SONLOK™ 3242
Anaerobic Thread Locking Compound

SONLOK 3242 is a fast curing, medium strength anaerobic thread locking compound for bonding and sealing threads, and retaining of cylindrical parts.

SONLOK 3242 is highly resistance to heat, vibrations, water, gases, oils, hydrocarbons and many chemicals.

Applications:

- Ideal for thread locking plated parts, vibration or moving components.
- Ideal for fasteners between ¼" and ¾" (6 to 20 mm) diameters.
- Locks and seals threaded joints-nuts, screws, and studs.
- Meets 90% of all nut and bolt thread locking applications.
- Meets Military specifications: MIL-S-46163 Type II Grade N
                                       MIL-S-22473E Letter Grade CVV

Adhesive Properties:

Composition:	Methacrylate Ester
Color:	Blue
Viscosity:	1,200 cps at 25 ^{0}C
Brookfield RVT, Spindle 3 @ 20 rpm	
Specific Gravity:	1.07
Maximum Diameter of Thread/Gap Filling:	M 36/ 1 ½ "/ 0.20 mm
Flash Point:	> 100 ^{0}C
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:	
3/8 x 16 steel nuts and bolts	8 to 17 N.m.
	70 to 150 lb.in.
3/8 x 16 cadmium nuts and bolts	1 to 7 N.m
	10 to 60 lb.in.
3/8 x 16 zinc nuts and bolts	2 to 7 N.m
	20 to 60 lb.in
M10 black oxide steel nuts and bolts	8 to 19 N.m
	71 to 168 lb.in

Prevail Torque, ISO 10964:

3/8 x 16 steel nuts and bolts	3 to 7 N.m
	25 to 60 lb.in
3/8 x 16 cadmium nuts and bolts	1.0 to 5.0 N.m
	4 to 40 lb.in
3/8 x 16 zinc nuts and bolts	1.0 to 4.0 N.m.
	10 to 40 lb.in
Temperature Range	-55 to 150 ^{0}C

Physical Properties:

Coefficient of Thermal Expansion, ASTM D 696, K-1	80×10^{-6}
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 ^{0}C	100	85
Ethanol	22 ^{0}C	100	100
Motor Oil	125 ^{0}C	100	100
Gasoline	22 ^{0}C	100	95
Brake Fluid	22 ^{0}C	100	100
Water/Glycol	87 ^{0}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 3242 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 ^{0}F to 82 ^{0}F. Please do not return any unused material to its original container.