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3M™ Neoprene Contact Adhesive 10

Product Description

3M™ Neoprene Contact Adhesive 10 is a multi-purpose contact adhesive which may be used to bond plastic laminate, aluminum, steel, wallboard, wood, masonry, rubber and canvas.

Product Features

- Roll or brush-applied.
- Fast drying.
- Adhesion to a wide variety of materials.
- Excellent resistance to plastic flow (creep).
- 60 minute bonding range.
- Meets the specification requirements of MMM-A-121, MMM-A-130B, and A-A-1936A.

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties

Property	Values		Notes	Test Condition
Color	Light Yellow (wet and dry)			
Solids Content by Weight	21 to 25 %			
Flash Point	-25 °C	-14 °F	TCC	
Solvent	Petroleum distillate, acetone, toluene and n-hexane			
Coverage	288 sq ft/gal		@ 2.5 g/ft² dry wt.	
Viscosity	450 to 700 cP		Brookfield Viscometer RVF #2 spindle @ 20 rpm	80°F(27°C)

*Note

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.

Typical Uncured Physical Properties

Property	Values
Base	Polychloroprene
Net Weight	6.9 ∓ 0.2 lb/gal

Typical Performance Characteristics

180° Peel Adhesion	Dwell/Cure Time	Test Condition	Failure mode
160 oz/in	1 day @ Room Temperature	Room Temperature	
208 oz/in	3 days @ Room Temperature	Room Temperature	
272 oz/in	5 days @ Room Temperature	Room Temperature	
304 oz/in	7 days @ Room Temperature	Room Temperature	
352 oz/in	2 wk @ Room Temperature	Room Temperature	

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Typical Performance Characteristics (continued)

180° Peel Adhesion	Dwell/Cure Time	Test Condition	Failure mode
368 oz/in	3 wk @ Room Temperature	Room Temperature	
448 oz/in	3 wk @ Room Temperature	-30°F(-34°C)	SF
144 oz/in	3 wk @ Room Temperature	180°F(82°C)	

Property: 180° Peel Adhesion
Substrate: Cotton Duck to Cold Rolled Steel
notes: AF: adhesive failure CF: cohesive failure SF: substrate failure

Overlap Shear Strength	Dwell/Cure Time	Test Condition	Failure mode
430 lb/in²	2 wk @ Room Temperature	Room Temperature	SF
433 lb/in²	3 wk @ Room Temperature	Room Temperature	SF
676 lb/in²	3 wk @ Room Temperature	-30°F(-34°C)	SF
111 lb/in²	3 wk @ Room Temperature	180°F(82°C)	
70 lb/in²	3 wk @ Room Temperature	225°F(107°C)	

Property: Overlap Shear Strength
Substrate: Birch Plywood
notes: AF: adhesive failure CF: cohesive failure SF: substrate failure

Handling/Application Information

Application Equipment

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. Brushes: Use fiber or animal hair brushes. Do not use nylon or other synthetic fibers.
2. Rollers: Use solvent resistant paint rollers, designed for applying oil based paints.

Handling/Application Information (continued)

Directions for Use

Working Temperature
1. The temperature of the adhesive and surfaces to be bonded should be at 65°F (18°C) or above.
2. Warm the can of adhesive by placing in a warm room, not in stove, oven or other possible ignition source.
3. If the room must be warmed, turn off the heater before opening container.
4. Leave heater off until all vapors 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
1. Drying time depends on temperature, humidity, air movement and porosity of materials bonded.
Cleanup
1. 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.

Surface Preparation

Note: Read and follow precautions before using this product.
Surface Preparation
1. For best results, all surfaces to be bonded should be dry and free from dirt, dust, oil, loose paint, wax, grease, etc.
2. Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone.*
3. If used for decorative laminate, laminate should have reached moisture equilibrium for the shop conditions.

Storage and Shelf Life

Best storage temperature is 60-70°F (16-27°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™ Neoprene Contact Adhesive 10 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.
When stored at the recommended conditions in the original, unopened container this product has a shelf life of 30 months from date of manufacture.

Industry Specifications

MMM-A-121
MMM-A-130B
A-A-1936A

Information

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