



Scotch-Weld™

1300L Contact Rubber Adhesive

Product Data Sheet

Updated : October 2006
Supersedes : March 1996

Product Description

A fast drying adhesive that develops strength quickly. Has excellent heat resistance; temperature performance range is from (-5°F to 300°F) -21°C to 149°C.

Physical Properties

Not for specification purposes

Solvent	Methyl Ethyl Ketone & Petroleum Distillate.	
Flash Point	-18°C	
Consistency	Thin Syrup	
Solids Content	29% (typical)	
Specific Gravity	0.84	
Colour	Yellow/Amber	
Shelf Life	15 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	-21°C to 149°C (-5°F to 300°F)	
Water Resistance	Excellent	
Weathering Resistance	Excellent	
Fuel & Oil Resistance	Fair	

Strength of Adhesive 180° Peel Strength	Time @ 24°C (75°F)	Test Temp		Approx. Value LBS/IN. Width
		°C	°F	
	1 day	24	75	30
	3 days	24	75	33
	5 days	24	75	33
	7 days	24	75	26
	2 weeks	24	75	25
	3 weeks	24	75	23
	after 3 weeks	-34	-30	16.5
	after 3 weeks	66	150	26
	after 3 weeks	82	180	22.5

Date : October 2006
1300L Contact Rubber Adhesive

Storage Conditions Store product at 16°C - 27°C (60°F - 80°F) for maximum storage life. Lower temperatures cause increased viscosity of a temporary nature. Higher temperatures reduce normal storage life.

Rotate stock on a "first in - first out" basis.

Application Characteristics

This adhesive is not recommended for Airless Spraying.

* 3HP Compressor for intermittent use.

5HP Compressor for continuous use.

** To measure Fluid Flow, pressurised fluid source only, pull trigger, flow material into measuring device for 60 seconds; increase or decrease fluid source pressure to obtain desired fluid flow.

All material hoses should be nylon or PVA lined. Packings and glands in contact with the adhesive should be made of Teflon.

Spray gun	Air cap	Fluid Tip	Air Pressure	Approx. Air Requirement*	Fluid flow**
DeVilbiss JGA, MBC, or AGB	704	FX	70 psi	17 CFM	8.5 L/h
Binks No. 62, 18 or 61	63PH	63B	70 psi	21 CFM	11 L/h

Directions for Use

Surface Preparation

Surfaces must be clean, dry and free from oil and grease.

Application

Spray or brush. Stir well before use. Apply to both surfaces, allow to become aggressively tacky for about four minutes, make bond under uniform pressure.

Coverage

(1 mil dry film) 300 sq. ft/gal
(6.2 m²/litre).

Approximate Drying or Setting Time

(10 mil wet film, 2 surfaces) Up to 8 minutes.

Application Temperature Range

16°C - 27°C (61°F - 80°F)

Clean Up

Excess adhesive may be removed with methyl ethyl ketone, Toluene or SCOTCH-GRIP Solvent No. 2.

Note:

All of these solvents are highly flammable. It is essential that proper safety precautions are observed.

Additional Product Information

AFS 1387A. This product is also available in a version meeting MIL-A-1154-C and MIL-A-5092-B-Type II. Please contact your 3M representative for details.

CAUTION

Highly flammable petroleum mixture. Use only in well ventilated areas. Avoid prolonged or repeated skin contact. Keep away from

heat and sources of ignition during storage and use.

Date : October 2006
1300L Contact Rubber Adhesive

Health and Safety Information

Precautions

Highly flammable. Vapour may be harmful. May cause eye irritation. Keep away from heat. Keep away from sources of ignition - No Smoking. Keep container tightly closed and in a well ventilated place. Take precautionary measures against static discharges. Avoid breathing vapours, eye contact and prolonged skin contact. Only use in well ventilated areas.

First Aid

Eye Contact:

Rinse 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 information please contact the Toxicology Department at the Bracknell Head Office on 0344 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.



Industrial Adhesives & Tapes Division

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