



# RITE-LOK™ Cyanoacrylate Adhesive RT3500B

## Product Data Sheet

Updated : February 2007  
Supersedes : New

### Product Description

RITE-LOK 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. 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 <sup>2</sup>
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

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<b>Additional Product Information</b>	RITE-LOK Activators AC11 and AC12 may be used in conjunction with RITE-LOK cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most RITE-LOK cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30%.
<b>Application Techniques</b>	Bond speed is very fast so ensure that parts are properly aligned before bonding. RITE-LOK Activators may be required if there are gaps or porous surfaces. Some plastics may require application of RITE-LOK 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.
<b>Storage Conditions</b>	Refrigerate to 5°C. Under such conditions shelf life will be 6 months.  When stored in a cool, dry place away from direct sunlight shelf life will be reduced. Do not store in temperatures exceeding 21°C
<b>Shelf Life</b>	6 months from date of despatch by 3M when stored in the original carton at 5°C
<b>Precautionary Information</b>	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. <a href="http://www.3M.com">www.3M.com</a>
<b>For Additional Information</b>	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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<b>Note</b>	Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendation

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Industrial Adhesives & Tapes Division

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