



# Scotch-Weld™

## Nitrile Rubber & Plastic Adhesive

826

Technical Data

December, 2007

### Features

- A light colored, fast drying adhesive.
- Excellent resistance to aromatic fuels, water and oil.
- Used to bond many types of plastic films including ABS, cellulose acetate, and PVC.

### 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>	750 - 1250 cps.
<b>Brookfield Viscometer:</b>	RVF #2 sp @ 20 rpm @ 80°F (27°C)
<b>Solids (by wt.):</b>	21 - 25%
<b>Base:</b>	Nitrile
<b>Color:</b>	Light Amber
<b>Net Weight (approx.):</b>	7.5 - 8.0 lbs./gal.
<b>Flash Point:</b>	35°F (2°C) (Setaflash)
<b>Solvent:</b>	Ethyl Acetate, Ethyl Alcohol

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## Handling/Application Information

### Directions for Use:

1. **Surface Preparation:** Surfaces must be clean, dry and dust free. Wiping thoroughly with methyl ethyl ketone (MEK)\* will aid in removing oil and dirt.\*
2. **Application Temperature:** For best results, the temperature of the adhesive and surfaces should be at least 65°F (18°C).
3. **Application:** Stir well before using.  
**Porous Surface(s):** Brush, flow or spray a thin, even coat of adhesive to one or both surfaces. Coating both surfaces is preferred since it gives greater strength and permits longer open time before bonding. Very absorbent materials may require more than one coat. Bond while adhesive is still wet or aggressively tacky. Join surfaces with firm pressure.  
**Non-Porous Surface(s):** Brush, flow or spray a thin, even coat of adhesive to both surfaces. Allow adhesive to dry until tacky. Join surfaces with firm pressure.
4. **Drying Time:** Drying time depends on temperature, humidity, air movement, and porosity of the materials bonded. Typically, drying times of 5 to 10 minutes can be expected.
5. **Cleanup:** Excess adhesive may be removed with methyl ethyl ketone (MEK)\* or acetone,\* preferably while still wet.

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

## 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 2:1 ratio, divorced design pump is suggested. All material hoses should be nylon lined. Packings and glands in contact with the adhesive should be Teflon®.
2. **Spray:**

Spray Gun	Air Cap	Fluid Tip	Air Pressure	Approximate Air Requirement <sup>1</sup>	Fluid Flow <sup>2</sup>
DeVilbiss, JGA	704	E	60 psi	14½ CFM	4 fl. oz./min.
Binks No. 62, 95 or 2001	66PE	66	60 psi	16½ CFM	4 fl. oz./min.

**Note:** This adhesive is not recommended for airless spraying.

<sup>1</sup>2-3 H.P. Compressor for intermittent use.  
<sup>2</sup>4 H.P. Compressor for continuous use.

<sup>2</sup>To Measure Fluid Flow: Pressurize fluid source only; pull trigger, flow material into measuring device for 60 seconds, increase or decrease fluid source pressure to obtain desired fluid flow.

3. **Brush:** Typical brushes designed for oil based paint may be used.

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**Typical Adhesive  
 Performance  
 Characteristics**

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180° Peel Strength Canvas/Steel			Overlap Shear Strength Alum./Alum.*		T-Peel Strength Canvas/Canvas aged 2 days @ 120°F (49°C) plus:	
Time @75°F (24°C)	Test Temp	Value (lbs./in. width)	Test Temp	Value (lbs./sq. in.)	Aging	Value (piw)
1 day	75°F (24°C)	10	-67°F (-55°C)	1395	1) 24 hrs./120°F (49°C) VMP	16
3 days	75°F (24°C)	17	-30°F (-34°C)	1811	2) 24 hrs./120°F (49°C) Jet Fuel	9
5 days	75°F (24°C)	18.5	75°F (24°C)	198	3) 24 hrs./160°F (71°C) Oil	21
7 days	75°F (24°C)	21	150°F (66°C)	88	4) 1 wk./Freon #11	13
2 weeks	75°F (24°C)	23	180°F (82°C)	59	2 wk./Freon #11	12
3 weeks	75°F (24°C)	27	200°F (93°C)	55	5) 1 wk./Freon #12	15
After 3 weeks	-30°F (-34°C)	17.5	250°F (121°C)	25	2 wk./Freon #12	15
After 3 weeks	150°F (66°C)	5	*Test specimens heat cured for 15 min. @ 325°F (163°C), 150 psi.			
After 3 weeks	180°F (82°C)	4				

**Storage**

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.

**Shelf Life**

When stored in the original unopened container, 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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## Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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**ISO 9001:2000**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



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