



Scotch-Weld™

Universal Contact Adhesive 10

Product Data Sheet

Updated: September 2006
Supersedes: March 2001

Product Description

Scotch-Weld Contact Adhesive 10 is a liquid, air-drying adhesive, which bonds immediately and permanently upon application of contact pressure.

There is no need for clamping or fixing.

Physical Properties

Not for specification purposes

Solvent	Aliphatic Petroleum Distillates Acetone, Toluene.	
Flash Point	-28°C	
Consistency	Thin Syrup	
Solids Content	21-23% (by weight)	
Base	Neoprene	
Viscosity	Approx 600 cPs	
Net Weight	6.9+/- 0.2 lbs/gal	
Brookfield Viscometer	RVF# 2sp @ 20rpm	
Colour	Yellow	
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

Performance Characteristics

Not for specification purposes

Service Temperature Range	-30°C - +100°C	
Serviceability	Scotch-Weld Contact Adhesive 10 is non-staining, water resistant and withstands oxidation, oils, greases and most chemicals.	
Water Resistance	The cement film formed by Scotch-Weld Contact Adhesive 10 is resistant to water. However, wood and some other porous materials will swell in water and the hydraulic effect of the swelling will weaken the bond between the wood and the adhesive. Swelling to a degree which will weaken the bond cannot be caused by high humidity or other exposure to moisture - only by extensive immersion in water.	

Storage Conditions

Best storage temperature is 16-27°C. Continuous exposure to higher temperatures may cause some increase in viscosity. Quality is not affected until the cement becomes thickened so that it is difficult or impossible to spread.

Scotch-Weld Contact Adhesive 10 will not freeze. Continuous exposure to low temperatures will cause a considerable increase in viscosity. After storage at low temperatures and before using, the cement must be thawed out and stirred vigorously until the entire container regains its original viscosity. The thawing out process should be done at approximately room temperature, never at elevated temperatures. Several days may be required for thawing out - particularly on the larger containers.

Application Characteristics**Method:**

Brush (fibre or animal hair, do not use nylon or other synthetic fibres). Paint Roller or Notched Scraper.

Coverage:

3.7 to 5.1 m²/litre.

Bonding Range:

45-60 minutes at 50% max RH and 24°C.

Bonding Pressure:

Use heavy body pressure on a small (3" wide max) hand roller.

Directions for Use**Surface Preparation:**

For best results, all surfaces to be bonded should be smooth and dry. As your bond will be no better than the surface to which it adheres, dirt, dust, oil, loose paint, wax, grease, etc should be removed. Aluminium, steel and copper should always be wiped with solvent before the adhesive is applied. Solvent wipe the surface with a clean cloth or tissue until there is no further transfer of dirt or smut.

Application:

Stir well before using. Working temperature: the adhesive and both surfaces should be 18°C or above at the time of bonding. Apply Scotch-Weld Contact Adhesive 10 to both surfaces. Apply with a fibre or animal hairbrush, or pour it and spread with a scraper. Two coats on porous surfaces are recommended. Only one generous coat on non-porous surfaces is required. Cement must be completely dry between coats. Aluminium, steel, hardwoods, tempered hardboard and decorative laminates are non-porous. Soft woods, un-tempered hardboard, plywood and plaster are typical of the porous surfaces which require two brush coats. Some extremely porous surfaces, including many fibrous materials and masonry surfaces may require even more than two coats. The test for enough adhesive is a yellow shiny film when completely dry. Dull spots after drying indicate not enough adhesive; these spots must have another coat.

Let It Dry Completely

Under normal temperature and humidity conditions (24°C and max 50% RH) Scotch-Weld Contact Adhesive 10 will dry in 10 minutes. You have up to one hour after the adhesive is dry in which to complete the bonding job. You can bond as soon as it is dry, but the longer you wait the stronger the initial bond will be.

The test for dryness is to press a small piece of heavy kraft paper lightly against the dried adhesive. If no adhesive sticks to the paper, it is dry. If your two surfaces do not grab each other immediately when brought into contact, the adhesive has dried too long, you did not use enough or the relative humidity was above 50% causing a film of moisture to form on the adhesive surface.

Apply pressure Thoroughly

Bonding is immediate upon contact. Sustained pressure is not required but pressure must be applied to every square inch of the surface. Apply pressure by using heavy body pressure on a small (not over 3") hand roller. Rolling pins and other wide rollers are not as good because they bridge low spots and distribute the pressure over too large an area.

Assembling

Position the surfaces carefully before assembly.

No adjustment is possible after the adhesive films make contact. Use the paper slip-sheet method (or spacers) to position large pieces.

Finishing

Bonded assemblies can be machined or trimmed and finished immediately after bonding.

Cleaning

Use Scotch-Weld Solvent No. 1** for cleaning brushes immediately after use and for removing excess adhesive from finished jobs. **CAUTION:** Never pour solvent onto a bonded surface: it will attack the adhesive line and weaken the bond. Just wipe a cloth dampened in solvent.

**Directions for Use
Cont'd ...****Removing Bonded Material**

Squirt Scotch-Weld Solvent No. 1** from a clean oil can directly into the cement line. This will permit surfaces to separate slightly. Continue flooding the cement line while pulling gently on the surfaces until they are completely separated. Pulling too hard, or too fast, may break the material. Let the solvent do the work for you.

** **NOTE:** Scotch-Weld Solvent No. 1 is highly flammable. When using solvent for clean up, it is essential that proper safety precautions are observed.

**Additional Product
Information**

Effectively used for bonding decorative laminates, aluminium, steel, wallboard, plywood, particle board, wood veneer, masonry, wood, rubber, leather, canvas and other porous and non-porous material to each other or to themselves. Offers exceptionally high bond strength, superior resistance to heat and sunlight and excellent specific adhesion. Complies with D.C.I. Spec. AFS. 725A.

**Health and Safety
Information****Precautions:**

Highly flammable. Vapour may be harmful. May cause eye and skin irritation. Keep away from heat. Keep away from sources of ignition - No Smoking. Keep container tightly closed and in a well ventilated place. In case of insufficient ventilation, wear suitable respiratory equipment. Take precautionary measures against static discharges. Do not breathe vapours/ spray. Use only in well ventilated areas. Avoid contact with skin and eyes.

First Aid:**Eye Contact:**

Wash immediately with plenty of water and seek medical advice.

Skin Contact:

Wash with soap and water.

Ingestion:

Do not induce vomiting. Call a physician immediately.

For further health and safety information, please contact the Toxicology Department on Bracknell (01344) 858000.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.

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