



Scotch-Weld™ Cyanoacrylate Adhesive RT3500B

Product Data Sheet

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Supersedes : September 2008

Product Description

Scotch-Weld RT3500B is a high viscosity, black, rubber-toughened Cyanoacrylate adhesive. RT3500B displays excellent peel and impact strength and is well suited to applications involving vibration, thermal shock, temperature cycling and high humidity.

RT3500B is specially formulated to provide a more flexible bond than standard cyanoacrylates. RT3500B can be used up to 105°C and has intermittent temperature resistance up to 125°C.

RT3500B can be used to bond a wide variety of substrates including metals, plastics and rubbers. Scotch-Weld RT3500B can be used on PCB's to provide strain relief for large components.

Physical Properties

Base	Modified Ethyl
Soluble In	Acetone, MEK
Viscosity (cps)	Range @ 2.5rpm 5,000-10,000 Range @ 20rpm 1,000-3,000
Specific Gravity	1.1
Colour	Black

Performance Characteristics

Maximum Gap Fill (best results are obtained with very thin bond lines)	0.20mm
Fixture Time	20-90secs
Tensile Strength (ISO 6922)	20 N/mm ²
Full Cure	24hrs
Speed of Cure	The speed of cure of cyanoacrylates varies according to the substrate to be bonded. Acidic surfaces such as paper and leather will have longer cure times than most plastics and rubbers.
Moisture Resistance	Low resistance to high levels of moisture and humidity over time.
Service Temperature Range	-50 to +105°C

Additional Product Information	Scotch-Weld Activators AC11 and AC12 may be used in conjunction with Scotch-Weld cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most Scotch-Weld cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30%.
Application Techniques	Bond speed is very fast so ensure that parts are properly aligned before bonding. Scotch-Weld Activators may be required if there are gaps or porous surfaces. Some plastics may require application of Scotch-Weld AC77 Primer. Ensure parts are clean, dry and free from oil and grease. Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.
Storage Conditions	Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 6 months. Refrigeration to 0-5°C gives optimum storage stability.
Shelf Life	6 months from date of despatch by 3M when stored in the original carton at 0-5°C
Precautionary Information	Refer to product label and material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com
For Additional Information	To request additional information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA
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