Technical Data Sheet

3220

3220 is a kind of one component anaerobic adhesive with high strength and good cold water resistance. Be mainly used to bond silicon rod and polyester sheet.

This material is recommended for use in the silicon cutting process by diamond wire saw, to temporarily fix the silicone rod and polyester sheet.

Technology / Base	Acrylate
Type of Product	Adhesive
Components	One component
Curing	Anaerobic
Appearance / Color	Green
Consistency	liquid

Features and Benefits

- One component requires no mixing
- Fast cure speed and short curing time
- High bond strength on silicone rods and polyester sheets
- Good cold water resistance and short debonding time in hot water

Application Instructions

1. Coating surface area should be clean with alcohol and free of any fluxes, residues, dust or any other contaminants. The side face of polyester sheet should be taped to avoid adhesive curing at polyester sheet sides.
2. Brush the activator 3302 on both mating surfaces to be bonded. Allow the solvent to evaporate under good ventilation until the surfaces are completely dry.
3. Apply the anaerobic product to polyester sheet surfaces. Smooth the top of the adhesive by a scraper without bubbles.
4. Attach the silicone rod to the coating surface of polyester sheet and impact them together.
5. After the adhesive sets, clean the residue adhesive in the chamfers of bonding surfaces.
6. Clean the silicone rod and let the bonded joints curing 3 hours or more. Then move them to the next step for cutting.

Storage Conditions

The product should be stored in a cool, dry location at a temperature between 10℃ to 28℃ for a maximum shelf life of 12 months. Do not return unused material to container, as it would result in contamination and/or premature hardening of contents

Typical Packaging

Please contact your local Sales Office for available packaging options.

Disposal Advice

Please refer to the MSDS for disposal instructions.

Safety Advice

Please refer to the MSDS for safety advice.

Technical Data

Rheology	Value	Condition/Method
Viscosity (cps @ 23℃)	2000	
Density		
Density(g/cm^3)	1.03	
Curing		
Flash Point(℃)	>93	ISO3678, GB/T 5208-2008
Cure Speed(Fixture/Full)	5min/3 hrs.	Cured @ (23±2)℃，(50±5)%RH Cured Specifications: Cure speed will vary with temperature, relative humidity, and bonded materials.
Cured Mechanical Properties		
shear strength/(MPa/23℃)	≥10	
debonding time in 70℃ water（min）	≤6	

Date Modified: 13/06/2018

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