



PRODUCT INFORMATION

HIGH TECHNOLOGY MATERIALS

3523 Rev. 0
8/17/12



MERECO 3523

FIBER OPTIC ADHESIVE

HIGH TEMPERATURE EPOXY ADHESIVE WITH COLOR CHANGE TO INDICATE CURE

MERECO 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

Mix ratio by weight	10:1 by weight
Viscosity	1000-2000 cps @ 25° C
Resin	Epoxy
Color (unmixed)	Light yellow
Color (mixed)	Green to Blue
Color (cured)	Amber-red
Cure (150° C)	1 min
Cure (120° C)	2 min
Cure (100° C)	15 min
Cure (80° C)	30 min

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FORM 1105 REV. 0

Mix ratio (Base to Activator)	100:10 by weight
Specific Gravity, g/cc, Resin	1.21 at 25° C
Specific Gravity, g/cc, Activator	0.99 at 25° C
Specific Gravity, g/cc, Mix	1.19 at 25° C
Pot Life (100 grams)	3 Hours
Operating temperature	(-60 ° C to + 150 ° C)
Glass Transition Temp (Tg)	121° C
Tensile lap shear strength, psi	2,400
CTE Below Tg	68.1 ppm/ ° C
CTE Above Tg	100 ppm/ ° 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