

3M

Scotch-Grip™

Rubber & Gasket Adhesive

2141

Technical Data

August, 2002

Features

- A light colored, high strength adhesive with a long tack range.
- Excellent water, oil and grease resistance.
- Bonds neoprene, natural, reclaim, SB-R and butyl rubber to most substrates.

Typical Physical Properties

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

Viscosity (approx.):	900 - 1500 cps
Brookfield Viscometer:	RVF #2 Sp. @ 20 rpm @ 80°F (27°C)
Solids (by wt.):	28 - 32%
Base:	Polychloroprene
Color:	Yellow
Net weight (approx.):	7.0 - 7.4 lbs./gal.
Flash point:	-14°F [-26°C] (T.C.C.)
Solvent:	Petroleum Distillate, Toluene, Acetone and n-Hexane
Coverage (approx.): @ 2.5 gms. (dry wt.)/ft.²	392 ft. ² /gal.

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Handling/Application Information

Directions For Use:

1. **Surface Preparation:** Surfaces must be clean, dry and dust free. Wiping with solvent such as 3M™ Scotch-Grip™ Solvent No. 3 or Methyl Ethyl Ketone (MEK) will aid in removing oil and dirt.*
 2. **Application Temperature:** For best results the temperature of the adhesive and the surfaces being bonded should be at least 65°F (18°C).
 3. **Application:** Stir or agitate well before using.
Porous Surface: Apply a uniform generous brush coat of adhesive to one or both surfaces. Highest strengths are obtained when both surfaces are coated. Highly absorbent materials may require two coats.
Non-Porous Surface: Brush an even coat of adhesive on both surfaces. Press surfaces together firmly to ensure contact.
 4. **Drying Time:** When apply adhesive to only one surface the bond must be made immediately, while the adhesive is wet. When applying adhesive to both surfaces allow the adhesive to dry until tacky, but does not transfer to knuckle when touched (typically 5-10 minutes, depending on temperature, humidity, etc.).
 5. **Bonding:** After drying, you have up to 15 minutes to make the bond. Press surfaces together firmly to ensure contact.
 6. **Cleanup:** Excess adhesive may be removed with solvent such as 3M™ Scotch-Grip™ Solvent No. 2 or 3 or MEK, or 3M™ Citrus Base Industrial Cleaner.*
- *Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

Application Equipment Suggestions

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. **Pumping:**
 - A. **5 gallon or less dispensing system:** Use a pressure pot rated for 100 psi operating pressure.
 - B. **55 gallon dispensing system:** Use a 2:1 ratio divorced design double acting ball check type pump, bung mounted. Packings and glands in contact with the adhesive should be Teflon®*

*Teflon is a registered trademark of E.I. duPont deNemours and Co.
2. **Hoses:** All material hoses should be nylon lined.
3. **Brushes:** Brushes designed to be used with oil based paints may be used.

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**Typical Adhesive
 Performance
 Characteristics**

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Adhesive was brush applied to substrates and bonded while still tacky. The bonds were then tested in 180° peel and shear after aging for times indicated.

180° Peel Strength – Canvas/Steel

Overlap Shear Strength – 1/8" Birch/Birch

Time @75°F (24°C)	Test Temperature	Value (lbs./in. width)	Time @75°F (24°C)	Test Temperature	Value (psi)
1 day	75°F (24°C)	6	3 weeks after 3 weeks	75°F (24°C) 180°F (82°C)	377 68
3 days	75°F (24°C)	10			
5 days	75°F (24°C)	24			
7 days	75°F (24°C)	32			
2 weeks	75°F (24°C)	32			
3 weeks	75°F (24°C)	30			
after 3 weeks	-30°F (-34°C)	14			
after 3 weeks	150°F (66°C)	24			
after 3 weeks	180°F (82°C)	22			

Storage

Store product at 60-80°F (15-26°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a “first-in first-out” basis.

Shelf Life

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 15 months.

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Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit www.3M.com/adhesives. Address correspondence to: 3M Engineered Adhesives Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

Important Notice

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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If the 3M product is proved to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including, but not limited to, contract, negligence, warranty, or strict liability.

ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



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