out.
- Retains rotor to shafts in fractional and sub-fractional horsepower motors.
- Retains keys and splines. Augments press fits.

Physical Properties:

Composition:	Urethane Methacrylate
Color:	Green
Viscosity:	600 cps at 25 °C
Brookfield HBT	
Specific Gravity:	1.18
Maximum Diameter of Thread/Gap Filling:	0.20 mm
Flash Point:	> 93 °C
Solvent Content:	None
Shelf Life:	1 year

Curing Properties:

Handling Cure Time:	10 - 30 minutes
Functional Cure Time:	3-4 hours
Full Cure Time:	24 hours
Shear Strength:	20 - 24 N/mm ²
DIN 54452	
Coefficient of thermal expansion ASTM D696 K ⁻¹	80 x 10 ⁻⁶
% Elongation at Break	<2

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the material.

Warranty: All products purchased from or supplied by Parson are subject to terms and conditions set out in the contract. Parson warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Parson is considered accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Parson makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.