



3M™ Spray 80 Neoprene Contact Adhesive

Product Data Sheet

Updated : February 2004
Supersedes : August 1995

Product Description

Spray 80 Adhesive is a high performance plasticiser resistance neoprene contact adhesive. It features the high strength performance normally associated with bulk sprayable and brushable contact adhesives.

The good plasticiser resistance plus the ability to produce high strength heat resistant bonds to most substrates makes Spray 80 Adhesive ideal for many demanding jobs.

The controlled lace like pattern provides reduced overspray and misting allowing accurate adhesive application. The aerosol applied adhesive dries quickly, allowing bonds to be made three minutes after adhesive application. For operations requiring a longer bonding range you have up to 15 minutes to make the bond.

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

Physical Properties

Not for specification purposes

| | |
|--------------------|---|
| Base | Neoprene Elastomer |
| Solvent | Cyclohexane, Toluene and Methyl Acetate |
| Flash Point | -45°C approximately |
| Propellant | Dimethyl Ether |
| Contents | 530g (664 ml) |
| Consistency | Thin liquid |
| Colour | Cloudy pale yellow |

Physical Properties
 Not for specification purposes

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|-------------------|--|
| Shelf Life | 12 months from date of receipt by the customer when stored in original carton at 21°C (70°F) & 50% Relative Humidity |
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Performance Characteristics
 Not for specification purposes

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|----------------------------------|-----------------|
| Service Temperature Range | -30°C to + 92°C |
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Performance Characteristics Cont'd
 Not for specification purposes

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|------------------------------------|-----------|
| Water Resistance | Very Good |
| Heat Resistance | Good |
| Weathering Resistance | Good |
| Plasticiser/ Oil Resistance | Good |

Additional Product Information

Peel Adhesion: 89 N/25 mm width minimum

180° Peel adhesion- Canvas (No.10 Cotton Duck) from Steel after 24 hours at 23° C. Bonds were made at a 5 minutes open time and pulled in 180° peel at the rate of 50 mm per minute

Directions for Use

1. Ensure all surfaces to be bonded are clean, dry and free from dust, oil or grease before application of adhesive.
2. Ensure that the nozzle points toward the surface to be sprayed.
3. Turn the nozzle so that the tip points to the dot on the can rim.
4. Shake the can well before use. 10-20 seconds should be sufficient. An agitator ball has been introduced to ensure that the product is efficiently mixed with a minimum time of shaking.
5. Place materials to be bonded on a horizontal position. Hold the can 15-20 cm from the surface to be sprayed, keeping the can at an angle of 45 degrees. Apply at least two uniform and overlapping coats of adhesive to both surfaces to be bonded.
6. While spraying:
 - a) Release the nozzle at the end of each pass across the surface being sprayed and depress the nozzle once the can begin to move on the return travel
 - b) Push the nozzle of the can all the way down to avoid spluttering and to produce a uniform pattern.
7. After application, allow at least 3 minutes drying time before bonding.
8. Wipe tip with a rag soaked in Scotch Grip™ Solvent No.2 whenever build up of adhesive is observed.
9. To prevent nozzle from blocking, at the end of each day turn the can upside down and press the tip until the spray is clear of adhesive and wipe tip with a rag soaked in Scotch Grip™ Solvent No.2.
10. For operations requiring longer bonding range you have up to 15 minutes to make the bond.

Clean up:

Excess of adhesive may be removed using Scotch- Grip Solvent No.2. The spray insert of the aerosol actuator used with Spray 80 Aerosol causes some adhesive build- up which make cause the spray pattern to become narrow and non-uniform.

Adhesive Build up may be minimised by:

1. Shaking the can well before using.
2. Fully depressing the nozzle when spraying to avoid spluttering
Adhesive which, accumulates around the “V” portion of the spray tip opening may be removed by wiping the “V” portion of the tip insert with a rag soaked in Solvent No.2. If adhesive should plug the nozzle, remove the nozzle from the can and immerse in a container of Solvent No. 2. Return the nozzle to the aerosol can when the adhesive has been removed.

NOTE: Scotch Grip Solvent No. 2 is highly flammable. When using solvents for clean up it is essential that proper safety precautions are observed.

Coverage: 7 sq meters per can

Storage Conditions Cool, dry place at 16°C and 27°C for maximum storage life. Storage temperatures must not exceed 49°C.

Health and Safety
Information

Precautions:

Extremely flammable liquid and vapour. Moderate eye irritation. Keep away from heat and from sources of ignition including pilot lights and sparks. No smoking. Avoid prolonged breathing of vapours/ spray. Do not use in confined areas or areas with little air movement. Do not spray directly into eyes. Avoid prolonged or repeated contact with the skin. Keep out of reach of children

WARNING:

Pressurised container. Protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn, even after use. Do not spray on a naked flame or incandescent material.

First Aid:

Eye Contact:

Rinse immediately with plenty of water and seek medical advice.

Skin Contact:

Wash with soap and water.

For further information please contact our Toxicology Department at 3M Centre Tel (01344) 858000.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



Tapes & Adhesives

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