



PARSON ADHESIVES, INC.

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SONLOK™ 3290

Anaerobic Thread Locking Compound

SONLOK 3290 is a fast curing, penetrating, medium strength anaerobic thread locking compound for bonding and sealing threads, and retaining of cylindrical parts.

SONLOK 3290 is highly resistance to heat, vibrations, water, gases, oils, hydrocarbons and many chemicals.

Applications:

- Penetrates threads by capillary action. Medium strength threadlocker.
- Ideal for sealing hairline cracks, small nuts and bolts.
- Seals and welds porous metal parts. Localize heating and hand tools are needed for disassembly. Prevents corrosion and leakage.
- Secure setscrews and other assemblies after settings are completed.
- Fasteners on vibrating machines or moving components.
- Meets Military specifications: MIL-S-46163A Type III Grade R
MIL-S-22473E Letter Grade AA

Adhesive Properties:

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| Composition: | Methacrylate Ester |
| Color: | Green |
| Viscosity: Brookfield RVT Spindle 3 @ 20 rpm | 12 cps at 25 °C |
| Specific Gravity: | 1.07 |
| Maximum Diameter of Thread/Gap Filling: | M 5/ 1/2 " / 0.07 mm |
| Shelf Life: | 2 years |

Curing Properties:

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| Handling Cure Time: | 20 minutes |
| Functional Cure Time: | 1 - 3 hours |
| Full Cure Time: | 24 hours |

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| Breakaway Torque, ISO 10964: M10 steel nuts and bolts N·m | 10 N.m 85 lb.in. |
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| Prevail Torque, ISO 10964: M10 steel nuts and bolts | 29 N.m 250 lb.in. |
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