



Scotch-Weld™

Instant Adhesives

Technical Data

May 2019

Product Description	3M™ Scotch-Weld™ Instant Adhesives are single component, high strength cyanoacrylate adhesives.
Features	• One component, high strength adhesives that cure at room temperature. • Products provide varying cure times, bond strengths, and viscosities. • Can be used to bond a variety of substrates including many rubbers, plastics, and metals. • Economical to use as it requires only drops of adhesive to provide strong bonds to many metals, plastics, and rubbers.
Description	3M™ Scotch-Weld™ Instant Adhesive CA4 is a high-strength, very fast setting, multi-purpose cyanoacrylate adhesive that cures at room temperature with very low bonding pressures. It has particularly good adhesion to most cured rubbers. 3M™ Scotch-Weld™ Instant Adhesive CA5 is a high-strength, slow setting cyanoacrylate adhesive that cures at room temperature. Its relatively high viscosity is especially useful where some gap filling is desired for bonding rough or uneven surfaces. The longer set rate allows more time for proper alignment of parts to be bonded. Meets CID A-A-3097, Type II, Class 3. 3M™ Scotch-Weld™ Instant Adhesive CA7 is a high-strength, extremely fast setting cyanoacrylate adhesive that cures quickly at room temperature. It has excellent adhesion to many metals, plastics and rubbers, and produces bonds with more shock and impact resistance than many typical cyanoacrylate adhesives. 3M™ Scotch-Weld™ Instant Adhesive CA8 is a high-strength, rapid-setting cyanoacrylate adhesive that cures at room temperature. It has excellent adhesion to many metals, plastics and rubbers, and produces bonds with more shock resistance than many typical cyanoacrylate adhesives. Meets CID A-A-3097, Type II, Class 2.

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Description (*continued*) 3M™ Scotch-Weld™ Instant Adhesive CA9 is a high-strength cyanoacrylate adhesive that cures slower than many cyanoacrylates at room temperature. The longer set rate allows more time for proper alignment of parts before bonding takes place. It has excellent adhesion to many metals, plastics and rubbers, and produces bonds with more shock and impact resistance than many typical cyanoacrylate adhesives. Meets CID A-A-3097, Type II, Class 3.

3M™ Scotch-Weld™ Instant Adhesive CA40 is a high-strength, very fast-setting cyanoacrylate adhesive that cures at room temperature with very low bonding pressures. It has particularly good adhesion to many difficult to bond substrates such as EPDM rubber, aluminum and flexible vinyl.

3M™ Scotch-Weld™ Instant Adhesive CA40H is a high-strength cyanoacrylate adhesive. It is a higher viscosity, slightly slower setting version of Scotch-Weld CA40. It has particularly good adhesion to many difficult to bond substrates, such as aluminum, EPDM rubber, and flexible vinyl. Scotch-Weld CA40H exhibits good resistance to soap solutions and isopropyl alcohol. Its high viscosity helps prevent run off during application, and its slower set time allows additional time for proper alignment of parts.

3M™ Scotch-Weld™ Instant Adhesive Gel CA50 is a high-strength, surface insensitive, gel cyanoacrylate adhesive. Its gel consistency allows it to be used in many non-sag vertical applications, and to fill gaps up to .020 inches. The very slow cure rate allows plenty of time to reposition parts. Meets CID A-A-3097, Type II, Class 5.

3M™ Scotch-Weld™ Instant Adhesive CA100 is a high-strength cyanoacrylate adhesive. Its relatively high viscosity (approximately 3000 cps) allows gap-filling capability up to .020 inches. It has high T-Peel strength, thermal shock resistance, impact resistance, and excellent metal bonding capabilities. Meets CID A-A-3097, Type II, Class 3.

3M™ Scotch-Weld™ Instant Adhesives

Typical Physical Properties (uncured)

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

Product	3M™ Scotch-Weld™ Instant Adhesive								
	CA4	CA5	CA7	CA8	CA9	CA40	CA40H	Gel CA50	CA100
Color	Colorless	Colorless	Colorless	Colorless	Colorless	Colorless	Colorless	Colorless	Colorless
Base	Ethyl	Ethyl	Methyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl
Viscosity (cps)	150	2000	15-40	70-130	1000-1700	20	400-600	20,000-50,000	2500-4500
Temperature Range	-65°F (-54°C) – 180°F (82°C)						-65°F (-54°C) – 212°F (100°C)		
Specific Gravity	1.05	1.05	1.05	1.05	1.05	1.05	1.05	1.08	1.05
Net Weight (lbs/gal)	8.7	8.7	8.7	8.7	8.7	8.7	8.7	9.0	8.7

Typical Physical Properties (cured)

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

Product	3M™ Scotch-Weld™ Instant Adhesive								
	CA4	CA5	CA7	CA8	CA9	CA40	CA40H	Gel CA50	CA100
Time to Handling Strength (seconds)	5-40	12-60	1-30	5-40	20-70	3-20	5-40	60-120	20-70

Overlap Shear Strength Tested at 75°F [23°C] (psi)

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

Product	3M™ Scotch-Weld™ Instant Adhesive								
	CA4	CA5	CA7	CA8	CA9	CA40	CA40H	Gel CA50	CA100
Steel	2300	2500	2500	2000	2000	1700	1500	2000	2000
Aluminum - etched	2800	600	2400	2100	2400	2600	1500	900	2900
ABS	800*	800*	900*	900*	900*	800*	900*	800*	600*
PVC	800*	800*	1000*	1000*	1000*	800*	1000*	600*	700*

Overlap Shear Metal to Metal Bond Strength tested @ 75°F (23°C) (psi)

Tensile Lap Shear Strength (as defined in ASTM-D-1002) - cured 48 hours at 68°F (20°C) - 60% Relative Humidity - abraded and acetone wiped - test specimen is 1/2 sq. in. bond tested @ .1 in./minute loading rate.

*Substrate Failure

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Surface Preparation	For optimum strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation depends on the required bond strength and the environmental aging resistance desired by the user. Metals (Steel and Aluminum): 1. Wipe free of dust with oil-free solvent such as acetone or isopropyl alcohol. * 2. Sandblast or abrade using clean fine grit abrasives. 3. Wipe again with solvent to remove loose particles. Aluminum Etching: 1. Alkaline Degrease: Oakite 164 solution (9-11 oz./gallon water) at 190°F ± 10°F (88°C ± 5°C) for 10-20 minutes. Rinse immediately in large quantities of cold running water. 2. Acid Etch: Place panels in the following solution for 10 minutes at 150°F ± 5°F (66°C ± 2°C). <table><tr><td>Sodium Dichromate</td><td>4.1 - 4.9 oz./gallon</td></tr><tr><td>Sulfuric Acid, 66°Be</td><td>38.5 - 41.5 oz./gallon</td></tr><tr><td>2024-T3 aluminum (dissolved)</td><td>0.2 oz./gallon</td></tr><tr><td colspan="2">minimum Tap water as needed to balance</td></tr></table> 3. Rinse: Rinse panels in clear running tap water. 4. Dry: Air dry 15 minutes; force dry 10 minutes at 150°F ± 10°F (66°C ± 5°C). 5. If primer is to be used, it should be applied within 4 hours after surface preparation. Plastics/Rubber: 1. Wipe with Isopropyl Alcohol. * 2. Abrade using clean fine grit abrasives. 3. Wipe with Isopropyl Alcohol. * *Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.	Sodium Dichromate	4.1 - 4.9 oz./gallon	Sulfuric Acid, 66°Be	38.5 - 41.5 oz./gallon	2024-T3 aluminum (dissolved)	0.2 oz./gallon	minimum Tap water as needed to balance	
Sodium Dichromate	4.1 - 4.9 oz./gallon								
Sulfuric Acid, 66°Be	38.5 - 41.5 oz./gallon								
2024-T3 aluminum (dissolved)	0.2 oz./gallon								
minimum Tap water as needed to balance									
Handling 80°F	For short term storage (30 days), keep adhesive in a cool, dry place 60 to (16-27°C). For long term storage, refrigeration (40°F [4°C] or below) is suggested. Keep containers tightly covered and free of moisture. Polymerization is accelerated by sunlight, so avoid direct exposure to sun. One Ounce Bottles: At end of day, clear tip of dispensing nozzle by inserting a needle to prevent clogging. Wipe outside of nozzle to remove excess adhesive with a folded non-cotton cloth or tissue. Replace cap. One Pound Bottles: At end of day, remove cap-stem assembly and place overnight in nitromethane or methyl ethyl ketone. * Seal bottle with shipping cap. *Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.								

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Storage	Store in original containers at or below 80°F (27°C).
Shelf Life	These products can be expected to have at least nine months shelf life. At lower temperature, the shelf life will be longer. Lower temperatures cause increased viscosity of a temporary nature and will cause water to condense on the container. Therefore, containers stored at low temperatures should be allowed to return to room temperature before opening so that water does not come in contact with the adhesive and cause adhesive gelation.
Precautionary Information	Refer to Product Label and 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.
Technical Information	The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.
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**Industrial Business
Industrial Adhesives and Tapes Division**

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