



PARSON ADHESIVES, INC.

3345 Auburn Road Suite 107 Rochester, MI 48309

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

SONLOK[®] 3661

UV/Anaerobic Curable Retaining Compound

SONLOK 3661 is a fast curing, high strength anaerobic/UV curable retaining compound designed for the bonding of cylindrical fitting parts.

SONLOK 3661 retaining compound fill the “inner space” between components and cure to form a strong precision assembly. This product can be solidify, even when in contact with air, by exposure to high intensity, short wavelength UV light.

Applications:

- Ideal to fill gaps up to 0.005” diameter clearance.
- High temperature resistance retaining compound.
- Used for holding gears and sprockets onto gearbox shafts and rotors on electric motor shafts.
- Excellent retaining, sealing and thread locking compound.

Physical Properties:

Composition:	Methacrylate Ester
Color:	Amber
Viscosity:	500 cps at 25 °C
<small>Brookfield RVT Spindle 3@ 20 rpm</small>	
Specific Gravity:	1.09
Flash Point:	> 100 °C
Solvent Content:	None
Shelf Life:	1 year

Curing Properties:

Handling Cure Time:	5 minutes
Functional Cure Time:	1-3 hours
Full Cure Time:	24 hours
Compressive Shear Strength:	3,575 psi
Steel/Steel	
Temperature Range	-55 to 150 °C

Coefficient of Thermal Expansion,	K-1 80x10-6	ASTM D 696
Coefficient of Thermal Conductivity,	0.10 W/(m·K)	ASTM C 177
Specific Heat, kJ/(kg·K)	0.30	



Chemical Resistance:

Chemical	Temp.	% Initial Strength Retained	
		500 hours	1000 hours
Acetone	22 °C	100	100
Ethanol	22 °C	100	100
Motor Oil	125 °C	100	100
Gasoline	22 °C	100	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. Thread locker should be applied to the bolt in sufficient quantity to fill threads. SONLOK 3661 performs the best in thin bond gaps. This thread locker is specifically formulated to give controlled friction and torque/tension ratio during assembly.

GENERAL INFORMATION:

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

Cleanup:

Cured product can be removed with a combination of soaking in a Parson cleaning solvent and mechanical abrasion such as a wire brush.

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.