

3M Scotch-Weld™ 3535 B/A Two-Part Structural Adhesive

Category : Polymer , Adhesive

Material Notes:

3M™ Scotch-Weld™ Urethane Adhesives are two-component, polyurethane adhesives which cure at room temperature or with heat to form tough, impact-resistant structural bonds. Their adhesion properties are identical and they vary only in work life, cure time and color. They provide excellent adhesion to many primed or painted metal and plastic substrates and are designed to develop sag resistance approximately 30 second after mixing. Information provided by 3M

Order this product through the following link:

http://www.lookpolymers.com/polymer_3M-Scotch-Weld-3535-BA-Two-Part-Structural-Adhesive.php

Physical Properties	Metric	English	Comments
Viscosity	30000 cP	30000 cP	
Brookfield Viscosity	5000 - 6000 cP	5000 - 6000 cP	Base, RVF #6 sp @ 20 rpm
	15000 - 40000 cP	15000 - 40000 cP	Accelerator, RVF #5 sp @ 20 rpm

Mechanical Properties	Metric	English	Comments
Shear Strength	0.138 MPa	20.0 psi	Overlap, Solvent Wiped Steel
	@Temperature 82.0 °C	@Temperature 180 °F	
	0.276 MPa	40.0 psi	Overlap, Nylon
	@Temperature 82.0 °C	@Temperature 180 °F	
	0.483 MPa	70.0 psi	Overlap, Plexiglass
	@Temperature 82.0 °C	@Temperature 180 °F	
	0.689 MPa	100 psi	Overlap, Solvent Wiped Al
	@Temperature 82.0 °C	@Temperature 180 °F	
	0.689 MPa	100 psi	Overlap, Abraded and Solvent Wiped Steel
	@Temperature 82.0 °C	@Temperature 180 °F	
	0.758 MPa	110 psi	Overlap, Rigid PVC
	@Temperature 82.0 °C	@Temperature 180 °F	
	0.758 MPa	110 psi	Overlap, Polystyrene
	@Temperature 82.0 °C	@Temperature 180 °F	
	0.862 MPa	125 psi	Overlap, Lexan
	@Temperature 82.0 °C	@Temperature 180 °F	
	1.24 MPa	180 psi	

Mechanical Properties	Metric @ Temperature 82.0 °C	English @ Temperature 180 °F	Overlap, FRP Comments
	1.65 MPa @Temperature -40.0 °C	240 psi @Temperature -40.0 °F	Overlap, Nylon
	2.07 MPa @Temperature 82.0 °C	300 psi @Temperature 180 °F	Overlap
	2.07 MPa @Temperature 82.0 °C	300 psi @Temperature 180 °F	Overlap, Etched Aluminum
	2.07 MPa @Temperature 82.0 °C	300 psi @Temperature 180 °F	Overlap, Abraded and Solvent Wiped Al
	2.07 MPa @Temperature 82.0 °C	300 psi @Temperature 180 °F	Overlap, ABS
	2.28 MPa @Temperature -40.0 °C	330 psi @Temperature -40.0 °F	Overlap, Polystyrene
	2.55 MPa @Temperature -40.0 °C	370 psi @Temperature -40.0 °F	Overlap, Rigid PVC
	3.03 MPa @Temperature -40.0 °C	440 psi @Temperature -40.0 °F	Overlap, ABS, Substrate Failure
	3.65 MPa @Temperature 24.0 °C	530 psi @Temperature 75.2 °F	Overlap, Polystyrene
	4.00 MPa @Temperature 24.0 °C	580 psi @Temperature 75.2 °F	Overlap, Nylon
	4.27 MPa @Temperature -40.0 °C	620 psi @Temperature -40.0 °F	Overlap, Plexiglass
	4.83 MPa @Temperature 24.0 °C	700 psi @Temperature 75.2 °F	Overlap, Solvent Wiped Steel
	5.58 MPa @Temperature 24.0 °C	810 psi @Temperature 75.2 °F	Overlap, ABS
	6.62 MPa @Temperature 24.0 °C	960 psi @Temperature 75.2 °F	Overlap, Rigid PVC
	6.89 MPa @Temperature -40.0 °C	1000 psi @Temperature -40.0 °F	Overlap, Solvent Wiped Al

Mechanical Properties	Metric 0.89 MPa	English 1000 psi	Comments
	@Temperature -40.0 °C	@Temperature -40.0 °F	Overlap, Solvent Wiped Steel
	6.89 MPa	1000 psi	Overlap, Solvent Wiped Al
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	7.93 MPa	1150 psi	Overlap, FRP, Substrate Failure
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	8.27 MPa	1200 psi	Overlap, Abraded and Solvent Wiped Steel
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	8.55 MPa	1240 psi	Overlap, Lexan, Substrate Failure
	@Temperature -40.0 °C	@Temperature -40.0 °F	
	8.96 MPa	1300 psi	Overlap, Plexiglass
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	11.4 MPa	1660 psi	Overlap, FRP, Substrate Failure
	@Temperature -40.0 °C	@Temperature -40.0 °F	
	12.7 MPa	1840 psi	Overlap, Lexan, Substrate Failure
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	13.8 MPa	2000 psi	Overlap, Abraded and Solvent Wiped Steel
	@Temperature -40.0 °C	@Temperature -40.0 °F	
	13.8 MPa	2000 psi	Overlap
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	13.8 MPa	2000 psi	Overlap, Etched Aluminum
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	13.8 MPa	2000 psi	Overlap, Abraded and Solvent Wiped Al
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	13.8 MPa	2000 psi	Overlap, Abraded and Solvent Wiped Al
	@Temperature -40.0 °C	@Temperature -40.0 °F	
	17.2 MPa	2500 psi	Overlap, Etched Aluminum
	@Temperature -40.0 °C	@Temperature -40.0 °F	
	17.2 MPa	2500 psi	Overlap
	@Temperature -55.0 °C	@Temperature -67.0 °F	

Peel Strength	4.38 kN/m	25.0 pli	T-Peel
Mechanical Properties	Metric	English	Comments
Processing Properties	Metric	English	Comments
Cure Time	30.0 min	0.500 hour	
	480 min	8.00 hour	Full Cure

Descriptive Properties	Value	Comments
Appearance	Brown	Accelerator
	Off-White	Base

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