

Technical Data Sheet Tuffbond[®] 3661

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Page 1 of 1

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	100,000	100,000
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 20
Full Cure at 22°C, hours	24
Tensile Strength, psi	9700
Elongation, %	2 to 4
Hardness, Shore D	80 to 90
Coefficient of Thermal Expansion, in/in/°C	42 x 10 ⁻⁶
Thermal Conductivity, BTU in/ft ² /hr/°F	5

Electrical Properties

Property	Value
Dielectric Strength, V/mil	690
Dielectric Constant	3.8
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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