

3M

Scotch-Weld™

Rubber Toughened Instant Adhesives

RT300B • RT3500B

Technical Data

March, 2010

Product Description

3M™ Scotch-Weld™ Rubber Toughened Instant Adhesives are formulated with a unique elastomer that maximizes impact, vibration, peel, and thermal cycling resistance while providing tough flexible bonds. These adhesives are ideally suited for bonding flexible substrates and dissimilar materials.

Specific Features

- 3M™ Scotch-Weld™ Rubber Toughened Instant Adhesive RT300B (formerly PR80) is a medium viscosity black, rubber toughened cyanoacrylate.
- 3M™ Scotch-Weld™ Rubber Toughened Instant Adhesive RT3500B (formerly PR10) is a high viscosity, black, rubber toughened cyanoacrylate. It is formulated to provide a more flexible bond than standard cyanoacrylates and has good gap-filling capabilities.

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Typical Uncured Physical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	3M™ Scotch-Weld™ Rubber Toughened Instant Adhesives	
	RT300B	RT3500B
Color	Black	Black
Base	Ethyl Hybrid	Ethyl Hybrid
Appearance	Liquid	Liquid
Specific Gravity (g/ml)	1.1	1.1
Viscosity (cps)	300 - 1,000 ³	1,000 - 3,000 ¹ 5,000 - 10,000 ²
Time to Handling Strength (sec)	20 - 50	20 - 90
Full Cure Time (hr)	24	24

¹ Brookfield RVT, #3 spindle @ 20 rpm.

² Brookfield RVT, #3 spindle @ 2.5 rpm.

³ Brookfield LFT, #2 spindle.

Typical Cured Properties

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	3M™ Scotch-Weld™ Rubber Toughened Instant Adhesives	
	RT300B	RT3500B
Continuous Temperature Range (°F)	-65 to 200	-65 to 200
Intermittent Temperature Range (°F)	-65 to 250	-65 to 250
Gap Fill (in)	0.004	0.008
Overlap Shear Strength (psi)⁴	1,500	1,300

⁴ ASTM D1002 (grit-blasted steel).

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Handling Information

Surface Preparation

For optimum strength structural bonds, paint, oxide films, oils, dust, mold release agents, and all other surface contaminants must be completely removed. However, the amount of surface preparation depends on the required bond strength and the environmental aging resistance desired by the user. Typical quick surface preparation would include wiping with a clean solvent (such as isopropyl alcohol*), abrading the surface with a clean fine abrasive, and then wiping again with a clean solvent to remove loose particles.

Directions for Use

1. Ensure that parts are clean, dry, and free from oil and grease.
2. A instant adhesive activator may be required if there are bonding gaps or porous substrate surfaces, if substrates are low surface energy plastics (e.g., polyethylene, polypropylene) or if substrates have acidic surfaces (e.g., paper, leather).
3. Bond speed is typically very fast so ensure that parts are properly aligned before dispensing.
4. 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 slower cure speed and lower bond strength.

Cured Bond Characteristics

1. Full bond strength will typically be achieved within a 24 hour cure time.
2. Low humidity or low temperature conditions will slow down the cure rate.
3. After curing, 3M™ Scotch-Weld™ Rubber Toughened Instant Adhesive bonds are suitable for use at temperatures up to 200F (93°C) continuously, intermittently up to 250°F (121°C). At 220°F (105°C) the bond will be approximately 40% of the strength at room temperature.
4. Cyanoacrylate bond resistance to most oils and solvents is excellent. Long term humidity, moisture, or water immersion may affect the strength of a cured cyanoacrylate bond depending on the substrates and the bond gap. Testing is recommended to evaluate the effect.

***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

Storage

For short term storage (<30 days), keep adhesive in a cool (60°F to 80°F [16°C to 27°C]), dry place out of direct sunlight. Keep containers tightly covered and free of moisture. Refrigeration (40°F [4°C]) gives optimum long term storage stability.

Shelf Life

3M™ Scotch-Weld™ Rubber Toughened Instant Adhesives can be expected to have a shelf life of one year from the date of shipment from 3M when stored under refrigerated conditions.

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Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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ISO 9001:2000

This product was manufactured under a quality system registered to ISO 9001:2000 standards.

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