



Scotch-Weld™ Cyanoacrylate Adhesive XF100

Product Data Sheet

Updated : February 2010
Supersedes: February 2007

Product Description	Scotch-Weld XF100 is a very fast curing, medium low viscosity modified Ethyl Cyanoacrylate adhesive. It is suitable for the bonding of a very wide range of materials, including acidic surfaces and some porous ones, where rapid bonding times are required.
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Key Features	XF100 is especially formulated for instant bonding of paper, leather, wood, plastics, rubbers, metals and other common substrates. Although XF100 has a degree of gap filling ability, it is generally recommended for use on close-fitting parts and fairly smooth, even surfaces.
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Physical Properties	Base Ethyl Cyanoacrylate
	Soluble In Acetone, MEK
	Viscosity (cps) Range 90-130 Typical value 110
	Specific Gravity 1.06
	Colour Clear

Performance Characteristics	Maximum Gap Fill (best results are obtained with very thin bond lines) 0.15mm
	Fixture Time 1-30secs
	Tensile Strength MPa (ISO 6922) - after 2 minutes 7.5 – 12.5 - after 24 hours 15 - 25
	Full Cure 24hrs
	Speed of Cure The speed of cure of cyanoacrylates varies according to the substrate to be bonded. Acidic surfaces such as paper and leather will have longer cure times than most plastics and rubbers.
	Moisture Resistance Low resistance to high levels of moisture and humidity over time.
	Service Temperature Range -50 to +80°C

Additional Product Information	Scotch-Weld Activators AC11 and AC12 may be used in conjunction with RITE-LOK cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most Scotch-Weld cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30%.
Application Techniques	Bond speed is very fast so ensure that parts are properly aligned before bonding. Scotch-Weld Activators may be required if there are gaps or porous surfaces. Some plastics may require application of Scotch-Weld AC77 Primer. Ensure parts are clean, dry and free from oil and grease. Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.
Storage Conditions	Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months. Refrigeration to 5°C gives optimum storage stability.
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C
Precautionary Information	Refer to product label and material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com
For Additional Information	To request additional information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA
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