

# 3M

## Scotch-Weld™

### Industrial Adhesive

#### 4475

#### Technical Data

December, 2007

#### Features

- Dries quickly to a firm bond.
- Excellent resistance to water, plasticizer migration, many detergent and soap solutions, oils and grease.
- A general purpose adhesive for bonding most vinyls, ceramics, glass, leather and cloth to a variety of 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.

<b>Viscosity</b>	6,500 - 10,500
<b>Brookfield Viscometer</b>	RVF #5 sp. @ 20 rpm @ 80°F
<b>Solids Content (approx.)</b>	41-45% (by wt.)
<b>Base</b>	Synthetic Resin
<b>Color</b>	Clear
<b>Net Weight</b>	8.3 lbs./gal.
<b>Flash Point</b>	20°F CC
<b>Coverage</b>	487 sq. ft. per gallon (1 Mil Dry Film)
<b>Solvent</b>	methyl ethyl ketone (MEK)

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## Application Equipment Suggestions

**Note:** Appropriate application equipment can enhance adhesive performance. The user is responsible for evaluating application equipment in light of the user's particular purpose and method of application.

### 1. Pumping

#### 5-Gallon Pail Dispensing System

Pump – 9:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 4<sup>1</sup>/<sub>4</sub>" diameter air motor minimum.

Pail cover to be used to reduce solvent loss.

#### 55-Gallon Drum Dispensing System

Pump – 10:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 4<sup>1</sup>/<sub>4</sub>" diameter air motor minimum, Bung mount type.

### 2. Accessories

Hose – 1000 psi minimum working pressure, nylon lined. Flow rate at 40°F, 20 ft. of <sup>3</sup>/<sub>4</sub>-ID plus 10 ft. <sup>1</sup>/<sub>2</sub>-ID and a flow gun equals 1 pound/minute at pump air pressure of 75 psi.

### 3. Chemical Resistance Requirements

Synthetic materials in contact with this product must be resistant to ketones and aromatic solvents. Compare, nylon or Teflon® coatings are suggested for packings and gaskets.

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## Handling/Application Information

### Directions for Use

- 1. Surface Preparation:** Best results are achieved on clean, dry surfaces. Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone (MEK).\*
- 2. Application:** Apply adhesive to one or both surfaces (best results are obtained by coating both surfaces) and bond immediately using firm pressure.
- 3. Drying Time:** Allow to dry a minimum of 24 hours for maximum strength.
- 4. Cleanup:** Remove unhardened or hardened material with cloth dampened with a solvent such as methyl ethyl ketone (MEK).\*

**\*Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

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180° Peel Strength – Canvas/Steel		
Time @ 75°F	Test Temp.	Value (lbs./in. width)
1 day	75°F	13
3 days	75°F	24
5 days	75°F	27.5
7 days	75°F	32.5
2 wk.	75°F	35
3 wk.	75°F	44
after 3 wk.	-30°F	22
after 3 wk.	150°F	17
after 3 wk.	180°F	7

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## Storage

Best storage temperature is 60-80°F (16-27°C). Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a “first in, first out” basis.

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## Shelf Life

When stored at the recommended temperature in the original, unopened container, 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.

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## Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors 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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## Warranty and Limited Remedy

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**ISO 9001:2000**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



### Industrial Adhesives and Tapes Division

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