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Laboratory Data Sheet

Product 3901

Industrial Product, June 1999

PRODUCT DESCRIPTION

LOCTITE® Product 3901 is a fast heat curing, one component, thixotropic epoxy adhesive. It provides good bond strength to many materials and its beige color provides easy inspection.

TYPICAL APPLICATIONS

Product 3901 is designed for bonding to difficult substrates, such as polyimide, liquid crystal polymer and polyphenylene sulfide. The product offers good resistance to many chemicals.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy
Appearance	Beige color
Viscosity, Haake cone and plate 35 mm 2°:	
5 s-1, mPas (cP)	30,000 to 60,000
20s-1, mPas (cP)	12,000 to 35,000
Specific Gravity @ 25°C	1.2
Flash Point, TCC, °C (°F)	>93 (>200)

TYPICAL CURING PERFORMANCE

It is recommended that this product be cured at 125°C for 3 minutes, or 150°C for 2 minutes.

PERFORMANCE OF CURED MATERIAL

	Typical Value
Lap shear, grit blasted steel with 5 mil gap, N/mm ²	11.25
DSC, % conversion @ 124°C for:	-
2 minutes, %	83
3 minutes, %	91
4 minutes, %	>95
Tg, °C	110

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).

Directions for use

Read material safety data sheet before use. Thoroughly clean all substrates to be bonded. Allow the product to thaw to room temperature before use. Actual cure time depends on mass and geometry of part.

Storage

Product shall be ideally stored in a frozen location in unopened containers at a temperature between -20°C to -5°C (-4°F to 23°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact your local Technical Service Center.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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