

3M Scotch-Weld™

Instant adhesives, Thread lockers
and Thread Sealants

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 'M' shape. The logo is centered horizontally and vertically within its white rectangular background.

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*SERVING INDUSTRY
FOR OVER 73 YEARS*



3M™ Scotch-Weld™ Instant Adhesives

Fast bonding with the right combination of strength, cure time, and viscosity

For speed and performance, you'll likely find a product in this line with precisely the right combination of bond strength, cure time and viscosity.

These one-part cyanoacrylate adhesives rapidly reach handling strength at room temperature without a catalyst. On many applications, bonds reach handling strength in 5-10 seconds and 80% of full strength in an hour. A single drop per square inch can bond many plastics, rubber, metals and more with tensile strength up to 5,000 psi.

Application is easy from their own containers or through intermediate manual dispensers or automated systems. Curing requires no expensive equipment or fixturing.



3M™ Scotch-Weld™ CA40 Instant Adhesive works on many problem surfaces where other adhesives may fail, such as EPDM rubber.



For repair of fiberglass/concrete cast pottery, 3M™ Scotch-Weld™ Instant Adhesive CA50 Gel bonds with high tensile and shear strength. Non-sagging for neat application.



For wood and veneer repair, 3M™ Scotch-Weld™ Instant Adhesive CA40H is a high viscosity liquid for a fast void-filling bond.



3M™ Scotch-Weld™ Instant Adhesive CA8 is a multi-purpose product for use in a variety of assembly applications.

Product information: 3M™ Scotch-Weld™ Instant Adhesives

Product	Description	Base	Time ⁽¹⁾ To Handling Strength (Sec.)	Viscosity (CPS)	Average ⁽²⁾ T-Peel At 75°F (24°C) (PIW)	Overlap Shear Strength ⁽³⁾ @ 75°F (24°C) (PSI)					
						Steel	Alumi- num	Nitrile Rubber	Neoprene Rubber	ABS	Rigid PVC
CA4	• Fast setting for a variety of plastics and rubbers	ethyl	5-40	150	1-2	2300	2800	35*	55*	800*	800*
CA5	• Higher viscosity, slower setting version of CA4 for filling gaps • Meets CID A-A-3097, Type II, Class 3	ethyl	15-60	2000	1-2	2500	650	35*	55*	800*	800*
CA7	• Very fast setting • Excellent adhesion to metals, plastics, and rubbers	methyl	1-30	15-40	2-4	2500	2400	35*	55*	900*	1000*
CA8	• Slower setting than CA7 • Excellent adhesion to metals, plastics and rubbers • Meets CID A-A-3097, Type II, Class 2	ethyl	5-40	70-130	2-4	2000	2100	35*	55*	900*	1000*
CA9	• Slower setting version of CA8 for wire tacking and coil terminating • Meets CID A-A-3097, Type II, Class 3	ethyl	20-70	1000-1700	2-4	2000	2400	35*	55*	900*	1000*
CA40	• Very fast setting • Excellent adhesion to many substrates including flexible vinyl and EPDM rubber	ethyl	3-20	20	1-2	1700	2600	35*	55*	800*	800*
CA40H	• Higher viscosity version of CA40 • Better void filling capabilities.	ethyl	5-40	400-600	1-2	1500	1500	35*	55*	900*	1000*
CA50 Gel	• High-viscosity, non-sag gel • Less sensitive to acidic surfaces.	ethyl	60-120	45,000-85,000	1-2	2000	900	105*	130*	800*	600*
CA100	• High peel and impact strength • High thermal shock and heat resistance	ethyl	20-70	2500-4500	15	2000	2900	95*	120*	600*	700*
Surface Activator	• Clear, colorless organic-based liquid helps speed curing and prime surfaces • Comes with brush and spray pump										

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

(1) The time it takes assembled parts to reach a strength where further handling and processing can take place. Times will depend on surface to be bonded, temperature and humidity.

(2) Tested per ASTM D 1876-61T.

(3) Tested per ASTM D 1002-64.
* Substrate failure.



3M™ Scotch-Weld™ Anaerobic Adhesives

The easy choice for running a tight operation

To seal gaps and tighten the fit between metal surfaces, 3M™ Scotch-Weld™ Anaerobic Adhesives apply on target and cure quickly in the absence of air. The line represents the essentials for many industrial applications and making the right choice is easy.

- Easy-to-understand, color-coded packaging
- Simplified, streamlined inventory to reduce money tied up on the shelf
- Every product backed with 3M technical support

3M™ Scotch-Weld™ Threadlockers weld fasteners in place for blind holes and thru holes and prevent loosening from vibration.

3M™ Scotch-Weld™ Thread Sealants seal instantly to stop leaks when applied to the threads or compression fittings of most metal or certain plastic pipes.

3M™ Scotch-Weld™ Retaining Compounds bond and seal non-threaded cylindrical assemblies.

3M™ Scotch-Weld™ Gasket Makers fill voids between metal flanges and cure to a tight rigid or flexible seal.



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3M™ Scotch-Weld™ Threadlockers on threaded metal fasteners help keep production equipment up and running. You save the cost and time of disruptive, unscheduled downtime due to nuts, bolts, and screws that vibrate loose in such areas as gear housings and motor mounts.



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3M™ Scotch-Weld™ Gasket Makers eliminate pre-cut or compression gaskets, or hold pre-cut gaskets in place during production. Seal without shimming effect or creeping.



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3M™ Scotch-Weld™ Threadlockers fill and seal threads completely to help stop corrosion, rust, and leaks. Securely hold even dissimilar metals.



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3M™ Scotch-Weld™ Retaining Compounds readily tighten tolerances in worn bearing seats, keyways, splines, tapers, shims, gears, and shafts. Fill voids completely to seal out moisture.



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To save the cost of leaking fluid or gas, 3M™ Scotch-Weld™ Thread Sealants cure quickly to a tight, continuous seal without the creep and shrinkage of pastes.



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With a fast and easy squeeze, 3M™ Scotch-Weld™ Thread Sealants eliminate the cost and problems of shredding tapes, O-rings, and other mechanical sealants.

Product information: 3M™ Scotch-Weld™ Anaerobic Adhesives

3M™ Scotch-Weld™ Threadlockers

Product number	Removal (torque-break/prevail)	Bolt size	Description	Color	Size
3493	Low 50/30 lb. in.	Less than 5/16"	• Screw grade • Thixotropic to reduce flow after application to surface • Hand tools for disassembly	Purple	10, 50, 250 ml
3494	Medium 120/50 lb. in.	Up to 3/4"	• Nut grade • Thixotropic to reduce flow after application to surface • Oil tolerant • Hand tools for disassembly	Blue	10, 50, 250 ml
3495	Medium/high 200/100 lb. in.	Up to 1"	• Permanent, controlled torque • High breakaway, reduced prevailing torque • Heat and hand tools for disassembly	Red	10, 50, 250 ml
3496	High 230/330 lb. in.	Up to 1"	• Permanent • Low viscosity • High breakaway, high prevailing torque • Heat and hand tools for disassembly	Red	10, 50, 250 ml
3497	High 130/225 lb. in.	Up to 1-1/2"	• Permanent • High viscosity • Wide temperature range -65°F to 450°F (-55 to 232°C) • High breakaway, high prevailing torque • Heat and hand tools for disassembly	Red	10, 50, 250 ml
3498	Medium 85/250 lb. in.	Greater than 1/4"	• Wicks into pre-assembled bolts • Seals welds and porous metals • Locks and seals small compression and ferrule fittings • Service temperature to 400°F (204°C) • Heat and hand tools for disassembly	Green	10, 50, 250 ml

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3M™ Scotch-Weld™ Thread Sealants

Product number	Removal torque	Pipe size	Description	Color	Size
3477	Low 15 lb. in.	Up to 2"	• Medium viscosity with no fillers • For all hydraulic and pneumatic fittings • No clogging of valves or filters • Hand tool disassembly for pipes under 1", heat required for over 1"	Purple	50 ml
3478	Low 25 lb. in.	Up to 2"	• Faster cure than 3477 • Wide temperature range from -65°F to 400°F (-55°C to 204°C) • For stainless steel, Monel®, and other inactive surfaces • Hand tool disassembly	White	50 ml
3479	Medium 50 lb. in.	Up to 3"	• High lubricity for easy threading • Instant seal with slow cure • Re-adjustable for up to 24 hours • Wide temperature range from -65°F to 400°F (-55°C to 204°C) • Hand tool disassembly	White	50 ml

3M™ Scotch-Weld™ Retaining Compounds

Product number	Shear strength (psi)	Gap fill	Description	Color	Size
3434	2500	Up to 0.015"	• Medium-high strength • High viscosity • Thixotropic to reduce flow after application to surface • Temperature resistance to 450°F (232°C) for cylinder, heat exchanger, and other high temperature applications	Green	50 ml
3435	2500	Up to 0.005"	• Medium strength • Low viscosity general purpose compound for rigid cylindrical assemblies • Augments press fits	Green	50 ml
3436	3250	Up to 0.020"	• Medium strength • Gel formulation for repair of worn shafts, splines, keyways, and housings	Gray	50 ml
3437	3700	Up to 0.015"	• High strength • Medium viscosity • For rigid and slip fit assemblies	Green	50 ml

3M™ Scotch-Weld™ Gasket Makers

Product number	Hardness	Gap fill primed/unprimed	Description	Color	Size
3453	Rigid	Up to 0.020"/0.010"	• General purpose gasketing with wide temperature range from -65°F to 400°F (-55°C to 204°C) • Hand dispense or screen print • Instant low pressure seal	Red	50 ml
3454	Flexible	Up to 0.050"/0.010"	• Gasketing for aluminum flanges • Does not shrink or relax • Instant low pressure seal without priming	Red	50 ml
3455	Flexible	Up to 0.050"/0.010"	• General purpose gasketing for gearbox covers, pump flanges, fuel and water pumps • Provides instant low pressure seal	Purple	50 ml

3M™ Scotch-Weld™ Anaerobic Activator

Product number	Description	Size
3989 Anaerobic Activator	• Accelerates cure of all 3M anaerobic adhesive products • Helps assure cure on inactive metals • Dry time 30-60 seconds • 30 days on-part life • Solvent-based (flammable acetone)	4.5 oz.

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