

Technical Data Sheet

Tuffbond[®] 3661

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Product Description

Hernon[®] Tuffbond[®] 3661 is a unique room temperature curing, two component epoxy 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. The hardened adhesive is electrically insulative and heat conductive.

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 | Black |
| Viscosity at 25°C, cP | 70,000 -130,000 | 70,000 -130,000 |
| Mix Ratio by Weight | 1 | 1 |
| Specific Gravity | 1.58 | 1.66 |
| Flash Point | See MSDS | See MSDS |

Typical Properties (Cured)

Physical Properties

| Property | Value |
|--|----------------------------------|
| Working Life at 22°C (100g), minutes | 15 to 30 |
| Full Cure at 22°C, hours | 24 |
| Shear Strength, psi | ≥ 1500 |
| Elongation, % | 2 to 4 |
| Hardness, Shore D | 80 to 90 |
| Coefficient of Thermal Expansion, in/in/°C | 15 x 10 ⁻⁵ |
| Thermal Conductivity, W/m ² K | 0.4 |
| Temperature Range | -58 to 300 °F (-50 to 150 °C) |

Electrical Properties

| Property | Value |
|----------------------------|------------------------|
| Dielectric Strength, V/mil | 690 |
| Dielectric Constant | 1.6 |
| Dissipation Factor | 0.01 |
| Volume Resistivity, ohm-cm | 1.2 x 10 ¹⁴ |

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).

Storage

Tuffbond[®] 3661 should be stored in a cool, dry location in unopened containers at a temperature between 46°F to 82°F (8°C to 28°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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