



PARSON ADHESIVES, INC.

3345 Auburn Road Suite 107 Rochester, MI 48309

Phone (248) 299-5585 Fax (248) 299-3846 Email: sales@parsonadhesives.com

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:	500 cps at 25 °C
Brookfield RVT Spindle 3 @ 20 rpm	
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.
--	----------------------

Prevail Torque, ISO 10964: M10 steel nuts and bolts	31 N·m 320 lb.in.
--	----------------------



Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m:

M10 steel nuts and bolts	40 N.m.
	330 lb.in

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

M10 steel nuts and bolts	N·m
	57 N.m
	510 lb.in.

Compressive Shear Strength, ISO 10123:
Steel pins and collars > 8 N/mm²
> 1,000 psi

Temperature Range -55 to 150 °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 °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 3271 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.