



PARSON ADHESIVES, INC.

3345 Auburn Road Suite 107 Rochester, MI 48309

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

Web site: www.parsonadhesives.com

PARFIX 3406 Cyanoacrylate Adhesive

PARFIX 3406 is low viscosity combined with fast cure speed, surface insensitive cyanoacrylate adhesive (CA). It is specifically formulated to bond difficult surfaces with high industrial strength.

APPLICATIONS:

- Ideal for bonding rough, porous and acidic surfaces including Wood, Cardboard, Balsa Wood, Rubbers, Plastics, Metals, Leather, etc.
- Wide variety of industrial manufacturing and repairing applications

BONDING TIMES:

| | | | |
|----------|--------------|----------|---------------|
| Plastics | 2-5 seconds | Rubbers | < 3 seconds |
| Wood | 1-5 seconds | Leather | 5-15 seconds |
| Metals | 8-10 seconds | Ceramics | 12-18 seconds |

PHYSICAL PROPERTIES

Liquid

| | |
|--|---------------------|
| Composition | Ethyl Cyanoacrylate |
| Appearance | Colorless liquid |
| Viscosity @ 25 ⁰ C | 20 cps |
| <small>Brookfield LVT Spindle 1 @ 30 rpm</small> | |

Cured Adhesive

| | |
|---------------------------|---------------------------|
| Gap Filling | 0.05 mm |
| Tensile Shear Strength | 18-28 n/mm ² |
| Service Temperature Range | -60 to +80 ⁰ C |
| Full Cure | 24 hours |
| Melting Point Temperature | 160 to 170 ⁰ C |

Shear Strength ASTM D 1002/DIN 53283

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



Mechanical Properties:

| | |
|---|---------------------|
| Coefficient of thermal conductivity, ASTM C177, $W.m^{-1} k^{-1}$ | 0.1 |
| Glass Transition Temperature, ASTM E228, | 122 °C |
| Coefficient of thermal expansion, ASTM D696, K^{-1} | 75×10^{-6} |
| Dielectric strength, ASTM D149, kV/mm | 27 |
| Volume resistivity, ASTM D257, Ohm.cm | 1×10^{16} |
| Dielectric constant, 25 °C, ASTM D150 | 2.7 |

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.