



## PARSON ADHESIVES, INC.

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### **SONLOK™ 3675** **Anaerobic Adhesive**

SONLOK 3675 is a low viscosity, fast curing, general-purpose anaerobic adhesive specifically designed for joining cylindrical assemblies. The temperature range for this product is 65 °F to 300 °F.

SONLOK 3675 cures when confined between ferrous or copper alloy metals. On thermoplastics or other inactive metals, primer is necessary.

#### **Applications:**

- Bonds pivot pins, adapters and plugs in place.
- Bonds sleeves, wear rings and bushing in place.
- Locks bearings on shafts and in housings. Seals mechanical fits that have small clearances.

#### **Physical Properties:**

Composition:	Anaerobic Methacrylate
Color:	Green
Viscosity:	100 - 150 cps at 25 °C
Brookfield RVT	
Specific Gravity:	1.1
Flash Point:	> 100 °C
Solvent Content:	None
Shelf Life:	1 year

#### **Curing Properties:**

Handling Cure Time:	10 - 20 minutes
Functional Cure Time:	1-3 hours
Full Cure Time:	24 hours
Shear Strength:	20 - 30 N/mm <sup>2</sup>
Dielectric strength, ASTM D 149, V/mil	250
Compressive Strength ASTM D 4562, psi	225 x 10 <sup>3</sup>

**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.