



Scotch-Weld™

TE-031 Thermoset Adhesive

Product Data Sheet

Updated: June 2005
Supersedes: December 1993

Product Description

Extrudable grade with fast set time ideal for bonding a wide variety of plastics including polystyrene and polyacrylic.

Scotch-Weld Thermoset Adhesives are a family of one-component, moisture curing, urethane adhesives. These adhesives are applied warm and bond a wide variety of substrates such as wood, fibre reinforced plastic (FRP) and many other plastics to themselves, to metal and glass.

Features:

100% solids.
Rapid rate of strength build-up.
Broad substrate adhesion.
Highly plasticiser resistant.
High strength bonds.
One component.
Various set times.
Can be used to bond heat sensitive materials.

Physical Properties (Uncured)

Not for specification purposes

Application Temperature	250 °F 121°C	
Viscosity (at 250°F - 121°C)	13,000 cps (mPa.s)	
Colour (solid)	White/Off-White	
Open Time ²	2 minutes	
Set Time ³	30 seconds	
Density molten g/ml	1.04	
Shelf Life	6 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

¹ Measured on Brookfield viscometer with Thermoset using spindle no. 27.

² The bonding range of a 3.2mm/1/8" bead of molten adhesive on a non-metallic substrate.

³ The minimum amount of time required between when the bond is made and when it will support a 5 psi / 35 kPa tensile load.

Physical Properties (Cured)

Not for specification purposes

Shore D Hardness ¹	50	
Modulus ²	38.6 MPa	
100% Modulus ²	7.6 MPa	
Tensile Strength at Break ²	26.9 MPa	
Elongation at Break ²	725 %	

¹ Measured on .090" - .110" thick bars (2.3 - 2.8mm)

² ASTM D 638, Die C, measured on .011" - .017" (280-430µm) thick films cured 7 days at 77°F (25°C)/50% Relative Humidity.

Performance Characteristics Not for specification purposes	Overlap Shear Strength (MPa)	Tested at 73°F (23°C)	
	Substrate		
	Maple	10.6	
	FRP	13.0	
	Polycarbonate	14.5	
	Polyacrylic	9.2	
	Polystyrene	4.9 ¹	
	ABS	9.3 ¹	
	PVC	11.5 ¹	
	¹ Substrate Failure		

Performance Characteristics Cont'd.. Not for specification purposes	Overlap Shear Strength (MPa)	tested at 180°F (82°C)	
	Substrate		
	Maple	2.3	
	FRP	5.5	

	180° Peel Strength (N/cm)	Tested at 73°F (23°C)	
	Substrate		
	FRP	168 ¹	
	Polycarbonate	166 ¹	
	Polyacrylic	135 ¹	
	Polystyrene	114 ¹	
	ABS	147 ¹	
	PVC	175 ¹	
	Aluminium	53 ²	
	Glass	5	
	¹ Cotton duck failed during test.		
	² Scotch-Weld Adhesive not suggested for use on uncoated aluminium		

	Plasticised Vinyl, T-Peel (N/cm) Condition	Tested at 73°F (23°C)	
	Initial	28 ¹	
	Aged at 160°F (71°C) for 2 weeks	39 ¹	
	¹ Substrate Failure		

Environmental Resistance	FRP, Overlap Shear Strength (MPa)	Tested at 73°F (23°C)	
	Condition		
	15 days at 25°C/50% RH	13.0	
	Thermal Cycle ¹	13.4	
	¹ Thermal cycle = 10 cycles of 16 hours at 100°F (38°C) / 100% RH. 4 hours at -20°F (-29°C) with bonds aged for 24 hours at 77°F (25°C) /50% RH prior to testing.		

Typical Rate of Strength Build Up	FRP, Overlap Shear Strength (MPa)	Tested at 73°F (23°C) at various times after bonding.	The FRP was conditioned for 7 days at 77°F (25°C) / 50% RH prior to bonding.
	Time		
	10 minutes	2.3	
	1 hour	4.2	
	24 hours	13.2	
	1 week	13.0	
Typical Rate of Strength Build Up – Cont'd..	The cure rate will vary depending on air temperature, relative humidity, substrate and bond line thickness. Cure rate is more rapid on wood (moisture-rich substrate) than on plastic.		

Test Procedures**Overlap Shear Strength**

Overlap shear (OLS) strengths were measured on 25.4mm wide 12.7mm overlap specimens. These bonds were made individually using 25.4 x 101.6 mm sample coupons. The thickness of the bond line was 75-150 μm (micrometer). The thickness of the substrates were : Plastics 3.2mm, Maple 9.5mm.

All strengths were measured at 23°C except where noted. The separation rate was 50.8mm/minute.

180° Peel Strength

180° peel strengths were measured on 25.4 x 203.2mm pieces of flexible cotton duck (canvas) bonded to rigid 25.4 x 101.6mm substrates. The rigid substrates were approximately 3.2mm thick and the separation rate of the testing jaws was 50.8mm per minute. All strengths were measured at 73°F (23°C).

T-peel Strength

T-peel strengths were measured on 25.4mm wide pieces of plasticised vinyl at 73°F (23°C). The separation rate of the testing jaws was 50.8mm per minute.

Cure Cycle

With the exception of rate of strength build up, all bonds, unless otherwise noted, were cured for a minimum period of 7 days at 77°F (25°C)/50% RH before testing or subjecting to further conditioning or environmental ageing. Bonds were prepared using the suggested procedure for the particular substrate tested.

Directions for Use

Apply to clean, dry surfaces. Remove oil, grease and other contaminants by wiping with isopropyl alcohol. For fibre reinforced plastics and other materials that are often contaminated with mold release agents. It is recommended that the surface be solvent wiped, abraded and solvent wiped.

After heating to recommended application temperature, apply adequate amount of Scotch-Weld Thermoset Adhesive to one of the substrates to be bonded. Join the substrates within the adhesives specified open time and hold/fixture the bonded part until the adhesive has adequately set. Do not use to bond metal or glass to itself or each other or cure will not occur due to low moisture vapour transmission of the substrate.

Important: Adhesive heated at application temperature for more than 16 hours should be discarded.

Note: When using solvents, extinguish all ignition sources and observe manufacturers' directions and precautions for handling such materials.

Dispensing Equipment

Scotch-Weld Adhesive Cartridges can only be dispensed through the 3M Scotch-Weld Adhesive Applicator. Other container sizes can be dispensed through bulk equipment specifically designed for use with hot melt polyurethane reactive adhesives (PUR). For more information on PUR application equipment, contact your local 3M sales representative. All equipment must be used in strict accordance with the recommendations of the manufacturer.

WARNING: Do not use Scotch-Weld Adhesive above 275°F (135°C). Scotch-Weld Adhesive should not be applied to substrates that exceed 275°F (135°C).

Caution: Wear heat resistant gloves and safety glasses when handling.

Container sizes available: 10 fl. oz cartridge, five gallon pail, 55 gallon drum.

Clean Up:

Allow product to solidify. Remove uncured waxy material (usually within the first 20 minutes after application) by scraping with a putty knife or similar tool. For cured material, remove by cutting or sanding. **Do not use heat or flame to remove adhesive.**

Surface Preparation**Plastic:**

Wipe with isopropanol soaked cheesecloth. Allow solvent to evaporate before bonding.

Note: Scotch Weld Adhesives are not recommended for bonding untreated polyolefins.

Plastic contaminated with mold release:

Wipe with isopropyl soaked cheesecloth, abrade with fine grit abrasive, wipe with isopropyl alcohol soaked cheesecloth. Allow solvent to evaporate before bonding.

FRP, Rubber and Aluminium (uncoated):

Wipe with methyl ethyl ketone (MEK) soaked cheesecloth, abrade with fine grit abrasive, wipe with MEK soaked cheesecloth. Allow solvent to evaporate before bonding.

Priming may be necessary on aluminium if part will be subjected to hot or humid conditions.

Glass:

Wipe with MEK soaked cheesecloth. Allow solvent to evaporate before bonding. Priming may be necessary on glass if part will be subjected to hot or humid conditions.

Note:

When using solvents, extinguish all ignition sources and observe manufacturers directions and precautions for handling such materials.

Storage Conditions

For maximum shelf life store product at 60°F (16°C) to 80°F (27°C), indoors and protect from exposure to moisture.

Products have a 6 month shelf life in unopened containers.

Health and Safety Information

Refer to the Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

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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.



Industrial Adhesives & Tapes Division

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3M United Kingdom PLC
3M House,
28 Great Jackson Street,
Manchester,
M15 4PA

Product Information :
Tel 0870 60 800 50
Fax 0870 60 700 99

3M Ireland
3M House, Adelphi Centre,
Upper Georges Street,
Dun Laoghaire, Co. Dublin,
Ireland

Customer Service :
Tel (01) 280 3555
Fax (01) 280 3509