



TBP Converting, Inc.
Sikafast 3341 PDS

SikaFast® -3341

Long Open Time, 10:1 Mix Ratio, Toughened, Low/Medium Modulus Structural Methylmethacrylate Adhesive

Typical Product Data

Properties	Component A SikaFast®-3341	Component B SikaFast®-3341
Chemical base	Toughened 2-component methylmethacrylate	
Color	Milky-white	Blue
Color mixed	Blue	
Cure mechanism	Free Radical Polymerization	
Density (uncured)	8.0 lb/gal	8.9 lb/gal
Density mixed	8.1 lb/gal	
Mixing ratio	10:1	
	by volume	
	by weight	
Viscosity ^a (Individual Component), Brookfield Spindle T-D @ 20 RPM	125,000 cps	50,000 cps
Application temperature	50°- 95°F (10°- 35°C)	
Skin Time ^b (CQP ^c 019)	45 minutes	
Peak Exotherm Time / Temperature; (Sika P.4.10.11)	65 minutes / 60°C (140°F)	
Shore D-hardness (ASTM D 2240)	73	
Tensile strength ^b (ASTM D 638)	1450 psi (10 MPa)	
E-Modulus ^b @ 0.1-1% (ASTM D 638)	65,000 psi (450 MPa)	
Tensile lap-shear strength (CQP 046-1)	2200 psi (15 MPa)	
Service temperature range	-40° to 250°F (-40°to 121°C)	
Shelf life (storage below 77°F (25°C))	12 months	9 months

^a 77°F (25°C)

^b 73°F (23°C) / 50% r.h.

^c CQP = Corporation Quality Procedure

Description

SikaFast®-3341 is an extended open time, 10:1 ratio two-component adhesive system based on methylmethacrylate (MMA) polymer technology. Uncured SikaFast®-3341 is a thixotropic, non-sagging paste which allows an easy and precise application.

Product Benefits

- Non-sagging and thixotropic formulation
- Good impact, peel and shear resistance
- Little or no surface preparation with excellent durability

Areas of Application

SikaFast®-3341 is an extended open time, flexible structural adhesive designed to substitute welding, riveting and other mechanical fastening. SikaFast®-3341 is suitable for high strength fastening of joints on different types of substrates including top coats, metals, and plastics, etc., with no or limited surface preparation. This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, label and Safety Data Sheet which are available on request at tsmh@us.sika.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current Product Data Sheet, label and Safety Data Sheet prior to product use.

