

Technical Data Sheet Tuffbond® 3661

November 2019

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Product Description

Hernon® Tuffbond® 3661 is a unique room temperature curing, two component epoxy-containing adhesive for high temperature bonding and potting applications. It is formulated to cure at room temperature, with a convenient mixing ratio of 1:1. **Tuffbond® 3661** produces high strength bonds whose strength is maintained even after long exposure to temperatures in the 250° to 300°F range.

Product Benefits

- Convenient mixing
- Solid, No Solvent
- Low Shrinkage
- Superior durability
- Thermal shock and chemical resistance
- Versatile cure schedules, ambient temperature cure or fast-elevated temperature cure as required.

Typical Properties (Uncured)

Property	Part A	Part B
Appearance	White	Gray
Viscosity at 25°C, cP	70,000 -130,000	70,000 -130,000
Mix Ratio by Weight	1	1
Specific Gravity	1.59	1.66
Flash Point	See SDS	See SDS

Typical Properties (Cured)

Physical Properties

Property	Value
Working Life at 22°C (20g), minutes	10 to 30
Operating Temperature, °C	-54 to 150
Hardness, Shore D	80 to 90
Glass Transition Temperature, (T _g) °C	69
Coefficient of thermal expansion, ASTM D696	
Before T _g	25 x 10 ⁻⁶ K ⁻¹
After T _g	150 x 10 ⁻⁶ K ⁻¹
Coefficient of thermal conductivity, ASTM C 177, W/(m·K)	0.47

Typical Cured Performance

Shear Strength on grit blasted steel lap-shear specimens tested according to ASTM D1002.

Cure Time at 22°C	Shear Strength (psi)
24 Hours	≥ 1500

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 Safety Data Sheet (SDS).

Storage

Tuffbond® 3661 should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°C) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.

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