



## PARSON ADHESIVES, INC.

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### SONLOK™ 3246

#### *Anaerobic Thread Locking Compound*

SONLOK 3246 is a fast curing, medium strength anaerobic threadlocking compound for bonding and sealing threads, and retaining of cylindrical parts.

SONLOK 3246 is highly resistance to heat, vibrations, water, gases, oils, hydrocarbons and many chemicals.

#### **Applications:**

- Idea for heavy duty applications such as bolts used in transmissions, construction equipments or railroad assemblies where resistance to heavy vibration, shock and stress level is required along with high temperature resistance.
- The thixotropic nature of SONLOK 3246 reduces the migration of liquid product after application to the surfaces.

#### **Adhesive Properties:**

Composition:	Dimethacrylate Ester
Color:	Blue
Viscosity: Brookfield RVT, Spindle 3 @ 20 rpm	2,600 cps at 25 °C
Specific Gravity:	1.15
Maximum Diameter of Thread/Gap Filling:	3/4 " / 0.20 mm
Flash Point:	> 100 °C
Shelf Life:	2 years

#### **Curing Properties:**

Handling Cure Time:	6 - 8 minutes
Functional Cure Time:	1 - 3 hours
Full Cure Time:	24 hours

Breakaway Torque, ISO 10964: M10 steel nuts and bolts N·m	18 N.m 170 lb.in.
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Prevail Torque, ISO 10964: M10 steel nuts and bolts	12 N.m 48 lb.in.
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Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 steel nuts and bolts	15 - 24 N.m.
	130 - 210 lb.in

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

M10 steel nuts and bolts N·m	4 - 9 N.m
	35 - 80 lb.in.

Temperature Range	-55 to 200 °C
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### **Physical Properties:**

Coefficient of Thermal Expansion, ASTM D 696, K-1	80×10 <sup>-6</sup>
Coefficient of Thermal Conductivity, ASTM C 177,W/(m·K)	0.10
Specific Heat, kJ/(kg·K)	0.30

### **Chemical Resistance:**

Chemical	Temp.	% Initial Strength Retained	
		500 hours	1000 hours
Acetone	22 °C	95	90
Ethanol	22 °C	100	100
Motor Oil	125 °C	95	95
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 3246 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 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 consider 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 nor infringe any patent.