



PARSON ADHESIVES, INC.

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SONLOK 3222 Anaerobic Thread Locking Compound

SONLOK 3222 is a fast curing, low strength anaerobic thread-locking compound for bonding and sealing threads, and retaining of cylindrical parts. SONLOK 3222 is highly resistance to heat, vibrations, water, gases, oils, hydrocarbons and many chemicals.

◆ Features

- High strength, optically clear and high performance one-part UV curable adhesive system
- The adhesive cures in seconds upon exposure to UV radiation to form an impact resistant, weather resistant and flexible bond.
- UV adhesive with excellent resistance to prolonged humidity or water resistance.

◆ Application

- Ideal for thread locking small screws from loosening under vibration.
- Ideal for fasteners diameters of 1/4" (6 mm) and smaller.
- Specifically suitable for applications such as adjustment of set screws and small diameter fasteners where easy disassembly is required.
- Meets Military specifications: MIL-S-46163 Type II Grade M

◆ Physical Properties

Description	Specification
Composition	Methacrylate Ester
Color	Purple
Viscosity	1000 cps at 25 °C
Specific Gravity	1.1
Maximum Diameter of Thread/Gap Filling	1/4" / 6 mm
Flash Point	> 100 °C
Solvent Content	None
Shelf Life	1 year

◆ Curing Properties

Description	Specification
Handling Cure Time	15-30 minutes
Functional Cure Time	1-3 hours
Full Cure Time	24 hours
Shear Strength	3 - 5 N/mm ²
Locking Torque	
- Break	4 - 8 N.m
- Prevailing	2 - 4 N.m
- Temperature Range	-55 to 150 °C

◆ Chemical Resistance

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

◆ 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 3222 performs the best in thin bond gaps. This thread locker is specifically formulated to give controlled friction and torque/tension ratio during assembly.

◆ 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.

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.

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