



Loctite® 3423™

June 2012

PRODUCT DESCRIPTION

Loctite® 3423™ provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (Resin)	Grey paste ^{LMS}
Appearance (Hardener)	Beige paste ^{LMS}
Appearance (Mixture)	Grey paste
Components	Two part - Resin & Hardener
Viscosity	Thixotropic
Mix Ratio, by volume - Resin : Hardener	1 : 1
Mix Ratio, by weight - Resin : Hardener	100 : 70
Cure	Room temperature cure after mixing
Application	Bonding
Key Substrates	Metals , Ceramics, Rigid plastics and Wood

Loctite® 3423™ is a two component, high viscosity, thixotropic epoxy adhesive which cures at room temperature after mixing. It is a general purpose, non sag adhesive which develops high strength on a wide range of substrates. The thixotropic properties enable this adhesive system to bond rough vertical surfaces made from metal, ceramic, rigid plastics or wood through gaps of up to 3 mm. When cured, the adhesive can be sanded to a smooth finish.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin Properties

Specific Gravity @ 25 °C	1.3 to 1.36 ^{LMS}
Flash Point - See MSDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 7, speed 5 rpm	100,000 to 400,000

Hardener Properties

Specific Gravity @ 25 °C	0.95 to 1 ^{LMS}
Flash Point - See MSDS	
Viscosity @ 25 °C, Cone & Plate Rheometer, mPa·s (cP):	
Shear Gradient: 30 s ⁻¹	70,000 to 110,000 ^{LMS}
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 7, speed 5 rpm,	200,000 to 500,000

Mixed Properties

Pot Life @ 25 °C, minutes:	
200 g mass	30 to 60 ^{LMS}

TYPICAL CURING PERFORMANCE

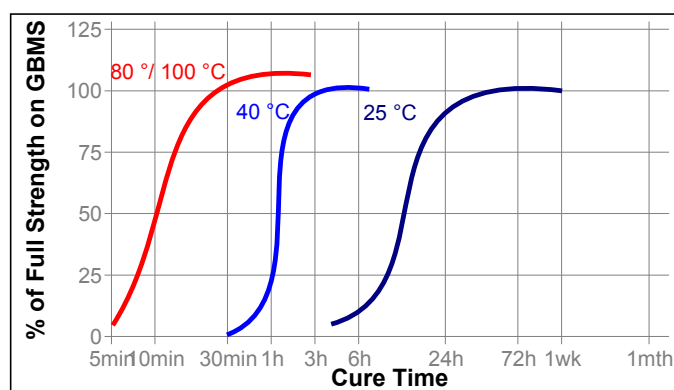
Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Fixture Time, @ 22 °C, hours 3

Cure Speed vs. Time/Temperature

Loctite® 3423™ develops high strength at room temperature within 12 hours. The rate of cure will depend on the ambient temperature, elevated temperatures may be used to accelerate the cure. The graph below shows the shear strength developed with time on grit blasted steel lap shears at different temperatures and tested according to ISO 4587.



TYPICAL PROPERTIES OF CURED MATERIAL

4 mm thick samples cured for 7 days @ 22 °C

Physical Properties:

Coefficient of Thermal Expansion ISO 11359-2, K ⁻¹ :	
Temperature Range: 20 °C to 35 °C	31×10 ⁻⁶
Temperature Range: 85 °C to 200 °C	192×10 ⁻⁶

1.2 mm thick samples cured for 7 days @ 22 °C

Physical Properties:

Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.28
Shore Hardness, ISO 868, Durometer D	70 to 80
Glass Transition Temperature, ASTM E 1640, °C	55
Elongation, ISO 527-3, %	2
Tensile Strength, ISO 527-3	N/mm ² 24 (psi) (3,500)
Tensile Modulus, ISO 527-3	N/mm ² 1,500 (psi) (220,000)
Compressive Strength, ISO 604	N/mm ² 64 (psi) (9,300)



Electrical Properties:

Volume Resistivity, IEC 60093, $\Omega \cdot \text{cm}$	30×10^{15}
Surface Resistivity, IEC 60093, Ω	400×10^{15}
Dielectric Constant / Dissipation Factor, IEC 60250:	
1 kHz	2.9 / 0.01
1 MHz	2.7 / 0.02
10 MHz	2.7 / 0.02

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 7 days @ 22 °C, tested at 22 °C.

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm ²	15 to 19
	(psi)	(2,200 to 2,800)
Stainless steel (grit blasted)	N/mm ²	13 to 17.5
	(psi)	(1,900 to 2,500)
Aluminum (abraded)	N/mm ²	7 to 12
	(psi)	(1,000 to 1,700)
Aluminum (etched)	N/mm ²	7 to 11
	(psi)	(1,000 to 1,600)
Galvanized Steel (HD)	N/mm ²	5 to 11
	(psi)	(730 to 1,600)
Zinc dichromate	N/mm ²	6.5 to 10.5
	(psi)	(940 to 1,500)
Brass	N/mm ²	4 to 12
	(psi)	(580 to 1,700)
GRP (smooth skim side)	N/mm ²	0.6 to 1.2
	(psi)	(90 to 170)
Phenolic	N/mm ²	1 to 1.8
	(psi)	(150 to 260)
ABS	N/mm ²	0.5 to 1.1
	(psi)	(70 to 160)
Polycarbonate	N/mm ²	1 to 4
	(psi)	(150 to 580)
Hardwood (Mahogany)	N/mm ²	5 to 13
	(psi)	(730 to 1,900)
Softwood (Red Deal)	N/mm ²	6 to 12
	(psi)	(870 to 1,700)

180° Peel Strength, ISO 8510-2:

Mild Steel (grit blasted)	N/mm	2 to 3
	(lb/in)	(11.4 to 17.1)

TYPICAL ENVIRONMENTAL RESISTANCE

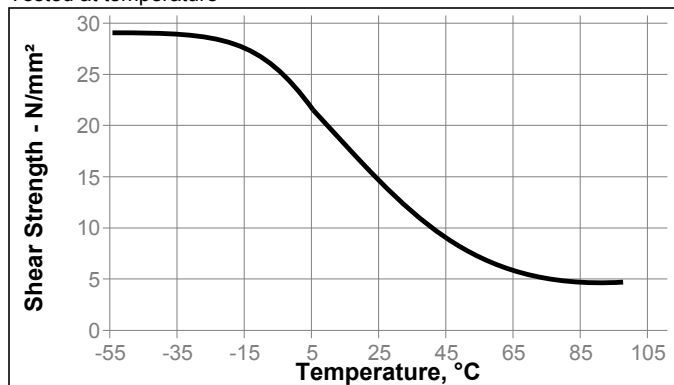
Cured for 7 days @ 22 °C

Lap Shear Strength, ISO 4587:

Mild Steel (grit blasted)

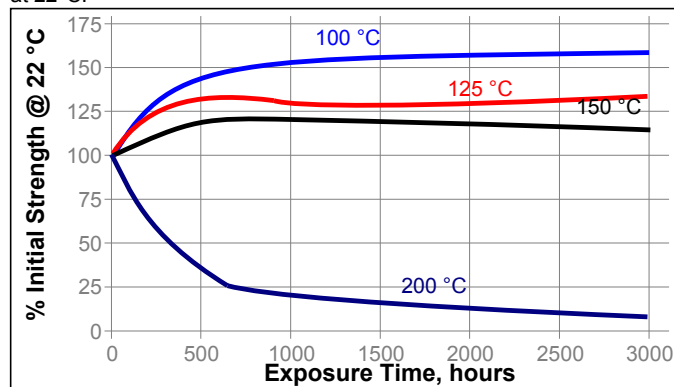
Hot Strength

Tested at temperature



Heat Aging

Cured for 5 days @ 22 °C. Stored at temperatures indicated and tested at 22 °C.



Chemical/Solvent Resistance

Immersed in conditions indicated and tested at 22 °C.

Environment	°C	% of initial strength		
		100 h	400 h	1000 h
Motor oil	22	90	90	50
Acetic Acid, 10%	22	85	80	60
Sodium Chloride, 7.5%	22	100	100	55
Sulfuric Acid, 6.5%	22	100	90	80
Water	60	85	85	80
Water	90	90	70	60
Humidity, 98% RH	40	100	100	100

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

Directions for use

1. For best performance surfaces for bonding should be clean, dry and free of grease. For high strength structural bonds, special surface treatments can increase the bond strength and durability.
2. To use, resin and hardener must be blended. Product can be applied directly from dual cartridges by dispensing through the mixer head supplied. Discard the first 3 to 5 cm of bead dispensed. Using bulk containers, mix thoroughly by weight or volume in the proportions specified in the Product Description Matrix. For hand mixing, weigh or measure out the desired amount of resin and hardener and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.
3. It is recommended that this product is not mixed and cured in bulk quantities of greater than 4 kg as excessive heat build-up can occur. Mixing smaller quantities will minimize the heat build-up.

4. Apply the adhesive as quickly as possible after mixing to one surface to be joined. For maximum bond strength apply adhesive evenly to both surfaces. Parts should be assembled immediately after mixed adhesive has been applied.
5. For working life please see section 'Typical Properties of Uncured Material'. Higher temperatures and larger quantities will shorten this working time.
6. Keep the assembled parts from moving during cure. The joint should be allowed to develop full strength before subjecting to any service loads.
7. Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
8. After use and before adhesive hardens, mixing and application equipment should be cleaned with hot soapy water.

Loctite Material Specification^{LMS}

LMS dated July 26, 2005. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{MPa}\cdot\text{s} = \text{cP}$

Note

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Reference 1.2