



TECHNICAL DATA

ZYROBOND®

CA 3401

Cyanoacrylate Adhesive

CA 3401 is a medium viscosity cyanoacrylate adhesive with quick curing properties.

CA 3401 is specifically developed for bonding difficult surfaces with high industrial strength.

CA 3401 is recommended for universal applications and for rough, porous and acidic surfaces.

APPLICATIONS:

■ Steel	■ Plated Metals	■ Aluminium	■ Wood
■ MDF	■ Rubber	■ Plastics	■ ABS
■ PVC	■ Acrylic	■ Ceramic	■ Leather
■ Textiles	■ Cork	■ Cardboard	■ Paper

TECHNICAL DATA:

Adhesive Properties:

Chemical Basis:	Ethyl Cyanoacrylate
Appearance:	Clear Liquid
Viscosity: (Brookfield LVF, Spindle)	80 – 120 cps @ 25°C
Specific Gravity:	1.15
Flash Point:	80°C - 93°C

Curing Properties: (after 24 hours at 25°C)

Shear Strength:	18 – 28 N/mm ²	ASTM D 1002, DIN 53283
Shear Strength: (Steel, sand blasted)	> 20 N/mm ²	ASTM D 1002, DIN 53283
Shear Strength: (Aluminium, etched)	> 18 N/mm ²	ASTM D 1002, DIN 53283
Shear Strength: (ABS)	> 10 N/mm ²	ASTM D 1002, DIN 53283
Shear Strength: (Polycarbonate)	> 12 N/mm ²	ASTM D 1002, DIN 53283
Shear Strength: (Rubber)	> 22 N/mm ²	ASTM D 1002, DIN 53283
Shear Strength: (Wood)	> 25 N/mm ²	ASTM D 1002, DIN 53283
Melting Point Temperature:	160 - 170°C	
Final Cure:	24 hours	
Gap Fill:	0.20 mm	
Temperature Resistance:	-53 to +82°C	



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Flexible Cyanoacrylate Adhesive

Typical Cure Speed:

Fixing Time: (Aluminum)	8 – 10 sec.
Fixing Time: (Rubber)	3 sec.
Fixing Time: (Plastic)	2 – 5 sec.
Fixing Time: (Wood)	1 – 5 sec.
Fixing Time: (Leather)	5 – 15 sec.
Fixing Time: (Ceramic)	12 – 18 sec.

Physical and Electrical Properties:

Glass Transition Temperature:	122°C	ASTM E228
Coefficient of Thermal Expansion:	75x10 ⁻⁶	ASTM D696 K ⁻¹
Dielectric Strength:	n.a.	ASTM D149
Coefficient of Thermal Conductivity:	0.1 W.m ⁻¹ K ⁻¹	ASTM C177
Specific Volume Resistance:	n.a.	ASTM D257
Specific Surface Resistance:	n.a.	ASTM D257
Dielectric Constant:	n.a.	ASTM D150

Chemical Resistance:

Medium	Temperature	% Initial Strength	
		500 Hours.	1000 Hours.
Isopropanol:	22°C	85	85
Petrol:	22°C	80	75
Motor Oil:	40°C	90	90
Spirit:	22°C	90	90

Instructions for Use: Surfaces should be dry, clean and free of any contamination. Best results will be achieved with surfaces that have been lightly abraded immediately prior to bonding. If using accelerator, apply to one component surface only. Apply a thin film of adhesive to the other surface and bring the 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.

Bonding Times: Under normal conditions, the surface moisture initiates the curing process. Functional strength is developed very quickly; however, the curing process continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on the substrates used.

Storage: Cyanoacrylate adhesives should ideally be stored in a cool, dry place in unopened containers. For long term storage, cyanoacrylate adhesives should be refrigerated or stored at temperatures below 8°C. The shelf life (stored at room temperatures) can be up to 1 year (modified cyanoacrylates 6-9 months). If refrigerated, cyanoacrylates can remain within specifications for up to 2 years (modified cyanoacrylates up to 1 year).

General information: The information contained herein serves merely as an indication and is given to the best of knowledge. The users must test the suitability of the product for her/his/their respective application independently however. All products purchased from or supplied by Nohtec are subject to terms and conditions set out in the contract. Nohtec warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Nohtec 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. Nohtec 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 infringe any patent.