

Rubber & Gasketing Adhesive

The image shows the iconic 3M logo in a bold, red, sans-serif font. The '3' is a single digit, and the 'M' is a double-digit 'M'. The logo is centered horizontally and vertically in the upper half of the page.

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*SERVING INDUSTRY
FOR OVER 73 YEARS*



3M™ Fastbond™ and Scotch-Grip™ Industrial Adhesives

Innovative answers to a wide variety of non-structural bonding challenges

3M™ Fastbond™ and Scotch-Grip™ Adhesives are industrial tools designed to provide innovative answers to a wide variety of non-structural bonding problems.

Some formulations are tailored to specific types of applications such as 3M™ Scotch-Grip™ Plastic Adhesives. These high strength, fast drying elastomers bond polycarbonate, vinyl, and many other plastics to themselves and materials such as wood or metal. With 3M™ Scotch-Grip™ Rubber and Gasket Adhesives you can easily bond neoprene, EPDM, and many more.

Depending on the specific 3M industrial adhesive, you can select drums, cans, pails, or handy tubes. These collapsible squeeze tubes are self-contained, lightweight applicators to give you “take-it-to-the-job” convenience for multi-station or low volume assembly and field repairs.



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For a reliable non-structural adhesive, you're likely to find just what you need in the 3M™ Fastbond™ and Scotch-Grip™ lines backed with more than 50 years of 3M adhesives research and engineering. For example, 3M™ Fastbond™ Insulation Adhesive 49 is a fast tacking, pressure sensitive formulation for bonding fabric, insulation, and other lightweight materials to themselves, or to metal, wood, and other substrates.



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When refurbishing a pinball machine, 3M™ Scotch-Grip™ Plastic Adhesive 4693H bonds and seals decorative translucent plastic inserts into the underside of the playing surface. Up to 60 minute bonding range with contact bond properties.



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To prevent moisture penetration, a pressure flow gun applies 3M™ Scotch-Grip™ Rubber and Gasket Adhesive to bond a rubber gasket into a commercial light fixture cover.



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With excellent resistance to fuel and oil, 3M™ Scotch-Grip™ Rubber and Gasket Adhesive 847 bonds and seals chemical drum gaskets in place.



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HVAC duct insulation is easy and economical to apply with 3M™ Fastbond™ Insulation Adhesive 49. This single-component, water-based pressure sensitive formulation speeds up assembly with instant tack.



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In washing machine repair, 3M™ Scotch-Grip™ Rubber and Gasket Adhesive 1300 bonds with high immediate strength and seals the doughnut ring seal in the outer tub. Bond line resists up to 300°F (149°C).



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In bonding plastic feathers and nocks onto arrow shafts, fast-tacking 3M™ Scotch-Grip™ Plastic Adhesive 4475 dries quickly to a firm bond. Resists plasticizers, water, and heat up to 200°F (93°C).

Product Information: 3M™ Scotch-Grip™ Plastic Adhesives

Product	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PIW)	
								75°F (24°C)	180°F (82°C)	75°F (24°C)	
Plastic Adhesives	826	• Fast drying for many plastic films • Resists aromatic and aliphatic fuels, water, oil	24%	35°F (3°C)	Thin liquid	Amber	Spray, brush	Up to 45 minutes	198 ⁽¹⁾	59 ⁽¹⁾	27 ⁽³⁾
	1099	• Fast drying and heat curable • Resists weathering, water, oil, plasticizer migration, aliphatic fuels • Meets MIL-A-13883B, Type I and MMM-A-189C, Class 2	32%	0°F (-18°C)	Medium liquid	Light Tan	Brush, flow	Up to 40 minutes	1306 ⁽¹⁾⁽²⁾	643 ⁽¹⁾⁽²⁾	31 ⁽³⁾
	1099L	• Sprayable version of 1099 Adhesive	24%	0°F (-18°C)	Thin liquid	Tan	Spray, brush	Up to 20 minutes	1306 ⁽¹⁾⁽²⁾	643 ⁽¹⁾⁽²⁾	31 ⁽³⁾
	2262	• Quick tack, clear, non-staining • Resists plasticizer migration for bonding many flexible vinyls	25%	0°F (-18°C)	Thin liquid	Clear	Brush, flow	Up to 20 minutes	N/A	N/A	17 ⁽⁴⁾
	4475	• Clear, fast tacking, dries quickly • Resists water, plasticizers detergent, oils and grease	42%	20°F (-7°C)	Medium liquid	Clear	Flow	Up to 10 minutes	N/A	N/A	44 ⁽³⁾
	4693	• Long tack range • Water and heat resistant bond for many plastics, including polyethylene and polypropylene	24%	1°F (-17°C)	Thin liquid	Clear	Spray, brush	Up to 60 minutes	N/A	N/A	22 ⁽³⁾
	4693H	• High viscosity version of 4693 Adhesive for collapsible tubes	36%	1°F (-17°C)	Medium liquid	Clear	Flow, brush	Up to 60 minutes	N/A	N/A	22 ⁽³⁾

(1) Aluminum to aluminum @ 0.1 inches/minute separation rate.

(3) Canvas to cold rolled steel @ 2.0 inches/minute separation rate.

(4) Unsupported vinyl to steel @ 2.0 inches/minute separation rate.

(2) Bonds heat cured for 15 minutes @ 325°F, 150 PSI

Product Information: 3M™ Scotch-Grip™ Rubber and Gasket Adhesives

Product	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PIW)	
								75°F (24°C)	180°F (82°C)	75°F (24°C)	
Rubber and Gasket Adhesives	847	• Quick drying and flexible with fuel and oil resistance • Heat and solvent reactivatable • Curable with heat	36%	0°F (-18°C)	Medium liquid	Brown	Flow, brush	Up to 15 minutes	200 ⁽¹⁾	9 ⁽¹⁾	40 ⁽²⁾
	847L	• Lower viscosity version of 847 Adhesive for spray application	24%	0°F (-18°C)	Thin syrup	Brown	Spray, brush	Up to 20 minutes	200 ⁽¹⁾	9 ⁽¹⁾	40 ⁽²⁾
	847H	• Higher viscosity version of 847 Adhesive	50%	0°F (-18°C)	Thick syrup	Brown	Flow, brush	Up to 10 minutes	200 ⁽¹⁾	9 ⁽¹⁾	40 ⁽²⁾
	1300	• High immediate strength • Fast-drying and heat resistant for rubber and metal	37%	-14°F (-26°C)	Medium liquid	Yellow	Flow, brush	Up to 12 minutes	549 ⁽¹⁾	136 ⁽¹⁾	52 ⁽²⁾
	1300L	• Lower viscosity version of 1300 Adhesive • Sprayable • Meets Mil Spec MMM-A-121	29%	-14°F (-26°C)	Thin liquid	Yellow	Spray, brush	Up to 8 minutes	549 ⁽¹⁾	136 ⁽¹⁾	52 ⁽²⁾
	2141	• Easy brushing • General purpose with excellent water resistance	30%	-14°F (-26°C)	Medium liquid	Light Yellow	Flow, brush	Up to 15 minutes	377 ⁽¹⁾	68 ⁽¹⁾	32 ⁽²⁾
	4799	• Brushable paste consistency with low soak-in on porous surfaces • Can bond EPDM rubber	36%	-14°F (-26°C)	Thin paste	Black	Brush, trowel	Up to 15 minutes	N/A	N/A	28 ⁽²⁾

Note: The technical information and data on these pages should be considered representative or typical only, and should not be used for specification purposes.

(1) Birch plywood to birch plywood @ 0.1 inches/minute separation rate.

(2) Canvas to cold rolled steel @ 2.0 inches/minute separation rate.

Product Information: 3M™ Fastbond™ and 3M™ Scotch-Grip™ Insulation and Light-Duty Adhesives

	Product	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Peel Strength (PIW)75°F (24°C)
3M™ Fastbond™ Adhesives	Insulation Adhesive 49	<ul style="list-style-type: none"> Fast tacking, high performance pressure sensitive adhesive for lightweight materials Low VOCs • UL component recognition MAGW2 file MH 6288 	55%	None	Thin liquid	Clear	Spray, brush, roller	30 days plus	3.0 ⁽³⁾
	Pressure Sensitive Adhesive 4213NF	<ul style="list-style-type: none"> Resists staining and discoloration Dries clear Low VOCs 	54%	None	Medium liquid	Clear	Brush, roller, trowel	5 minutes	12.0 ⁽²⁾
	Industrial Adhesive 4224NF	<ul style="list-style-type: none"> Permanently pressure sensitive with aggressive tack • Plasticizer resistant Low VOC content 	40%	None	Thick liquid	Blue, Clear	Spray, brush, roller, trowel, coater	30 days plus	4.4 ⁽³⁾
3M™ Scotch-Grip™ Adhesives	Industrial Adhesive 1870	<ul style="list-style-type: none"> Single surface application Very long tack range Flexible bond • Resists bleed through 	26%	-7°F (-22°C)	Thin liquid	Tan	Spray, brush	Up to 40 minutes	7.0 ⁽⁴⁾
	Construction Mastic 4323	<ul style="list-style-type: none"> Resists wear, heat and dead load creep 	66%	1°F (-17°C)	Mastic	Gray	Caulk, flow, trowel	Up to 20 minutes	N/A
	Industrial Adhesive 4550	<ul style="list-style-type: none"> Fast tacking Long bonding range 	35%	Less than -20°F (-29°C)	Medium liquid	Clear/translucent	Low pressure spray	Up to 60 minutes	23.0 ⁽¹⁾

Product Information: 3M™ Scotch-Grip™ Solvents

	Product	Features	Base	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color	Application Method
Solvents	Solvent No. 2	<ul style="list-style-type: none"> Contains petroleum distillate and toluene for removing many oil-soluble adhesives, coatings and sealers Not recommended for surface preparation 	Toluene aliphatic blend	0%	-14°F (-26°C)	Very thin liquid	Clear	Brush, dip, spray
	Solvent No. 3	<ul style="list-style-type: none"> Contains methyl ethyl ketone for removing many oil-resistant adhesives, coatings, and sealers • Solvent reactivation of pre-applied adhesives • Cleans surfaces prior to bonding 	Methyl ethyl ketone	0%	-20°F (-29°C)	Very thin liquid	Clear	Brush, dip, spray

Note: The technical information and data on these pages should be considered representative or typical only, and should not be used for specification purposes.

- Canvas to cold rolled steel @ 2.0 inches/minute separation rate.
- Supported vinyl to wood @ 2.0 inches/minute separation rate.
- Primed polyester to steel @ 2.0 inches/minute separation rate.
- Maple to itself @ 50% R.H. Test at 0.1 inches/minute separation rate.





A tradition of 40 years and the performance you'll want for a long time to come

This line offers a wide range of choices for contact adhesive applications. Select from bonding ranges, strengths, solids content, and solvent or water-based formulations to meet requirements for bonding laminate, foam, and more.

In the line, you'll find the water-based pioneer 3M™ Fastbond™ Contact Adhesive 30NF – proven for almost 40 years in cabinet shops and compliant with the stringent requirements of South Coast Air Quality Management District Rule 1168. Plus, there's 3M™ Fastbond™ Contact Adhesive 2000NF with handling speed exceeding most solvent-based systems and up to 350 psi in overlap shear.

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The 3M™ Fastbond™ Water-Based Story

While competition pressures you to improve productivity, regulatory legislation demands that you move toward more environmentally-responsible technologies. Some local and regional regulations have made traditional solvent-based contact adhesives virtually obsolete.

By replacing solvent-based adhesives with a water-based 3M™ Fastbond™ Adhesive, compliance is getting easier in more and more applications. At the same time, you have a choice of production and end-use characteristics as you can see in the chart at far right.



Fastbond is the 3M trademark on a continually growing line of water-based adhesives. For example, 3M™ Fastbond™ Foam Adhesive 100 is a one-part, water-dispersed formulation for bonding many porous substrates to porous or non-porous substrates with minimal dry time.



For tabletop lamination, 3M™ Fastbond™ Contact Adhesive 2000NF gives you three times the coverage of a typical solvent-based system. For production speed, you go from spray to trim in seconds.



In compound cushion assembly, 3M™ Fastbond™ Foam Adhesive 100 holds curves in seconds. Lighter density foam is adhered around the higher density core with a smooth rounded edge.



3M™ Fastbond™ Foam Adhesive 100 quickly bonds substrates throughout chairs and couches. Bond foam to foam and fiber fill, foam to wood, fiber fill to fabric, and more.



In cabinet assembly, 3M™ Fastbond™ Contact Adhesive 30NF is a formulation proven in shops for four decades. Combines open time of up to 4 hours with high immediate bond strength. Apply with roller, brush, or spray gun.



In bonding carpet to fiberglass flooring and steps, 3M™ Fastbond™ Contact Adhesive 2000NF helps withstand the foot traffic and moisture in boat cabins.

Photo courtesy of Grady White Boats Incorporated.

Product Information: 3M™ Fastbond™ Contact Adhesives, Water-Based

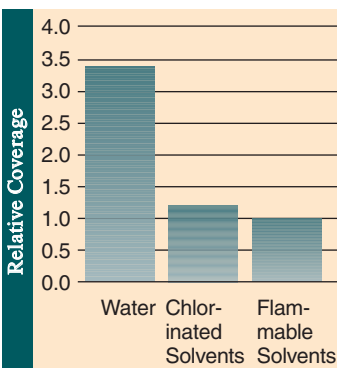
Product	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PIW)	
								75°F (24°C)	180°F (82°C)	75°F (24°C)	
Contact Adhesives, Water-Based	30NF	• Long bonding range with high immediate bond strength • Economical high coverage • Meets MIL-A-24179A, Type I	50%	None	Thin liquid	Green, Clear	Spray, roller, brush	Up to 4 hours	480 ⁽¹⁾	60 ⁽¹⁾	5.9 ⁽²⁾
	30H	• High viscosity version of 30NF for roll coating	50%	None	Medium liquid	Green, Clear	Spray, roller, brush, roll coat	Up to 4 hours	480 ⁽¹⁾	60 ⁽¹⁾	5.9 ⁽²⁾
	2000NF	• Water-dispersed, activated adhesive • Immediate bonding and handling strength without forced drying	49%	None	Thin liquid	Blue, Light Orange, Clear	Co-Spray	Up to 2 hours	350 ⁽¹⁾	50 ⁽¹⁾	4.1 ⁽²⁾
	100	• One-part, fast setting with neoprene base • Bonds many porous substrates to porous or non-porous substrates	47%	None	Very thin liquid	Lavender, Clear	Spray	Up to 20 minutes	NA	NA	1.1 ⁽²⁾

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Product Information: 3M™ Scotch-Grip™ Contact Adhesives

Product	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PIW)	
								75°F (24°C)	180°F (82°C)	75°F (24°C)	
Contact Adhesives	5	• Rapid strength buildup • Heat and creep resistant bond • Meets mil spec MMM-A-121	19%	-14°F (-26°C)	Thin liquid	Green, Light Yellow	Spray	30 minutes maximum	482 ⁽¹⁾	65 ⁽¹⁾	19 ⁽²⁾
	10	• Similar performance to 5 • Brushable with higher coverage • Meets mil spec MMM-A-121	22%	-14°F (-26°C)	Thin liquid	Light Yellow	Brush, roller	30 minutes maximum	482 ⁽¹⁾	65 ⁽¹⁾	19 ⁽²⁾
	1357	• Rapid buildup to a very high strength bond for metal • Resists heat and continuous load stress • Meets MIL-A-21366A, MMM-A-121	25%	-14°F (-26°C)	Thin liquid	Gray-green, Light Yellow	Brush, spray	30 minutes maximum	536 ⁽¹⁾	199 ⁽¹⁾	42 ⁽²⁾
	1357L	• Lower solids, lower viscosity version of 1357 for automatic spray	18%	-14°F (-26°C)	Thin liquid	Gray-green	Spray	30 minutes maximum	536 ⁽¹⁾	199 ⁽¹⁾	42 ⁽²⁾

(1) Birch plywood to birch plywood @ 0.1 inches/minute separation rate. (2) Canvas to cold rolled steel @ 2.0 inches/minute separation rate.



Carrier	Water	Chlorinated Solvents	Flammable Solvents
% Solids	50%	15%	20%
Density (lbs/gal)	9.1	10.8	6.7
lbs. of adhesive/gal	4.6	1.6	1.3
Relative coverage	3.4	1.2	1.0
Issues		Toxicity	Flammability



Buy only the quantity you need – Depending on the specific adhesive, you can select tubes, quart or gallon jugs for convenient handling, or 5-gallon pails and 55-gallon drums for large bulk dispensing.

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