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SONLOK™ 3540

Anaerobic Core & Plug Sealant

SONLOK 3540 is a high performance, high strength anaerobic thread sealant designed for the sealing of core plugs and many other high strength sealing applications. The product cures rapidly in the absence of air between close fitting metal surfaces.

SONLOK 3540 is ideal to seal against gases, water, LPG, hydrocarbons, oils and other chemicals. Excellent thixotropic property prevents migration of the sealant before or during curing.

Applications:

- Ideal for sealing and securing cylindrical metal assemblies, e.g. engine block cup and core plugs, water pump seals, and hub and shaft assemblies.

Adhesive Properties:

Composition:	Methacrylate Ester
Color:	Blue
Viscosity:	7,000 to 12,000 cps at 25 °C
Brookfield RVT Spindle 3 @ 20 rpm	
Specific Gravity:	1.08
Flash Point:	> 100 °C
Solvent Content:	None

Curing Properties:

Handling Cure Time:	10 - 30 minutes
Functional Cure Time:	2 - 4 hours
Full Cure Time:	24 hours

Breakaway Torque, ISO 10964:	
M10 steel nuts and bolts N·m	10 N.m
	88 lb.in.

Prevail Torque, ISO 10964:	
M10 steel nuts and bolts	6 N.m
	53 lb.in.

Break loose Torque, ISO 10964, Pre-torqued to 5 N·m:	
M10 steel nuts and bolts	16 N.m.
	141 lb.in



Max. Prevail Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 steel nuts and bolts N·m 7 N·m
62 lb.in.

Compressive Shear Strength, ISO 10123:

Steel pins and collars >14 N/mm²
>2,030 psi

Temperature Range -65 to 300 °F

Physical Properties:

Coefficient of Thermal Expansion, 80×10⁻⁶
ASTM D 696, K-1

Coefficient of Thermal Conductivity, 0.10
ASTM C 177, W/(m·K)

Specific Heat, kJ/(kg·K) 0.30

Chemical Resistance:

Chemical	Temp.	% Initial Strength Retained	
		500 hours	1000 hours
Acetone	22 °C	95	95
Ethanol	22 °C	95	95
Motor Oil	125 °C	100	100
Gasoline	22 °C	90	80
Brake Fluid	22 °C	90	80
Water/Glycol	87 °C	90	85

Application Method:

Surfaces should be dry, clean, and free of any contamination. Apply product evenly to both surfaces to be joined. Parts must be closely fitted metal surfaces in order to assure effective sealing and bonding of the assembly. Assemble and tighten as required.

Storage:

Anaerobic adhesives shall be ideally stored in a cool, dry place in unopened containers at a room temperature between 46 °F to 82 °F. Please do not return any unused material to its original container.

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.