

DESCRIPTION

The PERMACOL Contact Cement 3303 is a cyanoacrylate adhesive or 'super glue' with a high viscosity. This product cures through humidity. This adhesive can be used to bond plastics, rubbers, metals, etc.

Technical details	
Basis	Methoxyethylcyanoacrylate
Colour	Transparent
Density	1,1 g/cm ³
Solid content	100%
Viscosity	1100-1500 mPa.s at 23°C
Flash point	80°C
Max gap filling	0,3 mm
Temperature resistance	-40°C up to 100°C
Setting time	5-120 sec
Curing time	24 hrs
Operating temperature	10°C

	Setting time (s)	Shear resistance (N/mm ²)
Mild steel	5	7-10
Polycarbonate	30	8-11*
Pine wood	30	8-11*
Beech wood	25	11-13*

*:Material breakage

Curing recommendations

Use in a well-ventilated room. Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, etc. Metals are to be sanded to remove the oxide layer before cleaning. If the adhesive is stored in a refrigerator or other low temperature storage, allow the adhesive to reach room temperature before usage. Apply a thin layer of adhesive to one part and assemble the parts together immediately, so the adhesive will spread over the parts equally. Setting time is dependent on the

BENEFITS

- Fast settingtime
- Multi-purpose
- Gap filling
- High viscosity
- RoHS and REACH compatible

humidity and temperature. Don't apply to much adhesive, this will slow down the curing process and reduce the strength of the bond.

CLEANING

At room temperature, the remaining uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK.

Cured adhesives must be removed mechanically. We advise heating up the adhesive bond over 100°C. At this temperature, the adhesive will become softer, and the component can easily be removed using torsion.

STORAGE

Store in its original packaging. Avoid exposure to high humidity and sunlight. Do not open the package while the adhesive is cold. Remove the adhesive from the fridge at least two hours before use. See packaging for the expiration date. Shelf life: 12 months between 5°C and 10°C.

SAFETY

This product contains cyanoacrylic ester. Danger: Sticks within few seconds skin and eyelid to each other. Use protective gloves to avoid direct contact with the skin. Use in a well ventilated room. Use safety glasses to avoid splattering on the eyes. Check the Material Safety Data Sheet for specific safety information.

PACKAGING

The PERMACOL CA 3303 is available in different quantities. Contact us for more information about packaging

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