



PARSON ADHESIVES, INC.

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PARFIX 3409 Cyanoacrylate Adhesive

PARFIX 3409 is a gel of ethyl cyanoacrylate adhesive for vertical surfaces.

APPLICATIONS:

- Bonding applications for vertical surfaces where adhesive run-off or drip must be avoided.
- Suitable for wide variety of assembly of Industrial equipments and devices.

BONDS:

Acrylic	Polycarbonate	Polyimide
PVC	PEEK	PETG
Polysulfone	Wood	Latex
Steel	Aluminum	Zinc Dichromate

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.

Stainless Steel	50-95 seconds	Aluminum	5-30 seconds
Polycarbonate	20-60 seconds	PVC	50-95 seconds
Neoprene	15-25 seconds	Phenolics	30-60 seconds
ABS	20-60 seconds	Nitrile Rubber	15-25 seconds

PHYSICAL PROPERTIES

Liquid

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

Cured Adhesive

Gap Filling	0.50 mm
Tensile Shear Strength	15-26 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, ASTM E228, °C	120
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

Grit Blasted Steel	14 – 22 N/mm ²
Neoprene Rubber	10 – 15 N/mm ²
PVC	3 – 9 N/mm ²
Etched Aluminum	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.

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.