



TECHNICAL DATA

ZYROBOND®

CA 3460

Cyanoacrylate Adhesive

CA 3460 is a low viscosity cyanoacrylate adhesive with reduced blooming and minimal odour. Especially developed for critical cosmetic bonding and for workplaces with insufficient ventilation.

CA 3460 is recommended for jewellery, furniture and optical applications as well as for arts and crafts, advertising and on medical appliances.

APPLICATIONS:

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

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Adhesive Properties:

Chemical Basis:	Alkoxy Ethyl Cyanoacrylate
Appearance:	Clear Liquid
Viscosity: (Cone & Plate)	5-10 mPa-s @ 25°C
Specific Gravity:	1.07 g/cm ²

Curing Properties: (after 24 hours at 22°C)

Shear Strength: (Steel)	14 – 20 N/mm ²	ISO 4587
Shear Strength: (Aluminium)	7 – 9 N/mm ²	ISO 4587
Shear Strength: (ABS)	6 – 10 N/mm ²	ISO 4587
Shear Strength: (Polycarbonate)	5 – 10 N/mm ²	ISO 4587
Shear Strength: (Nitrile Rubber)	5 – 10 N/mm ²	ISO 4587
Tensile Strength: (EPDM)	2 – 6 N/mm ²	ASTM D412 (B)
Tensile Strength: (Neoprene)	5 – 10 N/mm ²	ASTM D412 (B)
Tensile Strength: (Nitrile Rubber)	5 – 10 N/mm ²	ASTM D412 (B)
Final Cure:	24 hours	
Gap Fill:	0.15 mm	

Typical Cure Speed:

Fixing Time: (EPDM)	10 – 15 sec.
Fixing Time: (Neoprene)	10 – 15 sec.
Fixing Time: (Nitrile- Rubber)	10 – 15 sec.
Fixing Time: (ABS)	15 – 40 sec.
Fixing Time: (PVC)	20 – 50 sec.
Fixing Time: (Balsa Wood)	10 – 15 sec.
Fixing Time: (Polycarbonate)	10 – 15 sec.
Fixing Time: (Steel)	20 – 45 sec.
Fixing Time: (Zink)	40 – 80 sec.

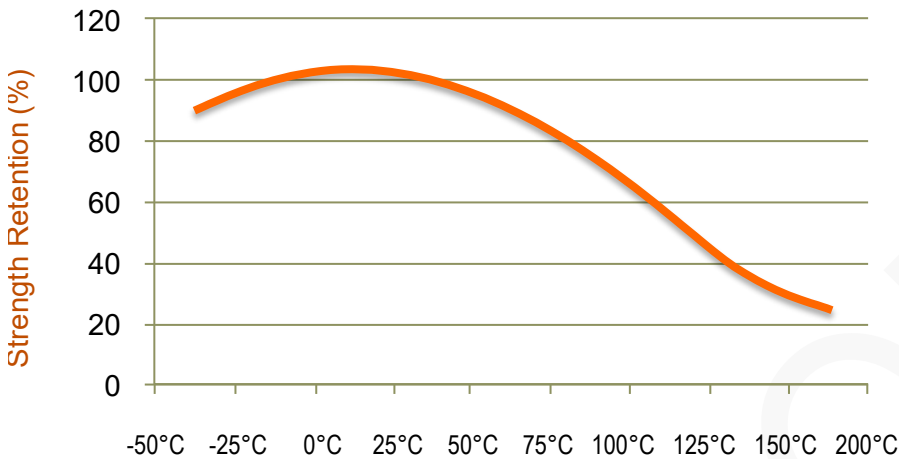


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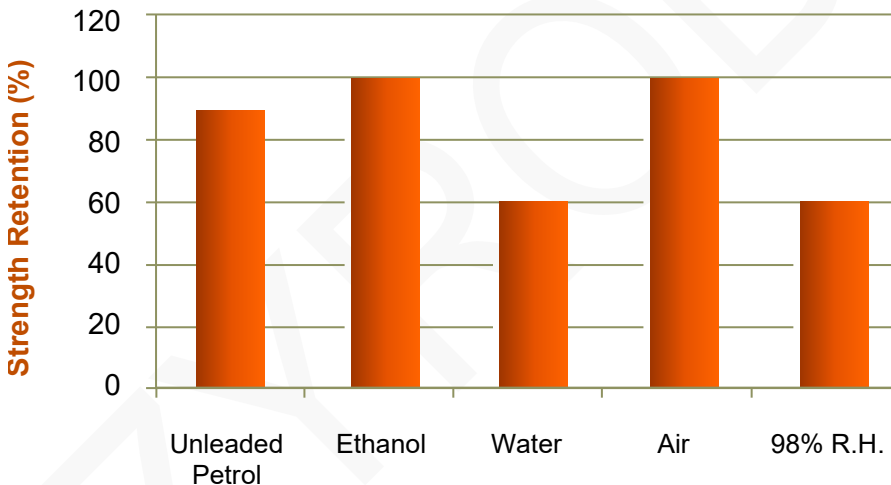
Temperature Resistance

Tested on mild steel, cured for 24-hours and conditioned to test temperature for 1 hour prior to pull test.



Chemical Resistance:

Exposed to conditions for 1,000 hours at 22°C except for 98% RH that had an exposure of 42°C.



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/its/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.