



PARSON ADHESIVES, INC.

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PARFIX 3415 Cyanoacrylate Adhesive

PARFIX 3415 is high viscosity combined with medium cure speed, methyl cyanoacrylate adhesive. It is specifically formulated to bond wide variety of metals and rubbers with high industrial strength.

APPLICATIONS:

- Ideal for bonding Grit blasted steel, Etched Aluminum, Zinc Dichromate, Neoprene Rubber, Nitrile Rubber Buna N Rubber, etc.
- Wide variety of industrial manufacturing and repairing applications
- Meets Military specification MLLA 46050C Type I Class III

BONDING TIMES:

Steel	20-40 seconds	Rubbers	< 10 seconds
Aluminum	30-60 seconds	Zinc Dichromate	30-60 seconds
ABS	10-25 seconds	PVC	30-70 seconds

PHYSICAL PROPERTIES

Liquid

Composition	Methyl Cyanoacrylate
Appearance	Colorless liquid
Viscosity@ 25 ⁰ C, mPa.s (cP)	1500 cps
Brookfield LVT Spindle 1 @ 30 rpm	

Cured Adhesive

Gap Filling	0.25 mm
Tensile Shear Strength	18-30 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	> 25 N/mm ²
Etched Aluminum	> 20 N/mm ²
Rubbers	> 15 N/mm ²
Zinc Dichromate	> 10 N/mm ²
Polycarbonate	> 13 N/mm ²
ABS	> 14 N/mm ²

Mechanical Properties

Glass Transition Temperature, ASTM E228, °C	165
Dielectric Strength, ASTM D149, v/mil	625
Coefficient of thermal expansion, ASTM D696, K ⁻¹	100 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1

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.