



## PARSON ADHESIVES, INC.

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### PARFIX 3404 Cyanoacrylate Adhesive

Medium Viscosity, Fast Cure Speed

ParFix 3404 is medium viscosity combined with fast cure speed, ethyl cyanoacrylate adhesive (CA). It is specifically formulated for bonding rubbers and plastic parts.

#### APPLICATIONS:

- Ideal for manufacturing O-rings from various rubber compounds.
- Suitable for bonding rubber parts, rubber gaskets, weatherstripping, injection molded badges and labels.
- Wide variety of industrial manufacturing and repairing applications

#### BONDING TIMES:

Plastics	2-10 seconds	Rubbers	< 5 seconds
Steel	15-30 seconds	Leather	5-15 seconds
Aluminum	2-10 seconds	Ceramics	12-18 seconds

#### PHYSICAL PROPERTIES

##### Liquid

Composition	Ethyl Cyanoacrylate
Appearance	Colorless liquid
Viscosity @ 25 °C, cps	80 - 100
Brookfield LVF, Spindle 1-60 rpm	

##### Cured Adhesive

Gap Filling	0.2 mm
Tensile Shear Strength	18-28 N/mm <sup>2</sup>
Service Temperature Range	-60 to +80 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C

#### Shear Strength ASTM D 1002/DIN 53283

Grit Blasted Steel	> 20 N/mm <sup>2</sup>	Etched Aluminum	> 18 N/mm <sup>2</sup>
Rubbers	> 22 N/mm <sup>2</sup>	Wood	> 25 N/mm <sup>2</sup>
Polycarbonate	> 12 N/mm <sup>2</sup>	ABS	> 10 N/mm <sup>2</sup>



### **Mechanical Properties:**

Coefficient of thermal conductivity, ASTM C177, W.m <sup>-1</sup> K <sup>-1</sup>	0.1
Glass Transition Temperature, ASTM E228,	122 °C
Coefficient of thermal expansion, ASTM D696, K <sup>-1</sup>	75 x 10 <sup>-6</sup>
Dielectric strength, ASTM D149, kV/mm	27
Volume resistivity, ASTM D257, Ohm.cm	1 x 10 <sup>16</sup>
Dielectric constant, 25 °C, ASTM D150	2.3

### **Chemical Resistance Properties:**

Chemical	Temp.	% Initial strength retained	
		500 hours	1000 hours
Isopropanol	22 °C	85	85
Gasoline	22 °C	80	75
Motor Oil	40 °C	90	90
Mineral Spirit	22 °C	90	90

### **APPLICATION INSTRUCTIONS:**

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.
- When bonding "O" rings, cut a fresh surface onto each end of the rubber to gain the best possible strength.

**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.