



# Scotch-Grip<sup>TM</sup> Rubber & Gasket Adhesive

2141

Technical Data

November, 2004

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## Features

- A light colored, high strength adhesive with a long tack range.
- Excellent water, oil and grease resistance.
- Bonds neoprene, natural, reclaim SB-R and butyl rubber to most substrates.

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## Typical Physical Properties

**Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

<b>Viscosity (approx.):</b>	900 - 1500 cps
<b>Brookfield Viscometer:</b>	RVF #2 Sp. @ 20 rpm @ 80°F (27°C)
<b>Solids (by wt.):</b>	28 - 32%
<b>Base:</b>	Polychloroprene
<b>Color:</b>	Yellow
<b>Net weight (approx.):</b>	7.0 - 7.4 lbs./gal.
<b>Flash point:</b>	-14°F [-26°C] (T.C.C.)
<b>Solvent:</b>	Petroleum Distillate, Toluene, Acetone and n-Hexane

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## Typical Adhesive Performance Characteristics

**Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

Adhesive was brush applied to substrates and bonded while still tacky. The bonds were then tested in 180° peel and shear after aging for times indicated.

### 180° Peel Strength – Canvas/Steel

### Overlap Shear Strength – 1/8" Birch/Birch

Time @75°F (24°C)	Test Temperature	Value (lbs./in. width)	Time @75°F (24°C)	Test Temperature	Value (psi)
1 day	75°F (24°C)	6	3 weeks  after 3 weeks	75°F (24°C)  180°F (82°C)	377  68
3 days	75°F (24°C)	10			
5 days	75°F (24°C)	24			
7 days	75°F (24°C)	32			
2 weeks	75°F (24°C)	32			
3 weeks	75°F (24°C)	30			
after 3 weeks	-30°F (-34°C)	14			
after 3 weeks	150°F (66°C)	24			
after 3 weeks	180°F (82°C)	22			

## Handling/Application Information

### Directions For Use:

- Surface Preparation:** Surfaces must be clean, dry and dust free. Wiping with solvent such as 3M™ Scotch-Grip™ Solvent No. 3 or Methyl Ethyl Ketone (MEK) will aid in removing oil and dirt.\*
- Application Temperature:** For best results the temperature of the adhesive and the surfaces being bonded should be at least 65°F (18°C).
- Application:** Stir or agitate well before using.  
 Porous Surface(s): Apply a uniform generous brush coat of adhesive to one or both surfaces. Highest strengths are obtained when both surfaces are coated. Highly absorbent materials may require two coats.  
 Non-Porous Surface(s): Brush an even coat of adhesive on both surfaces. Press surfaces together firmly to ensure contact.
- Drying Time:** When apply adhesive to only one surface the bond must be made immediately, while the adhesive is wet. When applying adhesive to both surfaces allow the adhesive to dry until tacky, but does not transfer to knuckle when touched (typically 5-10 minutes, depending on temperature, humidity, etc.).
- Bonding:** After drying, you have up to 15 minutes to make the bond. Press surfaces together firmly to ensure contact.
- Cleanup:** Excess adhesive may be removed with solvent such as 3M™ Scotch-Grip™ Solvents No. 2 or 3 or MEK, or 3M™ Citrus Base Industrial Cleaner.\*

**\*Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

# Scotch-Grip™

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### Application Equipment Suggestions

Appropriate application equipment enhances adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

1. **Pumping:**

A. **5 gallon or less dispensing system:** Use a pressure pot rated for 100 psi operating pressure.

B. **55 gallon dispensing system:** Use a 2:1 ratio divorced design double acting ball check type pump, bung mounted. Packings and glands in contact with the adhesive should be Teflon.®\*

\*Teflon is a registered trademark of DuPont.

2. **Hoses:** All material hoses should be nylon lined.

3. **Brushes:** Brushes designed to be used with oil based paints may be used.

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### Storage and Handling

Store product at 60-80°F (15-26°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a "first-in first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 15 months.

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**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.

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**For Additional Information** To request additional product information or to arrange for sales assistance, call toll free (800) 235-2376. Address correspondence to: 3M Aerospace and Aircraft Maintenance Division, 3M Center, Building 223-1N-14, St. Paul, MN 55144. If you are outside of the U.S., please contact your nearest 3M office or branch.

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This product was manufactured under a 3M quality system registered to AS9100 standards.



## Aerospace and Aircraft Maintenance Division Transportation Business

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