



PARSON ADHESIVES, INC.

3345 Auburn Road Suite 107 Rochester, MI 48309

Phone (248) 299-5585 Fax (248) 299-3846 Email: sales@parsonadhesives.com

SONLOK™ 3592 **Anaerobic Thread Sealant**

SONLOK 3592 is a slow cure speed, medium strength 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 3592 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
- High temperature resistance. After 72 hours the joint is sealed to pipe burst pressure.

Adhesive Properties:

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|--|----------------------|
| Composition: | Methacrylate Ester |
| Color: | White |
| Viscosity: | 350,000 cps at 25 °C |
| <small>Brookfield RVT Spindle 3 @ 20 rpm</small> | |
| Specific Gravity: | 1.21 |
| Flash Point: | > 100 °C |
| Solvent Content: | None |

Curing Properties:

| | |
|-----------------------|------------------|
| Handling Cure Time: | 60 - 120 minutes |
| Functional Cure Time: | 8 - 12 hours |
| Full Cure Time: | 24 hours |

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| Breakaway Torque, ISO 10964: M10 steel nuts and bolts N·m | >0.6 N·m >5 lb.in. |
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| Prevail Torque, ISO 10964: M10 steel nuts and bolts | 0.6 N·m 5 lb.in. |
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Compressive Shear Strength, ISO 10123:
Steel pins and collars > 0.5 N/mm²
> 70 psi

Temperature Range -65 to 400 °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 | 90 | 70 |
| Gasoline | 22 °C | 90 | 90 |
| Brake Fluid | 22 °C | 100 | 100 |
| Water/Glycol | 87 °C | 90 | 85 |

Application Method:

Surfaces should be dry, clean, and free of any contamination. Apply 360° 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° 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 °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.