

3M™ Scotch-Weld™ Instant Adhesives



Instant Versatility

Instant success with
metals, rubber, EPDM,
HSE and LSE plastics,
and more



3M™ Scotch-Weld™ Instant Adhesives

Pinch just a single drop per square inch from the handy bottle and bond with up to more than two tons of holding power. That's strength often greater than the bonded materials themselves.

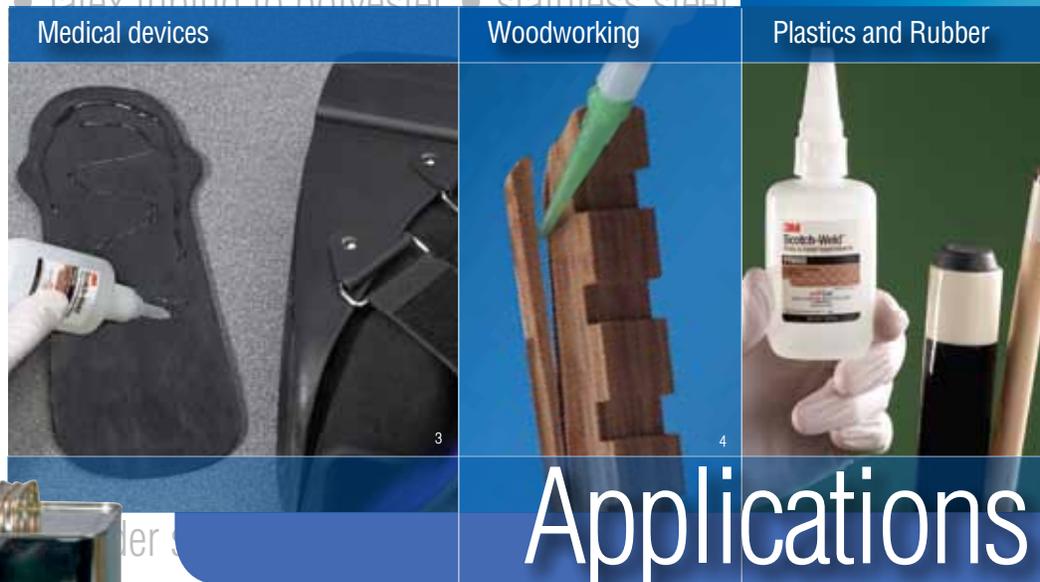
Known as instant adhesives, these solvent-free cyanoacrylates reach handling strength with hundreds of material combination in 5-10 seconds and 80% of full strength in an hour.

But there's more than seconds-fast bonding. Also rely on this line of liquids and gels for a wide selection of other properties to help improve production and end use:

- Super fast curing
- Low odor
- Low blooming
- High temperature resistance
- Rubber-toughened for impact resistance
- Flexible to resist vibration
- Plastics and rubber grade for LSE plastics and hard-to-bond rubbers
- Bonding contaminating and/or acidic surfaces
- High viscosity for gap filling, porous substrates, vertical applications
- Wicking applications for metal, plastic, and rubber
- Many 3M™ Scotch-Weld™ Instant Adhesives have been tested and passed the requirements of Commercial Item Description A-A-3097 (formerly MIL-A-46050C)

Pinch of power for hundreds of material

- EPDM to aluminum • wood to wood • ferrite magnet to metal
- silicone to ABS • nylon to aluminum • leather to wood • rubber to metal
- aluminum • urethane to painted metal • flexible vinyl to steel
- acrylic • latex tubing to metal • PVC to chrome • Kevlar® to metal
- coated paint • rubber to oily metal • rubber to zinc plate • nylon to metal
- composite to stainless steel • PVC to polyurethane foam • ABS to metal
- latex tubing to polyester • stainless steel to metal



Applications





really fast combinations

tal • polycarbonate to neoprene • ABS to
 rubber to fiberglass • nylon to ABS •
 • Lexan® to steel • EPDM to EPDM
 to neoprene • polyester to
 lon to stainless • carbon
 BS to PPS • to aluminum • ABS to polystyrene



success in any market

decorative trim • orthopaedic boot soles • wood edge molding repair • pool cues • motor
 assembly • gasketing • coil termination • power tool housing • handheld electronic devices •
 bonding • faucet assembly • kitchenware • medical devices • military equipment • hearing
 components • handle grips on compressors, exercise equipment, bicycles • automotive
 furniture • cosmetic cases • flexible tubing • door seals • battery cases • much more

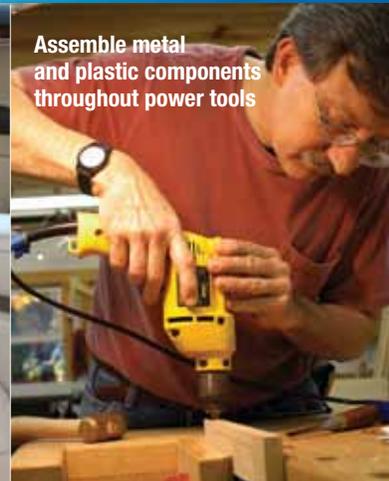
Assembly in a snap from tools to toys, workouts to play



Bond materials throughout a digital camera



Bond interior automotive trim and components: metal, plastic, leather, and rubber



Assemble metal and plastic components throughout power tools



Bond plastic to plastic



Bond plastic riser into lipstick casing

“Go To” Quick Selection Guide

		Plastics and Rubber	Surface Insensitive	General Purpose	Super Fast	Low Odor	Rubber Toughened	Flexible	High Temp.	Metal Bonder
Substrates	Wood, leather, fabric, or acidic surfaces		SI100							
	Metal to metal or plated surfaces									MC100
	EPDM, Viton®, Santoprene™, nylon, acetal	PR100								
	Dirty, oily or contaminated surfaces				SF100					
	Low surface energy (LSE) plastics	PR100 w/AC77								
	General bonding – Metal, plastics, and rubber			EC600						
	Treated metals to dissimilar substrates									MC100
	General purpose gap filling/vertical applications (all substrates)	PR GEL	SI GEL							
Operating Condition	Intermittent operating temp to 250°F (121°C)								HT700	
	Intermittent operating temp to 223°F (106°C) and constant thermal cycling						RT300B			
	Max. impact, flex, and peel strength						RT300B	FLX300		
Unique Properties	Bonding “up close” or in confined space					LO100				
	Eliminate blooming or cosmetic critical					LO100				
Process time	High speed automated dispensing				SF100					
	Fast cure and some impact, flex, peel							FLX300		
	Extra positioning time (slower curing)			EC600						

Self-contained applicator...pinch a drop or bead

- Flexible container to pinch a precise drop or squeeze a steady bead with the length and coverage you want
- Cut-to-size nozzle for targeted application



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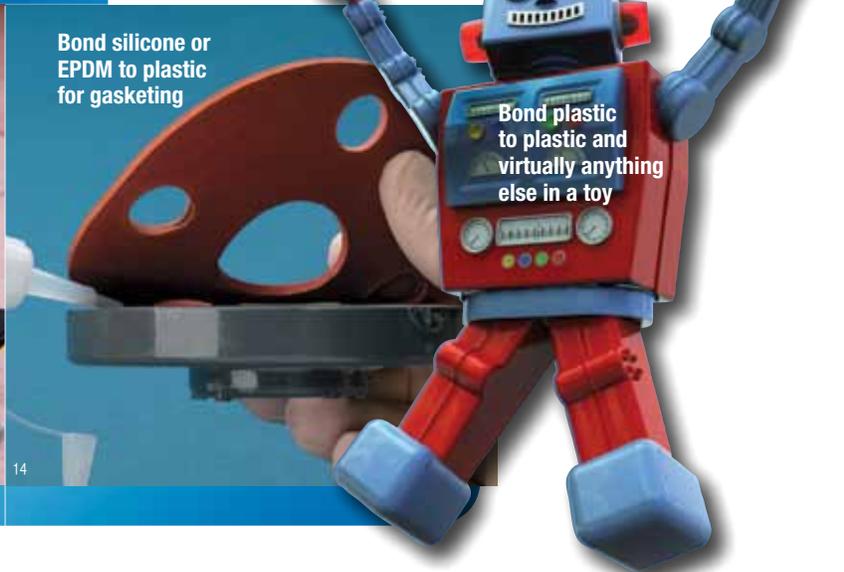
Assemble handle grips and electronic/electrical components in exercise equipment

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Bond soles to boots, bumpers to bottoms

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Bond silicone or EPDM to plastic for gasketing

Bond plastic to plastic and virtually anything else in a toy

Full Line Selection Guide

Product	Typical Use	Typical Viscosity (cps)	Temperature Range	Time to Handling	Full Cure (hours)	Markets	Size	UPC	Stock #
Plastic and Rubber Instant Adhesives									
PR5 (Clear)	Very low viscosity wicking grade for plastics/rubbers	5	-65° to 180°F (-54° to 82°C)	1-10 sec.	24	Automotive, appliance, electronics, hand tools, power tools	1 oz btl 1 lb btl	00-051115-25207-5 00-051115-25206-8	62-6149-0350-8 62-6149-3850-4
PR40 (Clear)	Low viscosity for close fitting plastic/rubber parts	40		3-20 sec.			1 oz btl 1 lb btl	00-051115-25204-4 00-051115-25205-1	62-6147-0350-2 62-6147-3850-8
PR100 (Clear)	General purpose, low viscosity plastic bonder	100		10-30 sec.			1 oz btl 1 lb btl 1 lb btl 2 kilo btl	00-051115-25214-3 00-051115-25939-5 00-051115-25213-6 00-051111-07176-2	62-6164-0350-7 62-6164-3825-5 62-6164-3850-3 62-6164-6850-0
PR600 (Clear)	Medium viscosity with some gap filling for plastics/rubbers	600		4-25 sec.			2 oz btl 1 lb btl 1 lb btl	00-051115-25241-9 00-051115-25936-4 00-051115-25240-2	62-6182-0852-4 62-6182-3825-7 62-6182-3850-5
PR1500 (Clear)	General purpose, high viscosity for gap filling	1500		20-100 sec.			1 oz btl 1 lb btl 1 lb btl 2 gram tube	00-051115-25222-8 00-051115-25937-1 00-051115-25221-1 00-051115-25202-0	62-6165-0350-4 62-6165-3825-2 62-6165-3850-0 62-6137-0250-5
PR Gel (Clear)	Fast cure, gel viscosity for max gap filling	Gel		30-60 sec.			20 gram tube 300 gram cart 850ml cart	00-051115-25265-5 00-051115-25282-2 00-051115-32154-2	62-6152-0352-8 62-6152-3300-4 62-6152-8550-9
PR600B (Black)	Black version of PR600	600		4-25 sec.			4 lb btl	00-048011-62622-2	62-6157-0354-3
Surface Insensitive Instant Adhesives									
SI5 (Clear)	Very low viscosity wicking grade	5	-65° to 180°F (-54° to 82°C)	15-35 sec.	24	Woodworking, luggage and fabric, hobby, costume jewelry, leather	1 oz btl 1 lb btl	00-048011-62635-2 00-048011-62726-7	62-6166-0350-2 62-6166-3850-8
SI40 (Clear)	Low viscosity for close fitting parts	40		2-20 sec.			1 oz btl 1 lb btl	00-051115-25231-0 00-051115-25230-3	62-6170-0350-4 62-6170-3850-0
SI100 (Clear)	Low viscosity for medium gaps	100		3-20 sec.			1 oz btl 1 oz btl 1 lb btl	00-051115-25268-6 00-051115-25290-7 00-051115-25267-9	62-6176-0350-1 62-6176-0353-5 62-6176-3850-7
SI1500 (Clear)	High viscosity for gap filling	1500		5-60 sec.			2 oz btl 1 lb	00-048011-61662-9 00-051115-25245-7	62-6178-0850-6 62-6178-3850-3
SI Gel (Clear)	Fast cure, gel viscosity for max gap filling	Gel		30-60 sec.			20 gram tube 300 gram cart	00-051115-25266-2 00-051115-25284-6	62-6163-0352-5 62-6163-3300-1

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

Product	Typical Use	Typical Viscosity (cps)	Temperature Range	Time to Handling	Full Cure (hours)	Markets	Size	UPC	Stock #
General Purpose Instant Adhesives									
EC40 (Clear)	General purpose, fast curing	40	-65° to 180°F (-54° to 82°C)	10-30 sec.	24	Automotive, general bonding, consumer products, toys, rubber/plastic assembly	1 oz btl 1 lb btl	00-048011-62645-1 00-048011-62646-8	62-6190-0350-2 62-6190-3850-8
EC100 (Clear)	General purpose, fast curing	100		10-40 sec.			1 oz btl 1 lb btl	00-048011-62638-3 00-048011-62640-6	62-6188-0350-6 62-6188-3850-2
EC600 (Clear)	Higher viscosity to reduce migration from bond area	600		5-60 sec.			1 oz btl 1 lb btl	00-048011-62641-3 00-048011-62637-6	62-6187-0350-8 62-6187-3850-4
EC2500 (Clear)	Slow cure for porous material or gap filling	2500		20-60 sec.			1 oz btl 1 lb btl	00-048011-62642-0 00-048011-62636-9	62-6186-0350-0 62-6186-3850-6
ECl Gel (Clear)	Industrial strength thixotropic gel for maximum gap fill	Gel		45-180 sec.			300 gram cart	00-048011-62659-8	62-6196-3300-1
Super Fast Instant Adhesives									
SF20 (Clear)	Optimum performance on wide range of rubber and plastic	20	-65° to 180°F (-54° to 82°C)	3-30 sec.	24	Automotive, appliance, leather working, hand tools, electronics, power tools	1 oz btl 1 lb btl	00-051111-91667-4 00-051115-25790-2	62-6151-0359-5 62-6151-3852-6
SF100 (Clear)	Fast cure, high strength with EPDM and other elastomers	100		3-30 sec.			20 gram btl 3 gram tube 1 lb btl	00-048011-62631-4 00-048011-62630-7 00-048011-62629-1	62-6174-0352-2 62-6174-0353-0 62-6174-3850-2
Low Odor Instant Adhesives									
L05 (Clear)	Very low viscosity wicking grade	5	-65° to 160°F (-54° to 71°C)	5-60 sec.	24	Cosmetic cases, appearance-critical applications, black substrates, close-up bonding	1 oz btl 1 lb btl	00-051111-92801-1 00-051111-92808-0	62-6129-0357-5 62-6129-3859-7
L0100 (Clear)	Low viscosity for close fitting parts	100		10-60 sec.			1 oz btl 1 lb btl	00-051111-92800-4 00-051111-92807-3	62-6128-0357-7 62-6128-3859-9
L01000 (Clear)	High viscosity for gap filling	1000		20-70 sec.			1 oz btl 1 lb btl	00-051111-92799-1 00-051111-92806-6	62-6132-0357-9 62-6132-3859-1
Rubber-Toughened Instant Adhesives									
RT300B (Black)	Low viscosity for close fitting parts	300	Continuous -65° to 200°F (-54° to 93°C) Intermittent -65° to 250°F (-54° to 121°C)	20-50 sec.	24	Automotive, appliance, electric motors, hand tools, electronics, power tools	1 oz btl 1 lb btl	00-051115-25212-9 00-051115-25211-2	62-6158-0350-9 62-6158-3850-5
RT3500B (Black)	High viscosity for gap filling	3500		20-90 sec.			1 oz btl 1 lb btl	00-051111-91665-0 00-051115-25200-6	62-6135-0359-8 62-6135-3850-3
Flexible Instant Adhesives									
FLX300 (Clear)	Medium viscosity with some gap filling	300	-65° to 160°F (-54° to 71°C)	10-35 sec.	24	Automotive, appliance, hand tools, electronics, power tools	20 gram btl	00-051115-25239-6	62-6159-0350-7
High Temperature Instant Adhesives									
HT40 (Clear)	Low viscosity for close fitting parts	40	Continuous -65° to 223°F (-54° to 106°C) Intermittent -65° to 250°F (-54° to 121°C)	5-20 sec.	24	Appliance, electronics, electric motors, automotive, transformers	1 oz btl 1 lb btl	00-048011-62730-4 00-051115-25186-3	62-6126-0350-6 62-6126-3850-2
HT700 (Clear)	Medium viscosity with some gap filling	700		15-40 sec.			1 oz btl 1 lb btl	00-051111-91662-9 00-051115-25187-0	62-6127-0359-5 62-6127-3850-0
Metal Instant Adhesives									
MC5 (Clear)	Low viscosity to penetrate between parts	5	-65° to 180°F (-54° to 82°C)	15-35 sec.	24	Costume jewelry, treated metals, plated metals, metal working	1 oz btl 1 lb btl	00-048011-62736-6 00-051115-25229-7	62-6169-0350-6 62-6169-3850-2
MC100 (Clear)	Multi-purpose metal bonder	100		5-20 sec.			1 oz btl 1 lb btl	00-051111-91663-6 00-048011-62634-5	62-6130-0359-9 62-6130-3850-4

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Product	Description	Time ⁽¹⁾ To Handling Strength (Sec.)	Viscosity (cps)	Overlap Shear Strength ⁽²⁾ @ 75° F (24°C) (PSI)						Size	UPC	Stock #
				Steel	Alumi- num	Nitrile Rubber	Neoprene Rubber	ABS	Rigid PVC			
Engineered Grade Instant Adhesives												
CA4	Fast setting for a variety of plastics and rubbers	5-40	150	2300	2800	35*	55*	800*	800*	2 gram tube 1 oz btl 1 lb btl	00-021200-96601-9 00-021200-96600-2 00-021200-96957-5	62-3801-0230-1 62-3801-0330-9 62-3801-3830-5
CA5	Higher viscosity, slower setting version of CA4 for filling gaps; meets CID A-A-3097, Type II, Class 3	12-60	2000	2500	600	35*	55*	800*	800*	1 oz btl 1 lb btl	00-021200-74289-7 00-021200-74288-0	62-3802-0330-7 62-3802-3830-3
CA7	Very fast setting; excellent adhesion to metals, plastics, and rubbers	1-30	15-40	2500	2400	35*	55*	900*	1000*	1 oz btl 1 lb btl	00-021200-21061-7 00-021200-21062-4	62-3812-0330-6 62-3812-3830-2
CA8	Slower setting than CA7; excellent adhesion to metals, plastics and rubbers; meets CID A-A-3097, Type II, Class 2	5-40	70-130	2000	2100	35*	55*	900*	1000*	2 gram tube 1 oz btl 1 lb btl	00-021200-21065-5 00-021200-21066-2 00-021200-21067-9	62-3815-0130-3 62-3815-0330-9 62-3815-3830-5
CA9	Slower setting version of CA8 for wire tacking and coil terminating; meets CID A-A-3097, Type II, Class 3	20-70	1000-1700	2000	2400	35*	55*	900*	1000*	1 oz btl 1 lb btl	00-021200-21068-6 00-021200-21069-3	62-3817-0330-5 62-3817-3830-1
CA40	Very fast setting; excellent adhesion to many substrates including flexible vinyl and EPDM rubber	3-20	20	1700	2600	35*	55*	800*	800*	1 oz btl 1 lb btl	00-021200-74290-3 00-021200-74291-0	62-3803-0330-5 62-3803-3830-1
CA40H	Higher viscosity version of CA40; better void filling capabilities	5-40	400-600	1500	1500	35*	55*	900*	1000*	1 oz btl 1 lb btl	00-021200-21073-0 00-021200-21074-7	62-3829-0330-0 62-3829-3830-6
CA50 Gel	High-viscosity, non-sag gel; less sensitive to acidic surfaces	60-120	45,000-85,000	2000	900	105*	130*	800*	600*	20 gram tube 200 gr tube	00-021200-82332-9 00-021200-83737-1	62-3872-0330-0 62-3872-3630-0
CA100	High peel and impact strength; high thermal shock and heat resistance	20-70	2500-4500	2000	2900	95*	120*	600*	700*	1 oz btl 1 lb btl	00-021200-82334-3 00-021200-82335-0	62-3873-0330-8 62-3873-3830-4
Instant Adhesive Primers, Activators, and Debonders												
AC09	Instant adhesive activator, non-flammable solvent-based, California Compliant.									2.0 fl oz 1 ltr	00-051111-07795-5 00-051111-07908-9	62-6198-0850-4 62-6198-8350-7
AC12	Instant adhesive accelerator with isopropyl alcohol formulation for insensitive plastics, cosmetically critical bond lines, and medical applications.									2 fl oz btl 1 Gal 55 Gal drum	00-048011-62727-4 00-051111-18690-9 00-048011-62680-2	62-6193-0850-5 62-6193-7550-4 62-6193-9550-2
AC68	Instant adhesive debonder for cleanup.									1 Gal 2 fl oz btl	00-048011-62693-2 00-048011-62692-5	62-3910-7550-4 62-3910-0850-5
AC77	Instant adhesive polyolefin primer for very fast bonding of difficult-to-bond polyethylene and polypropylene.									2 fl oz btl 1 Gal 55 Gal	00-048011-62728-1 00-048011-62653-6 00-048011-62654-3	62-3907-0850-1 62-3907-7550-0 62-3907-9550-8
AC78	Instant adhesive promoter for use with silicone, Santoprene™, Viton® and EPDM.									2 fl oz 8 fl oz 1 Gal	00-051115-31385-1 00-051115-31386-8 00-051115-31387-5	62-3912-0850-1 62-3912-3750-0 62-3912-7550-0
AC79	California compliant version of AC78 (acetone based).									2 fl oz 8 fl oz 1 Gal	00-051115-31388-2 00-051115-31389-9 00-051115-31390-5	62-3916-0850-2 62-3916-3750-1 62-3916-7550-1
AC113	Instant adhesive general purpose accelerator will not attack plastics.									2 fl oz btl 8 fl oz btl Qt can 1 Gal	00-048011-62681-9 00-048011-62682-6 00-048011-62683-3 00-048011-62684-0	62-6194-0850-3 62-6194-3750-2 62-6194-6550-3 62-6194-7550-2
AC452	Instant adhesive acetone-based accelerator flashes off rapidly; excellent adhesion; overspray may attack some plastics.									2 fl oz btl 8 fl oz btl 12 oz aerosol 1 Gal	00-048011-62685-7 00-048011-62686-4 00-048011-62687-1 00-048011-62689-5	62-6195-0850-0 62-6195-3750-9 62-6195-4450-5 62-6195-7550-9
Surface Activator	Clear, colorless organic-based liquid helps speed curing and prime surfaces; comes with brush and spray pump									2 oz btl 1 Gal	00-021200-87937-1 00-021200-87963-0	62-3804-0830-2 62-3804-7530-1

(1) The time it takes assembled parts to reach a strength where further handling and processing can take place. Times will depend on surface to be bonded, temperature and humidity.

(2) Tested per ASTM D 1002-64. *Substrate failure.

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3M Solutions Seminars are available without cost to engineers and managers working in the real world of competition and profitability.

The various topics and tools integrate 3M technologies and innovative thinking into practical and specific knowledge. The objective is to help you improve product, performance and process, especially if such trends as the following have complicated your life:

- Economy and competition increasing the pressure to improve productivity and reduce cost
- Steadily growing demand for use of lighter weight materials and less expensive LSE plastics
- The “Greening” of product life cycles expanding as a priority for manufacturers and suppliers
- Cyber-knowledge creating more knowledgeable and discerning end users and distribution channels
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