



## 3M™ Scotch-Weld™ Instant Adhesives (cont.)

Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range	Time to Handling	Full Cure (Hr)	Size	UPC	Stock #
<b>3M™ Scotch-Weld™ Instant Adhesives — Super Fast</b>								
<b>SF20</b> (Clear)	Fast cure, Optimum performance on wide range of rubbers and plastics	20	-65° to 180°F (-54° to 82°C)	4–30 sec	24	20g bottle 500g bottle	00-051111-91667-4 00-051115-25790-2	7100049744 7100039254
<b>SF100</b> (Clear)	Fast cure, high strength with EPDM and other elastomers	100	-65° to 180°F (-54° to 82°C)	4–30 sec	24	3g tube 20g bottle 500g bottle	00-048011-62630-7 00-048011-62631-4 00-048011-62629-1	7100039207 7100039206 7100039208
<b>3M™ Scotch-Weld™ Instant Adhesives — Rubber Toughened</b>								
<b>RT5000B</b> (Black)	Rubber toughened for impact resistance, High viscosity for minor gap filling	5,000	-65° to 180°F (-54° to 82°C)	30 sec	24	20g bottle 500g bottle	00-051111-91665-0 00-051115-25200-6	7100039251 7100039252
<b>3M™ Scotch-Weld™ Instant Adhesives — Engineered Grade</b>								
<b>CA4</b>	Fast setting for a variety of plastics and rubbers	150	-65° to 180°F (-54° to 82°C)	5–40 sec	24	2g tube 1 oz bottle 1 lb. bottle	00-021200-96601-9 00-021200-96600-2 00-021200-96597-5	7010366320 7000028586 7000028587
<b>CA5</b>	Higher viscosity, slower setting version of CA4 for filling gaps, Meets CID A-A-3097, Type II, Class 3	2,000	-65° to 180°F (-54° to 82°C)	12–60 sec	24	1 oz bottle 1 lb. bottle	00-021200-74289-7 00-021200-74288-0	7000046524 7010367474
<b>CA7</b>	Very fast setting, Excellent metal bonder, Better shock and impact resistance	15-40	-65° to 212°F (-54° to 100°C)	1–30 sec	24	1 oz bottle 1 lb. bottle	00-021200-21061-7 00-021200-21062-4	7000121352 7000121353
<b>CA8</b>	Rapid setting, Excellent adhesion to metals, plastics and rubbers, Meets CID A-A-3097, Type II, Class 2	70-130	-65° to 180°F (-54° to 82°C)	5–40 sec	24	2g tube 1 oz bottle 1 lb. bottle	00-021200-21065-5 00-021200-21066-2 00-021200-21067-9	7000121354 7000046526 7000046527
<b>CA9</b>	Slower setting for parts alignment, Useful for wire tracking and coil terminating, Meets CID A-A3097, Type II, Class 3	1,000–1,700	-65° to 180°F (-54° to 82°C)	20–70 sec	24	1 oz bottle 1 lb. bottle	00-021200-21068-6 00-021200-21069-3	7000046528 7010299373
<b>CA40</b>	Very fast setting, Excellent adhesion to many substrates including flexible vinyl and EPDM rubber	20	-65° to 180°F (-54° to 82°C)	3–20 sec	24	1 oz bottle 1 lb. bottle	00-021200-74290-3 00-021200-74291-0	7000000893 7000000894
<b>CA40H</b>	Higher viscosity version of CA40, Better void filling capabilities	400–600	-65° to 212°F (-54° to 100°C)	5–40 sec	24	1 oz bottle 1 lb. bottle	00-021200-21073-0 00-021200-21074-7	7000000895 7000000896
<b>CA50 Gel</b>	High-viscosity, non-sag gel, Less sensitive to acidic surfaces	45,000–85,000	-65° to 212°F (-54° to 100°C)	60–120 sec	24	20g tube 200g cart.	00-021200-82332-9 00-021200-83737-1	7100002517 7000000899
<b>CA100</b>	High peel and impact strength, shock and heat resistance	2,500–4,500	-65° to 212°F (-54° to 100°C)	20–70 sec	24	1 oz bottle 1 lb. bottle	00-021200-82334-3 00-021200-82335-0	7000000900 7000000901

For lead times on bulk adhesives, please contact your 3M representative.

**Key Product** Denotes product to consider first in this category. **\*** After Key Products, consider these.

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

### 3M™ Scotch-Weld™ Instant Adhesives (cont.)



292

Product (Color)	Key Features	Typical Viscosity (cP)	Time to Handling	Full Cure (Hr)	Size	UPC	Stock #
<b>3M™ Scotch-Weld™ Instant Adhesive Primers &amp; Activators</b>							
<b>AC09</b>	Instant adhesive activator, Non-flammable, solvent-based, California compliant	1	1–5 sec	24	2 fl oz bottle	00-051111-07795-5	7010366543
<b>AC77</b>	Instant adhesive primer for bonding of difficult-to-bond plastics such as polyethylene, polypropylene and polyacetal	<3	1–5 sec	24	2 fl oz bottle 1 gal can	00-048011-62728-1 00-638060-40067-8	7100039260 7100190206
<b>AC79</b>	Instant adhesive primer for bonding of difficult-to-bond elastomers such as silicone, fluoroelastomer and EPDM, VOC compliant	2	1–5 sec	24	2 fl oz bottle 8 fl oz bottle 4L can	00-051115-31388-2 00-051115-31389-9 00-051115-31390-5	7100039262 7100039264 7100039265
<b>AC113</b>	Instant adhesive general purpose accelerator, Will not attack plastics	<3	1–5 sec	24	8 fl oz bottle	00-048011-62682-6	7100079891
<b>AC452</b>	Instant adhesive acetone-based accelerator flashes off rapidly, Excellent adhesion, Overspray may attack some plastics	<2	1–5 sec	24	8 fl oz bottle 4L can	00-048011-62686-4 00-048011-62689-5	7010295349 7010366542
<b>Surface Activator</b>	Clear, colorless organic-based liquid helps speed curing and prime surfaces, Comes with brush and spray pump	<10	1–5 sec	24	2 fl oz bottle	00-021200-87937-1	7000046525

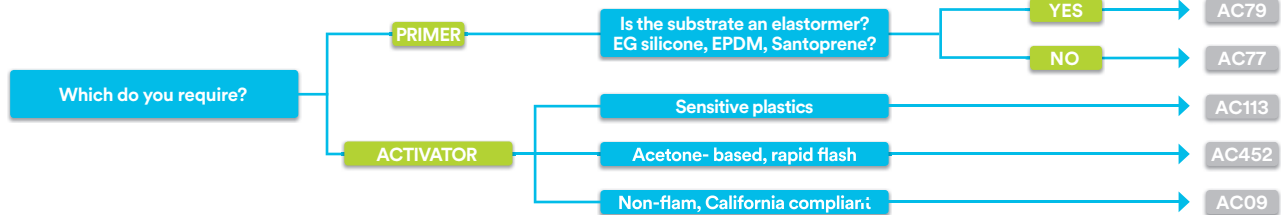
For lead times on bulk adhesives, please contact your 3M representative.

**Key Product** Denotes product to consider first in this category. \* After Key Products, consider these.

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

85

#### SURFACE PREPARATION



#### 3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesives

3M's Engineered Grade Instant Adhesives combine high performance, excellent adhesion and temperature resistance with the speed of instant adhesives — providing you with differentiated capabilities for your most difficult thin bond line applications.

**Key Products**  
CA5, CA40, CA40H, CA50 Gel

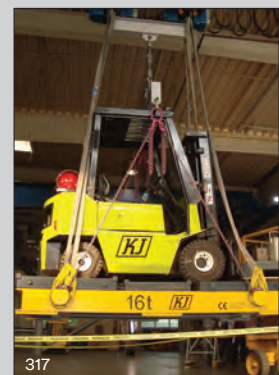


83

#### 3M™ Scotch-Weld™ Engineered Grade Instant Adhesives

The PR (Plastic & Rubber) series of products bonds to most plastics and rubbers with a range of viscosities that will fit all your application needs. Just a single drop per square inch bonds several thousand pounds of holding power. They provide proven, world record strength with a hold of 8 metric tons.

**Key Products**  
PR40, PR100, PR600, PR1500, PRGel



317