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 3416 Cyanoacrylate Adhesive

PARFIX 3416 is a high viscosity, cyanoacrylate adhesive with slower cure speed compare to other cyanoacrylate adhesives. This adhesive develops strong bonds on wide variety of metals, plastics, and elastomeric compounds.

APPLICATIONS:

- Specially formulated to bond various plastics, metals and elastomers.
- Rough or irregular surfaces.
- Applications requiring alignment time of up to 15 seconds.

BONDS:

Acrylic	Polycarbonate	Polyimide
PVC	PEEK	PETG
Polysulfone	PET	Latex
ABS	Rubber	Metals

BONDING TIMES:

Under normal conditions, the surface moisture initiates the curing process. Functional strength developed in a short time but curing continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on substrate used.

Steel	25-35 seconds	ABS	10-30 seconds
Polycarbonate	15-50 seconds	PVC	10-30 seconds
Neoprene	< 5 seconds	Phenolics	10-15 seconds
Aluminum	10-20 seconds	Nitrile Rubber	5 – 7 seconds

PHYSICAL PROPERTIES

Liquid

Composition	Ethyl Cyanoacrylate Adhesive
Appearance	Colorless liquid
Viscosity@ 25 ^{0}C, cps Brookfield LVF, Spindle 1-60 rpm	1500

Cured Adhesive

Gap Filling	0.45 mm
Tensile Shear Strength	15-22 n/mm^2
Service Temperature Range	-60 to +80 ^{0}C
Full Cure	24 hours
Melting Point Temperature	160 to 170 ^{0} C

Mechanical Properties

Glass Transition Temperature, ASTM E228, ^{0}C	125
Dielectric Strength, ASTM D149, v/mil	625
Coefficient of thermal expansion, ASTM D696, K^{-1}	90 x 10 $^{-6}$
Coefficient of thermal conductivity, ASTM C177, W.m^{-1}K^{-1}	0.1

Shear Strength, ASTM D1002/DIN 53283

ABS	8 – 14 N/mm^2
Neoprene Rubber	10 – 15 N/mm^2
PVC	6 – 9 N/mm^2
Acrylic	10 – 15 N/mm^2
Polycarbonate	5 – 10 N/mm^2

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.
- Thin bond lines favor high cure speed. Increasing the bond gap will slow down the rate of cure.