

# TECHNICAL INFORMATION

## DESCRIPTION

M3500FLX is a rubber-toughened cyanoacrylate adhesives that will display excellent peel and impact strength and is well suited to applications involving vibration, thermal shock, temperature cycling and high humidity

## APPLICATIONS

Specially formulated to provide more flexible bonds than standard cyanoacrylates. This product can be used up to 105°C and have intermittent temperature resistance up to 125°C. It can be used to bond a wide variety of substrates including metals, plastics, rubbers, etc.

## USEFUL HINTS/NOTES

Cured M3500FLX may be removed from most substrates, and parts disassembled, with M68DB debonder. It is not possible to fully remove cyanoacrylate from fabrics.

## PROPERTIES

Very Hgh Viscosity  
Speed: .....  
Metal/Metal <50 seconds  
Plastic/Plastic <30 seconds  
Rubber/Rubber <20 seconds

## INSTRUCTIONS FOR USE

Bond speed is fast so ensure that parts are properly aligned before bonding. Accelerator may be required if there are gaps or porous surfaces.

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.

## COMPATIBLE ACCELERATORS/PRIMER

MH16 Activators can be used for fillet cure or for priming absorbent surfaces.

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## THICK INSTANT M3500FL Rubber- Toughened /Flexible

## TECHNICAL FEATURES

Resin: ..... Ethyl Hybrid CA  
Color: ..... Clear  
Cure Speed with Activator\*: ..... < 5 seconds  
Cure Speed without Activator\*: ... 5-20 seconds  
Viscosity (Thixotropic): ..... 3500 cps  
Gap Fill: ..... .008"  
Flash Point: ..... >185°F  
Shelf Life: ..... 6 months @ 68°F  
Specific Gravity: ..... 1.1  
Max. Operating Temperature: ... -50°F to + 125°F  
\*Depending on Substrait

## CURED PERFORMANCE

Full Cure Time: ..... 24 hours @ 68°F  
Tensile Shear Strength: ..... 2500-3700 psi

## STORAGE

Store in a cool area out of direct sunlight.  
Refrigeration to 5°C gives optimum storage stability.

## PRESENTATION

Bottles: . . . . .1oz

## HEALTH & SAFETY IN USE

Contains Cyanoacrylate bonds skin and eyes in seconds. If accidental skin bonding happens, use Debonder M68DB and wash with warm soapy water and rise skin apart using a blunt instrument (such as a teaspoon handle). In case of eye contact, bath immediately with water and seek immediate medical attention.  
KEEP OUT OF REACH OF CHILDREN

**REVISED 03/25/07  
M3500FL**