

## MT3710

MT3710 is a two-component room temperature curing anaerobic adhesive. It is specially used for bonding motor silicon steel sheet. Medium viscosity, rapid curing at room temperature with the primer MT3300 used, and high strength after curing. It can meet the performance requirements of motor operation.

<b>Technology / Base</b>	Acrylic
<b>Type of Product</b>	Methacrylate ester
<b>Components</b>	Two component
<b>Curing</b>	Anaerobic
<b>Viscosity</b>	Medium
<b>Application</b>	Bonding for Stack Lamination
<b>Strength</b>	High
<b>Appearance (uncured)</b>	Part A: Red; Part B(Primer): Green

### Features and Benefits

- Used with the primer MT3300
- Medium Viscosity
- Fast curing speed at room temperature
- High strength

### Curing Profile

Recommended cure:

- 3-24h @23±2°C

Contact HB Fuller technical support for additional curing recommendations

### Application Instructions

1. Surface treatment: clean the surface of silicon steel sheet with alcohol or acetone to ensure that the surface is clean. If stamping oil is needed, appropriate amount is recommended, otherwise it will affect the bonding strength after curing.
2. Coating primer: if manually used, it is recommended to spray the primer evenly on the substrates, and wait 1-2 minutes until the solvent volatilized and then apply glue; if used by machine, it is recommended to set a reasonable spraying amount according to the amount of adhesive.
3. Sizing: it is recommended to use the machine to glue, and the amount of glue should be tested in advance to ensure that the spread area of glue is moderate, and no glue overflow occurs after pressing;
4. Assembly: after gluing, the silicon steel sheets can be stacked together in a specific mold, and certain pressure is applied to make the gap between the silicon steel sheets meet the size requirements.
5. Curing: put the fixed mold at room temperature for curing. Note: in the curing process do not

make the product by external force impact to avoid damage and failure.

### Storage Conditions

The product should be stored in a cool, dry location at a temperature between 5°C to 30°C for a maximum shelf life of 360 days.

Do not return unused material to container, as it would result in contamination and/or premature hardening of contents.

### Typical Packaging

Stock No. Unit Size

### Disposal Advice

Please refer to the MSDS for disposal instructions.

### Safety Advice

Please refer to the MSDS for safety advice.

### Caution

**Anaerobic products should NOT be used in pure oxygen and/or oxygen rich systems and in direct contact with food and should NOT be selected as a sealant for chlorine or other strong oxidizing materials.**



### Technical Data

Typical Properties of Uncured Material	Value	Condition/Method
<b>Rheology</b> Viscosity	1000~3000 mPa·s	Brookfield - RVT, 25 °C, Spindle 4, speed 20 rpm
Density	1.05g/cm <sup>3</sup>	GB/T13354
Flash point	102°C	ASTM D7263
<b>Curing</b> Fixture Time Full curing time	0.5-3 min 3-24h	with primer
<b>Cured Mechanical Properties</b> <b>After 24 hours @ 23±2 °C</b> Lap shear strength@1h Lap shear strength@24h	≥8.0Mpa ≥10.0Mpa	GB/T 7124 (DIN EN 1465)
Solvent Resistance	good	
Operating Temperature Range	-60 to 180°C	

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