

## PARSON ADHESIVES, INC.

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## SONLOK<sup>™</sup> 3545 Anaerobic Thread Sealant

SONLOK 3545 is a high performance anaerobic thread sealant designed for the locking and sealing of metal threaded pipes and fittings. The product cures rapidly in the absence of air between close fitting metal surfaces and provide low-pressure resistance immediately after application.

SONLOK 3545 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 locking and sealing of threaded metal pipes and fittings
- Pneumatic hydraulic sealant.

## Adhesive Properties:

Composition: Color: Viscosity: Brookfield RVT Spindle 3 @ 20 rpm Specific Gravity: Flash Point: Solvent Content:	Methacrylate Ester Purple 14,000 cps at 25 <sup>0</sup> C 1.20 > 100 <sup>0</sup> C None	
Curing Properties:		
Handling Cure Time: Functional Cure Time: Full Cure Time:	10 - 30 minutes 2 - 4 hours 24 hours	
Breakaway Torque, ISO 10964: M10 steel nuts and bolts N·m Prevail Torque, ISO 10964:	2 N.m 20 lb.in.	
M10 steel nuts and bolts	2 N.m 20 lb.in.	
Break loose Torque, ISO 10964, Pre-torqued to 5 N·m: M10 steel nuts and bolts 5 N.m. 44 lb.in		



Max. Prevail Torque, ISO 10964, P	re-torqued to 5 N·m:			
M10 steel nuts and bolts N·m	5 N.m			
	44 lb.in.			
Compressive Shear Strength, ISO 10123:				
Steel pins and collars	>1.5 N/mm²			
	220 psi			
Temperature Range	-65 to 300 <sup>0</sup> F			

#### **Physical Properties:**

Coefficient of Thermal Expansion,	80×10 <sup>-6</sup>
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 <sup>0</sup> C	95	95
Ethanol	22 <sup>0</sup> C	100	90
Motor Oil	125 <sup>0</sup> C	100	100
Gasoline	22 <sup>0</sup> C	100	95
Brake Fluid	22 <sup>0</sup> C	100	95
Water/Glycol	87 <sup>0</sup> C	100	100

## **Application Method:**

Surfaces should be dry, clean, and free of any contamination. Apply 360<sup>°</sup> bead of product to the leading threads of the male fitting, leaving the first thread free. Force the material into the threads and voids, adjust product amount accordingly and apply a 360<sup>°</sup> bead of product on the female threads also. 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 <sup>o</sup>F to 82 <sup>o</sup>F. Please do not return any unused material to its original container.