

3M

Scotch-Weld™

Plastic Adhesive

2262

Technical Data

December, 2007

Features

- 3M™ Scotch-Weld™ Plastic Adhesive 2262 is a high strength adhesive with exceptional resistance to plasticizer migration and bonds vinyl extrusions, flexible and rigid vinyls.
- Scotch-Weld Plastic Adhesive 2262 dries clear, is non-staining and features a very quick tacking, relatively short bonding range.

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.

Viscosity (approx.):	375 - 675 cps
Brookfield Viscometer:	RVF #2 Sp. @ 20 rpm @ 80°F (27°C)
Solids (by wt.):	25 - 28%
Base:	Synthetic Resin
Color:	Clear
Net weight (approx.):	7.1 - 7.5 lbs./gal.
Flash point:	0°F (-18°C)
Solvent:	Acetone, THF

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Handling/Application Information

Directions for Use:

1. **Surface Preparation:** Surfaces must be clean, dry and dust free. Wiping with a solvent such as methyl ethyl ketone (MEK)* will aid in removing oil and dirt.
2. **Application Temperature:** For best results, the temperature of the adhesive and the surfaces being bonded should be at least 65°F (18°C).
3. **Application:** Brush a uniform coat of adhesive on both surfaces.
4. **Drying Time:** Allow adhesive to dry until tacky but does not transfer to knuckle when touched (typically about 5 minutes depending on temperature, humidity, etc).
5. **Bonding:** When the adhesive dries to the tacky stage, you have up to 20 minutes to complete the bond. Combine the surfaces using firm pressure to ensure good contact.
6. **Cleanup:** Excess adhesive may be removed with a solvent such as methyl ethyl ketone (MEK),* preferably while the adhesive is still wet.

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

Application Equipment Suggestions

Note: 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. **5 gallon pail dispensing system:** Use a 2:1 ratio divorced design, double acting ball check type pump, 3 oz. per cycle, 2 inch air motor, syphon feed.
 - B. **55 gallon dispensing system:** Use a 2:1 ratio divorced design double acting ball check type pump, 3 oz. per cycle, 2 inch air motor, bung mounted.
Glands and packings in contact with adhesive should be Teflon.®
2. **Hoses:** Fluid hoses should be 200 psi working pressure minimum, nylon lined.
3. **Brushes:** Brushes designed to be used with oil based paints may be used.

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Typical Adhesive Performance Characteristics

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Peel Strength and Adhesion

3M™ Scotch-Weld™ Plastic Adhesive 2262 was used to bond unsupported vinyl (a clad grade containing approximately 30 phr DOP*) and supported vinyl to various substrates. Bonds were made by brush coating both surfaces; when the vinyl coated surface was slightly tacky (approximately 3-5 minutes), both surfaces were mated together and rolled to insure good contact. The bonds were subjected to various aging conditions and tested in 180° peel at a rate of 2 inches per minute.

Peel Strength (piw)

Unsupported Vinyl:

Substrate	Aging Conditions			
	1 Day @ R.T.	7 Days @ R.T.	Plus 7 Days @ 140°F	Plus 7 Days @ 100% R.H.
Steel	7 s	17 s	20 s	17 s
Glass	8½ s	15 s	TV	0 s
Aluminum	8½ s	19 s	TV	TV
Polyester	7½ s	14½ s	21 s	17 s
Wood (Maple)	10½ s	20 s	TV	TV

Supported Vinyl:

Substrate	Aging Conditions			
	1 Day @ R.T.	7 Days @ R.T.	Plus 7 Days @ 140°F	Plus 7 Days @ 100% R.H.
Glass	15 v	18 v	16 v	0 s
Aluminum	15 s	19 v	13 v	12 s
Polyester	16 v	16 v	14 v	13 v
Wood	15½ v	17½ v	14 v	17 v

Code: c - Adhesive failed cohesively s - Bond failed in adhesion to indicated substrate
v - Bond failed in adhesion to vinyl TV - Vinyl tore before bond failed

Note: The above adhesion values will vary for other grades of vinyl depending upon the amount and type of plasticizer present.

*30 parts per hundred resin of dioctyl phthalate plasticizer.

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 at the recommended conditions in original, unopened containers, 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.

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.



Industrial Adhesives and Tapes Division

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