

#625

QUICK-WELD #3

Rubber Toughened
Cyanoacrylate Adhesive

QUICK-WELD #3 is high viscosity combined with high temperature resistance, and excellent resistance to peel and shock loads. Specifically formulated to bond various rubbers, metals, wood and plastics for use in challenging environments.

APPLICATIONS:

- Ideal for bonding rubbers, metals and plastics.
- Ideal for Automotive Components, Electronic Parts, Electrical Components, Speaker Assemblies, Computer Assemblies, etc.

PHYSICAL PROPERTIES:

LIQUID

Composition	Rubber Toughened Ethyl Cyanoacrylate
Appearance	High Viscosity Liquid
Viscosity @ 77°F (25°C) Brookfield RTV	5,000 - 6,000 cps
Flash Point (TCC), °C	>93
Specific Gravity @ 25°C	1.06

CURED ADHESIVE

Gap Filling	0.6 mm
Tensile Shear Strength	13-25 N/mm ²
Service Temperature Range	-60 to +210°F
Full Cure	24 hours

Shear Strength ASTM D 1002/DIN 53283

Neoprene Rubber	>12 N/mm ²
Nitrile Rubber	>12 N/mm ²
SBR Rubber	>10 N/mm ²
PVC	> 6 N/mm ²
Aluminum	>17 N/mm ²
Steel	>24 N/mm ²
Polycarbonate	> 7 N/mm ²

ADDITIONAL PHYSICAL PROPERTIES:

Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ k ⁻¹	0.1
Glass Transition Temperature, ASTM E228, °C	125
Coefficient of thermal expansion, ASTM D696, K ⁻¹	80x10 ⁻⁶
Dielectrical Strength, ASTM D149, kV/mm	25

CHEMICAL RESISTANCE PROPERTIES:

Chemical	Temp	% Initial Strength Retained	
		500 hours	1000 hours
Isopropanol	22°C	85	85
Gasoline	22°C	80	75
Motor Oil	40°C	90	90
Mineral Spirit	22°C	90	90



BONDING TIMES:

Neoprene Rubber	<5 seconds
Nitrile Rubber	<5 seconds
SBR Rubber	15-25 seconds
ABS	15-40 seconds
Steel	15-50 seconds
Aluminum	10-25 seconds
Phenolic Materials	10-50 seconds
Polycarbonate	30-80 seconds

APPLICATION INSTRUCTIONS:

- All surfaces must be clean, dry, dust and grease free. Best results will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using IES #650 accelerator, apply to one surface only. Apply a thin film of adhesive to the other surface and bring 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.

STORAGE:

- Avoid direct sunlight which causes polymerization.
- Store in a dry place. Small amounts of moisture (contained in the air) can cause polymerization. Keep cap tightly closed when not in use.
- Maintain temperature below 80°F. Refrigeration storage (40°F) will extend shelf life. Allow product to attain room temperature before using.