



# Scotch-Weld<sup>TM</sup> 847 Universal Adhesive

## Product Data Sheet

Updated : October 2006

Supersedes : March 1996

### Product Description

847 adhesive is a high strength, fast setting nitrile based adhesive. It has excellent resistance to oil, fuel and other aliphatic hydrocarbons, and is resistant to most migratory plasticisers.

847 adhesive is suitable for bonding nitrile and other rubbers to metal, glass, plastics and most other surfaces. It is also suitable for bonding gaskets to oil filters etc.

847 adhesive is widely used in the electronic, radio and TV industries.

### Physical Properties

Not for specification purposes

<b>Base</b>	Nitrile Rubber	
<b>Solvent</b>	Acetone	
<b>Flash Point</b>	-17°C	
<b>Solids Content</b>	36% typical	
<b>Specific Gravity</b>	0.89 typical	
<b>Viscosity</b> (Brookfield RVF)	1600 cps typical (#3 spindle, 20rpm)	
<b>Colour</b>	Dark Brown	
<b>Shelf Life</b>	15 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

### Performance

#### Characteristics

Not for specification purposes

<b>180 Peel Strength</b>	Canvas/Aluminium (3M test method C 4013e)	<b>C 4013 e:</b> Speed of pulling : 50mm/min.
<b>Time at 23°C</b>	<b>Test Temperature</b>	<b>Value (daN/cm)</b>
1 hour 96 hours	23°C 23°C	5.4 10.7
<b>Oil resistance</b>	(3M test method C 4013g)	<b>C 4013 g:</b> Canvas/alu peel samples are cured for 72 hours at 23°C, + 24 hours in oil at 70°C
<b>Time at 70°C</b>	<b>Test Temperature</b>	<b>Value (daN/cm)</b>
24 hours in oil	23°C	7.0

**Heat Resistance**

(3M test method C 4013 h)

**C 4013 h:**

Canvas/alu peel samples are cured for 18 hours at 23°C + 24 hours at 70°C. A weight of 1 kg is applied on the canvas so as the angle between canvas and

aluminium if of 90°C. The assembly is heated to 70°C for 24 hours. After this time, the distance of failure is measured.

Time at 70°C	Test Temperature	Value (mm)
24 hours	70°C	10.0

**Guide Line**

Following are typical values obtained in 3M Laboratory.

Time at 24°C	Test Temperature	180° Peel Strength Canvas/Steel (daN/cm)	Overlap Shear Strength Birch/Birch (MPa)
1 day	24°C	2.2	-
3 days	24°C	4.0	-
5 days	24°C	4.8	-
7 days	24°C	5.4	-
2 weeks	24°C	6.0	-
3 weeks	24°C	7.0	1.0
3 weeks	-35°C	3.5	1.4
3 weeks	66°C	2.8	0.2
3 weeks	82°C	1.5	0.1

**Drying Time**

Application temperature range : 15 to 30°C.

Temperature of Film	Time for Cure (minutes)
95°C	120
115°C	40
135°C	12
160°C	8
180°C	5
200°C	2

**Storage Conditions**

Store product between 16°C and 27°C for maximum storage life.

**Directions for Use****Surface Preparation:**

Surfaces must be clean, dry and free from oil or greasy film.

**Application:**

Stir well before using. Apply a thin even coat to one or both surfaces by brush, knife coater, flow gun, notched scraper or other spreading method. Coating both surfaces is preferred since it gives greater strength and permits longer open time before bonding.

**Coverage:**

Approximately 12m<sup>2</sup>/litre for a medium brush coat application (0.025mm dry film).

**Porous Surface:**

Very absorbent materials may require more than one coat. Bond while adhesive is still wet or aggressively tacky.

**Non Porous Surface:**

Allow adhesive to dry until it is tacky, but does not transfer when touched. Join surfaces with firm pressure

**Directions for Use  
Cont'd ....****Drying Time:**

Open time for a one surface application is 3 to 10 minutes or 10 to 50 minutes for a two surfaces application.

Drying time depends on temperature, humidity, air movement and porosity of the materials bonded. This product in the bonded assembly may be heat cured to obtain bond strength.

**Clean Up:**

Excess adhesive may be removed with 3M Solvent No. 2 or Industrial Cleaner. When using solvents for clean up it is essential that safety precautions are observed.

**Reactivation:**

Greater immediate strength may be obtained by solvent reactivation or heat reactivation.

**Solvent Reactivation:**

Allow adhesive to dry completely. Wipe adhesive film rapidly with a cloth moistened in either ketone or ester type solvent and complete the bond in the regular manner. If coated areas are kept clean, films of 847 may be solvent reactivated up to six months after application.

**Heat Reactivation:**

Allow adhesive to air dry completely. Join surfaces and heat in oven, press, or under lamps at 120°C to 150°C. Allowance must be made for transfer of heat through mating parts to the adhesive film. Enough pressure should be applied during heating to ensure intimate contact. Surfaces may be pre-coated up to 7 days in advance of complete bonding. If desired, to obtain superior properties, heat cure the adhesive.

**Health and Safety  
Information**

Highly flammable. May cause eye irritation. Keep away from heat. Keep away from sources of ignition, including pilot lights and sparks. No smoking. Keep container tightly closed. Avoid eye contact, prolonged skin contact and prolonged breathing of vapour. Use only in well ventilated areas. Take precautionary measures against static discharges.

**First Aid:****Eye Contact:**

Rinse immediately with plenty of water and seek medical advice.

**Skin Contact:**

Wash with soap and water.

**Keep out of reach of children.**

For further Health and Safety information, please contact the Toxicology Department at Bracknell Technical Centre on (01344) 860678.

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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.

**Industrial Adhesives & Tapes Division**

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