



## PARSON ADHESIVES, INC.

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### SONLOK™ 3648 Retaining Grade

SONLOK 3648 is a fast curing, high strength anaerobic retaining compound for continuous working temperatures up to 300<sup>0</sup> F.

SONLOK 3648 retaining compound fill the “inner space” between components and cure to form a strong precision assembly.

#### Applications:

- Ideal to fill gaps up to 0.006” diameter clearance.
- High temperature resistance retaining compound.
- Used for rotors, shaft and gears in electric motors, bearings, and sleeves.
- Excellent retaining, sealing and thread locking compound.

#### Physical Properties:

Composition:	Anaerobic Methacrylate
Color:	Green
Viscosity:	500 cps at 25 °C
Specific Gravity:	1.1
Maximum Diameter of Thread/Gap Filling:	M 20/ 1 1/4 “/ 0.15 mm
Flash Point:	> 100 °C
Solvent Content:	None
Shelf Life:	1 year

#### Curing Properties:

Handling Cure Time:	2 - 5 minutes
Functional Cure Time:	1-3 hours
Full Cure Time:	24 hours
Shear Strength:	20 - 30 N/mm <sup>2</sup>
Locking Torque	
--Break	30 - 35 N.m
--Prevailing	55 - 70 N.m
--Temperature Range	-55 to 175 °C

**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 consider 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 nor infringe any patent.