

3M

Scotch-Weld™

Rubber Toughened Instant Adhesive

RT5000B

Technical Data

April, 2016

Product Description

3M™ Scotch-Weld™ Rubber Toughened Instant Adhesives are formulated with a unique elastomer that maximizes impact, vibration, and peel 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 RT5000B 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

3M™ Scotch-Weld™ Rubber Toughened Instant Adhesives RT5000B

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 Adhesive
	RT5000B
Color	Black
Base	Ethyl
Appearance	Liquid
Specific Gravity (g/ml)	1.1
Viscosity (cps) ¹	3,000 – 5,000
Time to Handling Strength (sec)*	<40
Time to full cure (hr)	24

¹ Brookfield viscosity Spindle #4 @ 20 rpm: * On EPDM. Time to handling is substrate dependent. The time needed to support a weight of 7.25 lbs

Typical Cured Properties

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	3M™ Scotch-Weld™ Rubber Toughened Instant Adhesive
	RT5000B
Continuous Temperature Range (°F)	-60 to 180F
Gap Fill (in)	0.008
	Overlap Shear Strength (psi) ¹
Steel ²	2400
Stainless Steel ²	3000
Aluminum ²	2350
ABS	1050 ³
Polycarbonate	1250 ³
PVC	1450 ³
Silicone Elastomer	n/a

¹ ASTM D-1002 ² Grit blasted ³ Substrate failure

3M™ Scotch-Weld™ Rubber Toughened Instant Adhesives RT3500B

Hot Strength on Steel

Temp (F)	Percent of Initial Strength
	RT5000B
72	100
167	81
212	63
257	44

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. An 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 180F (82°C) continuously, intermittently up to 250°F (121°C).
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.

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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 12 months from the date of shipment from 3M when stored under refrigerated conditions.
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.
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ISO 9001:2008

This product was manufactured under a quality system registered to ISO 9001:2008 standards.