TECHNICAL DATASHEET

Structalit 3446®



(HIGH TEMPERATURE EPOXY ADHESIVE

FOR BONDING TEFLON AND RULON)

STRUCTALIT 3446 is a new high temperature adhesive, with the unique capability of bonding Teflon, Rulon and similar fluorocarbon polymers to themselves or other substrates. STRUCTALIT 3446 when exposed continuously for five day at 260°C, lost only 20% of its bond strength! This unique adhesive can be successfully subjected intermittently to temperatures of 530°C. In addition to heat resistance, STRUCTALIT 3446 is highly chemically resistant to corrosive atmospheres.

Technical Data Bulleting n° 3.001 is available on request from the Dupont Company describing their recommended procedure for the installation of Dupon FEP Teflon shrink fit tubing with STRUCTALIT 3446 high temperature epoxy adhesive which is available both in liquid and paste forms.

1.12

TYPICAL CHARACTERISTICS*

Specific Gravity, 25°C/25°C:

Viscosity, (cps at 25°C): 4000

Heat Distortion Temp. (°C) 300

Weight per gallon (lbs) 9.30

Working life (100 gm. mass ambient at 25°C) (hrs) 48

Coverage (sq.ft./gallon) 150-200

Dielectric strength (volts/mil) 450

Volume resistivity at 25°C (ohm cm) 4 x 10¹⁴

Dissipation factor 0.015

Total mass loss at 125 ℃

Pot life 2½ hours

for a 100 gram mass @t 25°C

complied to the best of our knowledge. The information included in our data sheet is exclusive information for the tended users and describes characteristics, with no declaration of commitment. We recommend trails in order to confirm that our products satisfy the particular application requirements. For an additional technical consultation, please contact our RD department. In general, for guarantee claims please refer to our standard terms and conditions.

Our data sheets have been

Adhesives

and more...



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Collected volatile condensables at 25°C 0.00%

Tensile Shear Bond Strengths

(lap joints ½" x ½" area, kg/cm²)

Stainless Steel 195 to 225

Mild Steel 185 to 245

Aluminum to Aluminum 210 to 295

Aluminum to Teflon 25 to 26

Aluminum to Rulon 26 to 28

INSTRUCTIONS FOR USE

- Surfaces must be clean and grease free. The appropriate surface preparations for the substrate should be utilized for optimum adhesion. Pre-etched fluorocarbon plastics require no further surface preparation.
- 2) Add 1 to 2 % catalyst T-9 to the STRUCTALIT 3446 Base and mix thoroughly.
- Apply STRUCTALIT 3446 by any conventional method, maintaining a glue line of 0,025 - 0,125 mm. Although pressure is not required, clamping or other means of positioning is desirable during cure.

Use the following cure schedule:

- a) Preset adhesive at 95 to 105°C for 2 to 3 hours.
- b) Post cure of 150 to 200°C for 16 to 24 hours provides maximum properties.

Teflon and Rulon are registered trade marks of E.I. Dupont de Nemours Co., Wilmington,

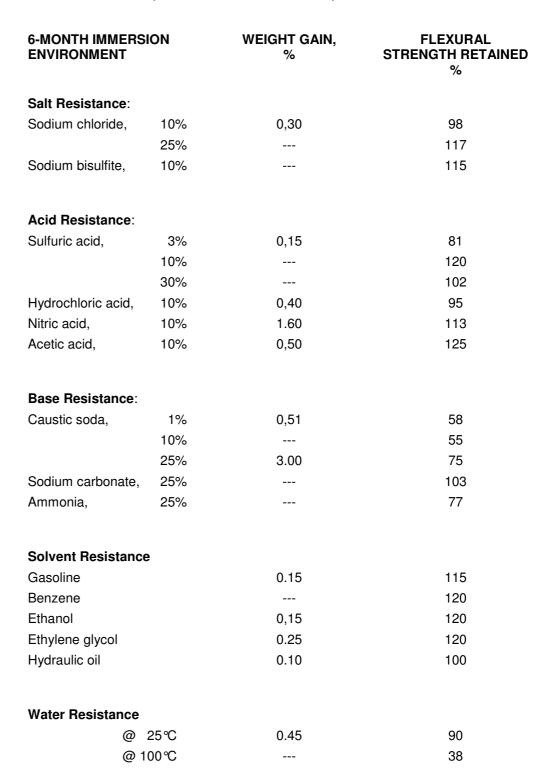
Delaware and Dixon Corp., Bristol, Rhode Island respectively.

^{*}Values listed are typical and are not specifications.

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(CHEMICAL RESISTANCE)





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