



PARSON ADHESIVES, INC.

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SONLOK™ 3271

Anaerobic Thread Locking Compound

SONLOK 3271 is a fast curing, high strength anaerobic thread-locking compound for bonding and sealing threads, and retaining of cylindrical parts.

SONLOK 3271 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.
- 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:	Red
Viscosity: Brookfield RVT Spindle 3 @ 20 rpm	500 cps at 25 °C
Specific Gravity:	1.11
Maximum Diameter of Thread/Gap Filling:	M 20/ 1 " / 0.15 mm
Flash Point:	> 100 °C
Solvent Content:	None
Shelf Life:	2 years

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 N·m	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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