The **3523** is a two-component, quick-curing epoxy adhesive specifically designed for fiber optic and opto-electronic applications where a color change is required to indicate complete cure. This product has been designed for terminating single and multi-mode fiber optic connectors, fiber optic bundle potting, encapsulating glass fibers in ferrules, and bonding to a variety of substrates including most metals, glass, plastic and ceramic substrates.

### PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Mix ratio by weight</th>
<th>Viscosity</th>
<th>Resin</th>
<th>Color (unmixed)</th>
<th>Color (mixed)</th>
<th>Color (cured)</th>
<th>Cure (150º C)</th>
<th>Cure (120º C)</th>
<th>Cure (100º C)</th>
<th>Cure (80º C)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>10:1 by weight</td>
<td>1000-2000 cps @ 25º C</td>
<td>Epoxy</td>
<td>Light yellow</td>
<td>Green to Blue</td>
<td>Amber-red</td>
<td>1 min</td>
<td>2 min</td>
<td>15 min</td>
<td>30 min</td>
</tr>
</tbody>
</table>

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Mix ratio (Base to Activator) 100:10 by weight

Specific Gravity, g/cc, Resin 1.21 at 25º C
Specific Gravity, g/cc, Activator 0.99 at 25º C
Specific Gravity, g/cc, Mix 1.19 at 25º C

Pot Life (100 grams) 3 Hours
Operating temperature (-60 º C to + 150 º C)

Glass Transition Temp (Tg) 121º C
Tensile lap shear strength, psi 2,400

CTE Below Tg 68.1 ppm/ º C
CTE Above Tg 100 ppm/ º C

Shore D Hardness 86

Nd 1.57

Consistency Liquid

Water absorption 0.004

Viscosity
- Resin 5000-6000 cps
- Hardener 500-600 cps
- Mix 1500-2000 cps

Substrates glass, ceramics, plastics, metals

Packaging 2 part kits
- Dual cartridges
- Mix-packs
- Pre-mixed and frozen syringes

Applications Single Mode, Multi-channel up to 125 micron core fibers, Connectors. Designed to meet Telecordia specifications. Epoxy can also be used in opto-electronic and medical applications

Shelf Life 1 Year
Storage Temperature Ambient

Use All surface to be clean and dry prior to application
- Mix thoroughly until uniform color is achieved
- Apply adhesive to substrate
- Cure per suitable time and temperature listed above
- Do not mix more than 20 grams per shot