



## PARSON ADHESIVES, INC.

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### SONLOK™ 3270

#### *Anaerobic Thread Locking Compound*

SONLOK 3270 is a fast curing, high strength anaerobic thread-locking compound for bonding and sealing threads, and retaining of cylindrical parts.

SONLOK 3270 is highly resistance to heat, vibrations, water, gases, oils, hydrocarbons and many chemicals.

#### **Applications:**

- Ideal for fastener up to 1" (25 mm) in diameter.
- Transmission and engine block studs, valve sets, etc.
- High strength, permanent and eliminates need for double nutting and welding. Prevents corrosion and leakage.
- Excellent performance of even oily surfaces.
- Fasteners on vibrating machines or moving components.
- Meets Military specifications: MIL-S-46163A Type I Grade K  
MIL-S-22473E Letter Grade CVV

#### **Adhesive Properties:**

Composition:	Methacrylate Ester
Color:	Green
Viscosity: Brookfield RVT Spindle 3 @ 20 rpm	500-800 cps at 25 °C
Specific Gravity:	1.11
Gap Filling:	0.15 mm
Flash Point:	> 100 °C

#### **Curing Properties:**

Handling Cure Time:	10 minutes
Functional Cure Time:	1 - 3 hours
Full Cure Time:	24 hours

Breakaway Torque, ISO 10964: M10 steel nuts and bolts	28 N.m 230 lb.in.
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Prevail Torque, ISO 10964: M10 steel nuts and bolts	31 N.m 320 lb.in.
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