



PARSON ADHESIVES, INC.

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SONLOK 3277 Anaerobic Thread Locking Compound

SONLOK 3277 is a fast curing, high strength anaerobic thread-locking compound for bonding and sealing threads, and retaining of cylindrical parts.

SONLOK 3277 is highly resistance to heat, vibrations, water, gases, oils, hydrocarbons and many chemicals.

◆ **Application**

- Ideal for locking and sealing of larger bolts and studs. (M25 and larger)
- Transmission and engine block studs, valve sets, etc.
- High strength, permanent and eliminates need for double nutting and welding. Prevents corrosion and leakage.
- Excellent performance of even oily surfaces.
- Fasteners on vibrating machines or moving components.
- Meets Military Specification: MIL-S-43163A Type I Grade L

◆ **Physical Properties**

Description	Specification
Composition	Methacrylate Ester
Color	Red
Viscosity @ 25 °C, Brookfield RVT	7000 cps
Specific Gravity	1.10
Maximum Diameter of Thread/Gap Filling	M 25/ 1 " / 0.25 mm
Flash Point	> 100 °C
Solvent Content	None
Shelf Life	1 year

◆ **Curing Properties**

Description	Specification
Handling Cure Time	10-20 minutes
Functional Cure Time	1-3 hours
Full Cure Time	24 hours
Shear Strength	15 - 20 N/mm ²
Locking Torque ISO 10964	
- Breakaway	28 - 42 N.m
- Prevailing	23 - 40 N.m
Temperature Range	-55 to 150 °C

◆ **Chemical Resistance**

Chemical	Temp.	% Initial Strength Retained	
		500 hours	1000 hours
Acetone	22 °C	100	95
Ethanol	22 °C	100	100
Motor Oil	125 °C	100	100

Gasoline	22 °C	100	100
Brake Fluid	22 °C	100	100
Water/Glycol	87 °C	85	85

◆ 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 3277 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.

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 considered 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 not infringe any patent.

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