



PARSON ADHESIVES, INC.

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PARFIX 3480 **Medium Viscosity, Black Rubber Toughened** **Cyanoacrylate Adhesive**

PARFIX 3480 is medium viscosity combined with fast cure speed, and excellent resistance to peel and shock loads. It is specially formulated to bond various Rubbers, Metals and Plastics for use in difficult environments.

APPLICATIONS:

- Ideal for bonding Rubbers, Magnets, Metals and Plastics.
- Ideal for Speaker Assemblies, Automotive Parts, Electronic Components, Electrical Parts, Computer Assemblies, Disk Drives, etc.

PHYSICAL PROPERTIES

Liquid

Composition	Rubber Toughened Ethyl Cyanoacrylate
Appearance	Black liquid
Viscosity	300 cps
@ 25 °C, Brookfield RTV	
Flash Point (TCC), °C	> 93
Specific Gravity @ 25°C	1.1

Typical Cure Speed

Substrate	Fixture Time, Seconds
Neoprene Rubber	12 – 22
Nitrile Rubber	12 – 22
SBR Rubber	15 – 25
Steel	60 – 100
Aluminum	10 – 25
Phenolic Materials	10 – 50
Polycarbonate	30 – 80

Cured Adhesive

Gap Filling	0.3 mm
Tensile Shear Strength	13-28 n/mm ²
Service Temperature Range	-60 to +80 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C



Mechanical Properties:

Glass transition temperature, °C	150
Coefficient of thermal expansion, ASTM D696, K ⁻¹	80 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1
Dielectric strength, ASTM D149, kV/mm	25
Dielectric constant, 25 ⁰ C, ASTM D150	2.75

Shear Strength ASTM D 1002, DIN 53283

Neoprene Rubber	> 12 N/mm ²
Nitrile Rubber	> 12 N/mm ²
SBR Rubber	> 10 N/mm ²
PVC	> 6 N/mm ²
Aluminum	> 19 N/mm ²
Steel	> 28 N/mm ²
Polycarbonate	> 7 N/mm ²
ABS	> 7 N/mm ²

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 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.