Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L TF

Product Data Sheet

Date: May 2016
Supersedes: October 2014

Product Description

Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L TF is a fast drying adhesive that develops strength quickly.

Typical Physical Properties

However it is important to note that the potential for the presence of toluene contamination in the adhesives will be at trace levels, far less than 0.1% and therefore below the minimum limits for declaration according to Annex XVII of REACH (1907/2006/EC) and also below the minimum limits for declaration on the 3M Safety Data Sheet according to CLP (1272/2008/EC).

	1300L TF
Viscosity (Brookfield RVF - #3 spindle @ 20 rpm) **(ISO 2555)**	510 mPAs
Solids Content **(EN ISO 827)**	27.5%
Colour (wet & dry)	Dark Brown
Specific Gravity **(EN ISO 2811.1)**	0.86 g/cm
Solvent As toluene is substituted by acetate in this new version of SW 1300L TF, the smell is different. The acetate is less toxic than toluene; however as with all solvent- based products, you should use it only in well-ventilated areas.	Acetone

Typical Adhesive Performance Characteristics

Tack Set	approx. 173 sec (period of time before the adhesive become tacky, test done at 23°C and 50% relative humidity)
Tack Range	approx. 247 sec (period of time in which the adhesive will remain in the tacky-dry condition, test done at 23°C and 50% relative)

Application Equipment

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 PTFE (polytetrafluoroethylene).

Directions for Use

When bonding wood veneers, success is dependent on many variables such as environmental conditions, bonding process, type of base material, type of veneer, adhesive type and top coat finishing systems to name a few. It is the user's responsibility to thoroughly test any adhesive for its suitability in bonding wood veneers. It is also recommended to follow the veneer manufacturers recommendation and industry guidelines.

Note: Read and follow precautions before using this product.

Surface Preparation
For best results, all surfaces to be bonded should be dry and free from dirt, dust, oil, loose paint, wax, grease, etc.

Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone.*****

If used for decorative laminate, laminate should have reached moisture equilibrium for the shop conditions.

Directions for Use

Working Temperature
The temperature of the adhesive and surfaces to be bonded should be at 18°C or above.
Warm the can of adhesive by placing in a warm room, not in stove, oven or other possible ignition source.
If the room must be warmed, turn off the heater before opening container.
Leave heater off until all vapours are gone.

Application
1. Stir thoroughly before using.
2. Apply adhesive generously in a uniform film on both surfaces with either a fiber or animal hair brush, or pour and spread with paint roller (solvent resistant texturing type).
3. Porous surfaces may require 2 coats of adhesive.
4. A glossy film when completely dry indicates adequate adhesive.
5. Dull spots after drying indicate not enough adhesive; these spots must have another coat.

Assembly
1. Allow to dry until adhesive is no longer tacky (5-10 minutes).
2. Position surfaces carefully before assembly.
3. No adjustment is possible after contact.
4. Spacers such as dowels or strips of laminate, may be used to prevent premature adhesive/adhesive contact and bonding.
5. Slide out the spacers and apply uniform pressure, working toward the edges.
6. A 3 in. roller used with maximum body pressure should be used to help ensure adequate contact and bonding, especially on the edges.
7. Bonded assemblies can be machined, trimmed or finished immediately after bonding.

Drying Time
Drying time depends on temperature, humidity, air movement and porosity of materials bonded.

Clean-up
Excess adhesive may be removed with a solvent such as methyl ethyl ketone.*****

*****When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer’s precautions and directions for use.

Additional Product Information	**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.
Storage Conditions	Best storage temperature is 16°C - 27°C. Continuous exposure to higher temperatures may cause some increase in viscosity. Quality is not affected until the adhesives becomes thickened so that it is difficult or impossible to spread. 3M™Scotch-Weld™1300L TF will not freeze, but continuous exposure to low temperature will cause a considerable increase in viscosity. After storage at low temperatures and before using, the adhesive must be thawed and stirred vigorously until the entire container regains its original viscosity. The thawing process should be done at approximately room temperatures, never at elevated temperatures. Several days may be required for thawing – particularly with larger containers. Rotate stock on a “first in-first out” basis.
Shelf Life	The product can be stored up to 45 months after production
Precautionary Information	Refer to product and Material Safety Data Sheet for health and safety information before using the product. For information please see below for contact details.
For Additional Information	To request additional product information or to arrange for sales assistance, please see below for contact details.
Important Notice	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 or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

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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