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SONLOK[®] 3243
Anaerobic Thread Locking Compound

SONLOK 3243 is a fast curing, medium strength anaerobic thread-locking compound for bonding and sealing threads and for retaining cylindrical parts.

SONLOK 3243 is highly resistant to heat, vibration, water, gases, oils, hydrocarbons and many chemicals.

APPLICATIONS:

- Ideal for less active material such as stainless steel and plated parts.
- Ideal for fasteners between ¼" and ¾" (6 to 20 mm) diameters.
- Locks and seals threaded joints, nuts, screws and studs, with improved oil resistance.
- Meets Military specifications: MIL-S-46163 Type II Grade N
MIL-S-22473E Letter Grade CVV

Adhesive Properties:

Composition:	Dimethacrylate Ester
Colour:	Blue
Viscosity: (Brookfield RVT Spindle 3 @ 20 rpm)	2,250 cps @ 77°F / 25°C
Specific Gravity:	1.07
Maximum Ø of Thread:	1½" (M36)
Gap Filling:	0.25 mm
Flash Point:	>210°F / 100°C

Curing Properties:

Handling Cure Time:	10 - 12 minutes		
Functional Cure Time:	1 - 3 hours		
Full Cure Time:	24 hours		
Breakaway Torque: (M10 steel nuts and bolts)	20 N.m	/ 180 lb.in	ISO 10964
Prevail Torque: (M10 steel nuts and bolts)	7 N.m	/ 60 lb.in	ISO 10964
Breakloose Torque:			
Pre-torqued to 5 N·m (M10 steel nuts and bolts)	24 N.m	/ 210 lb.in	ISO 10964
Max. Prevail Torque:			
Pre-torqued to 5 N·m (M10 steel nuts and bolts)	24 N.m	/ 210 lb.in	ISO 10964
Compressive			
Shear Strength: (Steel pins and collars)	> 8 N/mm ²	/ > 1,000 psi	ISO 10123
Temperature Range:	-65°F to 300°F	/ -55 to 150°C	



Physical Properties:

Coefficient of Thermal Expansion:	80×10^{-6}	ASTM D 696, K-1
Coefficient of Thermal Conductivity:	0.10	ASTM C 177, W/(m·K)
Specific Heat, kJ/(kg·K):	0.30	

Chemical Resistance:

Chemical	Temperature	% Initial Strength Retained	
		500 hours	1000 hours
Acetone:	72°F / 22°C	95	90
Ethanol:	72°F / 22°C	100	100
Motor Oil:	257°F / 125°C	95	95
Gasoline:	72°F / 22°C	100	100
Brake Fluid:	72°F / 22°C	100	100
Water/Glycol:	189°F / 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 3243 performs 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/8°C to 82°F/28°C. The shelf life is at least 1 to 2 years, dependant upon storage conditions. Please do not return any unused material to its original container.

GENERAL INFORMATION: This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Stress cracking can occur when used on thermoplastic. It is recommended to test compatibility on plastics before use.

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.