



## PARSON ADHESIVES, INC.

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### **SONLOK™ 3680** **Retaining Compound**

SONLOK 3680 is a fast curing; high strength anaerobic retaining compound for cylindrical joints.

SONLOK 3680 retaining compound is a single component anaerobic adhesive, which develops high strength rapidly when confined in the absence of air between close fitting metal surfaces.

#### **Applications:**

- Ideal to fill gaps up to 0.15 mm diameter clearance.
- Retaining Sleeves, Pulleys, Gears, Rotors, and Fans on shafts.
- Mounting sleeves, Securing bushings, bearings and plugs in housings.
- Excellent retaining, sealing and thread locking compound.

#### **Physical Properties:**

Composition:	Methacrylate Esters
Color:	Green
Viscosity:	1,250 cps at 25 °C
Brookfield RVT Spindle 3 @ 20 rpm	
Specific Gravity:	1.1
Maximum Diameter of Thread/Gap Filling:	0.15 mm
Flash Point:	> 93 °C
Solvent Content:	None
Shelf Life:	1 year

#### **Curing Properties:**

Handling Cure Time:	5 - 10 minutes
Functional Cure Time:	1-3 hours
Full Cure Time:	24 hours
Shear Strength:	22 - 25 N/mm <sup>2</sup>
Locking Torque	
--Break	30 - 40 N.m
--Prevailing	55 - 70 N.m
--Temperature Range	-55 to 150 °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 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.