

## #625 QUICK-WELD #3 Rubber Toughened Cyanoacrylate Adhesive (Black)

**QUICK-WELD #3** is high viscosity combined with high temperature resistance, and excellent resistance to peel and shock loads. Specifically formulated to bond various rubbers, metals, wood and plastics for use in challenging environments.

### APPLICATIONS:

- Ideal for bonding rubbers, metals and plastics.
- Ideal for automotive components, electronic parts, electrical components, speaker assemblies, computer assemblies, etc.

### PHYSICAL PROPERTIES:

#### LIQUID

Composition	Rubber Toughened Ethyl Cyanoacrylate
Appearance	Black, High Viscosity Liquid
Viscosity @ 77°F (25°C) <i>Brookfield RTV</i>	5,000 - 6,000 cps
Flash Point (TCC), °C	>93
Specific Gravity @ 25°C	1.06

#### CURED ADHESIVE

Gap Filling	0.6 mm
Tensile Shear Strength	13-25 n/mm <sup>2</sup>
Service Temperature Range	-60 to +210°F
Full Cure	24 hours
Shear Strength ASTM D 1002/DIN 53283	
Neoprene Rubber	>12 N/mm <sup>2</sup>
Nitrile Rubber	>12 N/mm <sup>2</sup>
SBR Rubber	>10 N/mm <sup>2</sup>
PVC	> 6 N/mm <sup>2</sup>
Aluminum	>17 N/mm <sup>2</sup>
Steel	>24 N/mm <sup>2</sup>
Polycarbonate	> 7 N/mm <sup>2</sup>

#### ADDITIONAL PHYSICAL PROPERTIES:

Coefficient of thermal conductivity, ASTM C177, W.m <sup>-1</sup> k <sup>-1</sup>	0.1
Glass Transition Temperature, ASTM E228, °C	125
Coefficient of thermal expansion, ASTM D696, K <sup>-1</sup>	80x10 <sup>-6</sup>
Dielectrical Strength, ASTM D149, kV/mm	25

#### CHEMICAL RESISTANCE PROPERTIES:

Chemical	Temp	% Initial Strength	
		500 Hrs	Retained 1000 Hrs
Isopropanol	22°C	85	85
Gasoline	22°C	80	75
Motor Oil	40°C	90	90
Mineral Spirit	22°C	90	90



### BONDING TIMES:

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

### APPLICATION INSTRUCTIONS:

- All surfaces must be clean, dry, dust and grease free. Best results will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using IES #650 accelerator, apply to one surface only. Apply a thin film of adhesive to the other surface and bring pieces together immediately. Hold for a 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.

### STORAGE

- Avoid direct sunlight which causes polymerization.
- Store in a dry place. Small amounts of moisture (contained in the air) can cause polymerization. Keep cap tightly closed when not in use.
- Maintain temperature below 80°F. Refrigeration storage (40°F) will extend shelf life. Allow product to attain room temperature before using.

NOTICE TO PURCHASER: The following warranty is in lieu of all other expressed or implied warranties, specifically all goods are manufactured of first class materials and by competent professionals. We have no control over the use and application of our products. Our liability shall not exceed the purchase price.

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