

## LOCTITE® EA 3421

Known as Hysol 3421  
October 2014

### PRODUCT DESCRIPTION

LOCTITE® EA 3421 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Chemical Type</b>	Epoxy
<b>Appearance (Resin)</b>	White to off-white paste <sup>LMS</sup>
<b>Appearance (Hardener)</b>	Amber, Clear liquid <sup>LMS</sup>
<b>Appearance (Mixture)</b>	Clear amber-yellow
<b>Components</b>	Two part - Resin & Hardener
<b>Viscosity</b>	Medium
<b>Mix Ratio, by volume - Resin : Hardener</b>	1 : 1
<b>Mix Ratio, by weight - Resin : Hardener</b>	100 : 90
<b>Cure</b>	Room temperature cure after mixing
<b>Application</b>	Bonding
<b>Specific Benefit</b>	Excellent on surfaces made from metal, ceramic, wood, glass or rigid plastics

LOCTITE® EA 3421 is a two component epoxy adhesive which cures slowly at room temperature after mixing. It is a general purpose, flowable adhesive which develops high strength and has excellent moisture resistance. The long working life and medium viscosity make this adhesive system suitable for large surfaces and where adjustment time is needed after assembly.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

#### Resin Properties

Specific Gravity @ 25 °C	1.12 to 1.18 <sup>LMS</sup>
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 6, speed 2.5 rpm	30,000 to 90,000 <sup>LMS</sup>
Spindle 6, speed 5 rpm,	60,000 to 100,000

#### Hardener Properties

Specific Gravity @ 25 °C	0.94 to 1.1 <sup>LMS</sup>
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 6, speed 5 rpm,	9,000 to 19,000
Spindle 6, speed 10 rpm	11,000 to 19,000 <sup>LMS</sup>

#### Mixed Properties

Pot Life @ 25 °C, minutes:	
200 g mass	30 to 150 <sup>LMS</sup>

### TYPICAL CURING PERFORMANCE

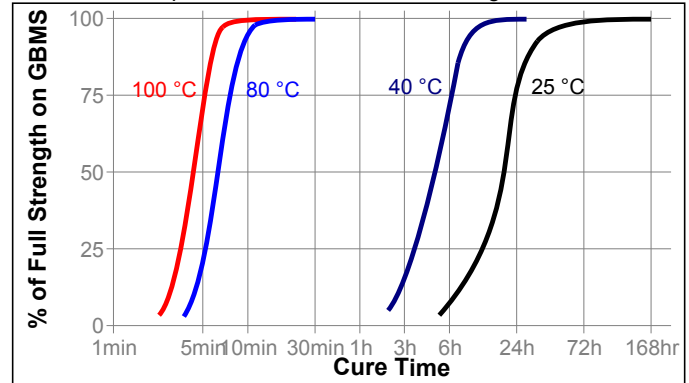
#### Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

Fixture Time, @ 22 °C, hours 4

#### Cure Speed vs. Time/Temperature

LOCTITE® EA 3421 develops high strength at room temperature within 36 hours. The rate of cure will depend on the ambient temperature, elevated temperatures may be used to accelerate the cure. The graph below shows the shear strength developed with time on grit blasted steel lap shears at different temperatures and tested according to ISO 4587.



### TYPICAL PROPERTIES OF CURED MATERIAL

4 mm thick samples cured for 7 days @ 22 °C

#### Physical Properties :

Coefficient of Thermal Expansion ISO 11359-1, K <sup>-1</sup> :	
Temperature Range: 16.8 °C to 40 °C	45×10 <sup>-6</sup>
Temperature Range: 55.4 °C to 199.4 °C	173×10 <sup>-6</sup>

1.2 mm thick samples cured for 7 days @ 22 °C

#### Physical Properties :

Coefficient of Thermal Conductivity, ISO 8302, W/(m-K)	0.28
Shore Hardness, ISO 868, Durometer D	70 to 80
Glass Transition Temperature, ASTM E 1640, °C	55
Elongation, ISO 527-3, %	6
Tensile Strength, ISO 527-3	N/mm <sup>2</sup> 28 (psi) (4,000)
Tensile Modulus, ISO 527-3	N/mm <sup>2</sup> 965 (psi) (140,000)
Compressive Strength, ISO 604	N/mm <sup>2</sup> 69 (psi) (10,000)

**Electrical Properties:**

Volume Resistivity, IEC 60093, Ω·cm	1×10 <sup>15</sup>
Surface Resistivity, IEC 60093, Ω	4×10 <sup>15</sup>
Dielectric Constant / Dissipation Factor, IEC 60250:	
1 kHz	4.3 / 0.04
1 MHz	3.7 / 0.04
10 MHz	3.6 / 0.03

**TYPICAL PERFORMANCE OF CURED MATERIAL**

**Adhesive Properties**

Cured for 7 days @ 22 °C

Lap Shear Strength , ISO 4587:

Steel (grit blasted)	N/mm <sup>2</sup> 20 to 25 (psi) (2,900 to 3,600)
Stainless steel (grit blasted)	N/mm <sup>2</sup> 9 to 12 (psi) (1,300 to 1,740)
Zinc dichromate	N/mm <sup>2</sup> 7 to 12 (psi) (1,000 to 1,700)
Aluminum (abraded)	N/mm <sup>2</sup> 8 to 12 (psi) (1,200 to 1,700)
Aluminum (etched)	N/mm <sup>2</sup> 12 to 16 (psi) (1,700 to 2,300)
Galvanized Steel (HD)	N/mm <sup>2</sup> 9.4 (psi) (1,400)
Brass	N/mm <sup>2</sup> 8 to 11 (psi) (1,200 to 1,600)
Glass-reinforced plastic (GRP)	N/mm <sup>2</sup> 0.5 to 2 (psi) (70 to 290)
Phenolic	N/mm <sup>2</sup> 2.5 to 4.5 (psi) (360 to 650)
ABS	N/mm <sup>2</sup> 0.5 to 1 (psi) (70 to 150)
Hardwood (Mahogany)	N/mm <sup>2</sup> 6 to 15 (psi) (870 to 2,200)
Softwood (Red Deal)	N/mm <sup>2</sup> 8 to 10 (psi) (1,200 to 1,500)
Polycarbonate	N/mm <sup>2</sup> 2.5 to 4 (psi) (360 to 580)
Tensile Strength , ISO 6922:	
Mild steel pin (grit blasted) to Soda glass	N/mm <sup>2</sup> 13 to 18 (psi) (1,900 to 2,600)
180° Peel Strength, ISO 8510-2:	
Steel (grit blasted)	N/mm 2 to 3 (lb/in) (11 to 17)

**TYPICAL ENVIRONMENTAL RESISTANCE**

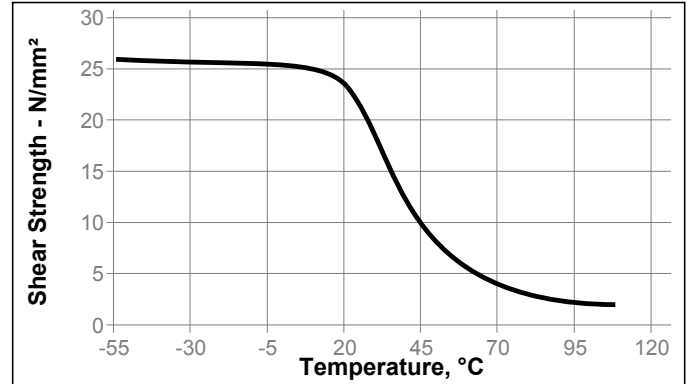
Cured for 7 days @ 22 °C

Lap Shear Strength , ISO 4587:

Steel (grit blasted)

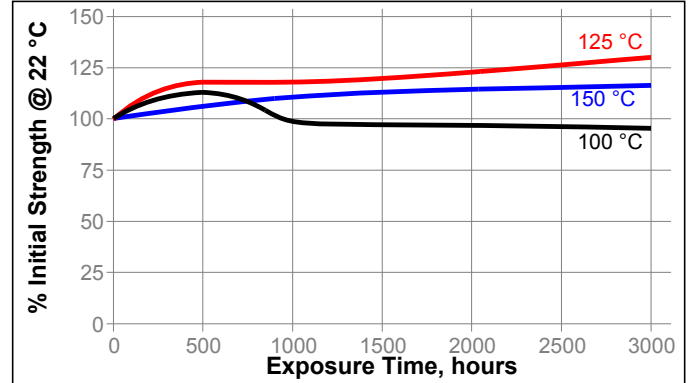
**Hot Strength**

Tested at temperature



**Heat Aging**

Cured for 5 days @ 22 °C, tested at 22 °C.



**Chemical/Solvent Resistance**

Immersed in conditions indicated and tested at 22 °C.

Environment	°C	% of initial strength		
		100 h	400 h	1000 h
Motor oil	22	100	100	50
Acetic Acid, 10%	22	70	70	60
Sulfuric Acid, 6.5%	22	100	100	100
Sodium Chloride, 7.5%	22	100	100	55
Water	60	100	90	90
Water	90	75	75	90
Humidity, 98% RH	40	100	100	100

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested at 22 °C

Tensile Strength , ISO 6922:

Steel (grit blasted) to Soda glass

Environment	°C	% of initial strength	
		400 h	1000 h
Humidity, 98% RH	40	100	100

**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).**

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive.

**Directions for use**

1. For best performance surfaces for bonding should be clean, dry and free of grease. For high strength structural bonds, special surface treatments can increase the bond strength and durability.
2. To use, resin and hardener must be blended. Product can be applied directly from dual cartridges by dispensing through the mixer head supplied. Discard the first 3 to 5 cm of bead dispensed. Using bulk containers, mix thoroughly by weight or volume in the proportions specified in the Product Description Matrix. For hand mixing, weigh or measure out the desired amount of resin and hardener and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.
3. It is recommended that this product is not mixed and cured in bulk quantities of greater than 4 kg as excessive heat build-up can occur. Mixing smaller quantities will minimize the heat build-up.
4. Apply the adhesive as quickly as possible after mixing to one surface to be joined. For maximum bond strength apply adhesive evenly to both surfaces. Parts should be assembled immediately after mixed adhesive has been applied.
5. For working life please see section 'Typical Properties of Uncured Material'. Higher temperatures and larger quantities will shorten this working time.
6. Keep the assembled parts from moving during cure. The joint should be allowed to develop full strength before subjecting to any service loads.
7. Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
8. After use and before adhesive hardens, mixing and application equipment should be cleaned with hot soapy water.

**Loctite Material Specification<sup>LMS</sup>**

LMS dated May 18, 2005. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

**Storage**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} = \text{N/mm}^2$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

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Reference 1.2