

# 3M

## Scotch-Weld™

### Plastic Adhesive

#### 2262

Technical Data

September, 2010

#### Features

- 3M™ Scotch-Weld™ Plastic Adhesive 2262 is a high strength adhesive with exceptional resistance to plasticizer migration and bonds vinyl extrusions, flexible and rigid vinyls.
- Scotch-Weld Plastic Adhesive 2262 dries clear, is non-staining and features a very quick tacking, relatively short bonding range.

#### 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 (approx.):</b>	375 - 675 cps
<b>Brookfield Viscometer:</b>	RVF #2 Sp. @ 20 rpm @ 80°F (27°C)
<b>Solids (by wt.):</b>	25 - 28%
<b>Base:</b>	Synthetic Resin
<b>Color:</b>	Clear
<b>Net weight (approx.):</b>	7.1 - 7.5 lbs./gal.
<b>Flash point:</b>	0°F (-18°C)
<b>Solvent:</b>	Acetone, THF

# 3M™ Scotch-Weld™ Plastic Adhesive 2262

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## Handling/Application Information

### Directions for Use:

1. **Surface Preparation:** Surfaces must be clean, dry and dust free. Wiping with a solvent such as methyl ethyl ketone (MEK)\* will aid in removing oil and dirt.
2. **Application Temperature:** For best results, the temperature of the adhesive and the surfaces being bonded should be at least 65°F (18°C).
3. **Application:** Brush a uniform coat of adhesive on both surfaces.
4. **Drying Time:** Allow adhesive to dry until tacky but does not transfer to knuckle when touched (typically about 5 minutes depending on temperature, humidity, etc).
5. **Bonding:** When the adhesive dries to the tacky stage, you have up to 20 minutes to complete the bond. Combine the surfaces using firm pressure to ensure good contact.
6. **Cleanup:** Excess adhesive may be removed with a solvent such as methyl ethyl ketone (MEK),\* preferably while the adhesive is still wet.

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

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## Application Equipment Suggestions

**Note:** Appropriate application equipment enhances adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

1. **Pumping:**
  - A. **5 gallon pail dispensing system:** Use a 2:1 ratio divorced design, double acting ball check type pump, 3 oz. per cycle, 2 inch air motor, syphon feed.
  - B. **55 gallon dispensing system:** Use a 2:1 ratio divorced design double acting ball check type pump, 3 oz. per cycle, 2 inch air motor, bung mounted.  
Glands and packings in contact with adhesive should be PTFE.
2. **Hoses:** Fluid hoses should be 200 psi working pressure minimum, nylon lined.
3. **Brushes:** Brushes designed to be used with oil based paints may be used.

# 3M™ Scotch-Weld™ Plastic Adhesive 2262

**Typical Adhesive  
Performance  
Characteristics**

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

**Peel Strength and Adhesion**

3M™ Scotch-Weld™ Plastic Adhesive 2262 was used to bond unsupported vinyl (a clad grade containing approximately 30 phr DOP\*) and supported vinyl to various substrates. Bonds were made by brush coating both surfaces; when the vinyl coated surface was slightly tacky (approximately 3-5 minutes), both surfaces were mated together and rolled to insure good contact. The bonds were subjected to various aging conditions and tested in 180° peel at a rate of 2 inches per minute.

**Peel Strength (piw)**

**Unsupported Vinyl:**

Aging Conditions				
Substrate	1 Day @ R.T.	7 Days @ R.T.	Plus 7 Days @ 140°F	Plus 7 Days @ 100% R.H.
Steel	7 s	17 s	20 s	17 s
Glass	8½ s	15 s	TV	0 s
Aluminum	8½ s	19 s	TV	TV
Polyester	7½ s	14½ s	21 s	17 s
Wood (Maple)	10½ s	20 s	TV	TV

**Supported Vinyl:**

Aging Conditions				
Substrate	1 Day @ R.T.	7 Days @ R.T.	Plus 7 Days @ 140°F	Plus 7 Days @ 100% R.H.
Glass	15 v	18 v	16 v	0 s
Aluminum	15 s	19 v	13 v	12 s
Polyester	16 v	16 v	14 v	13 v
Wood	15½ v	17½ v	14 v	17 v

Code: c - Adhesive failed cohesively      s - Bond failed in adhesion to indicated substrate  
v - Bond failed in adhesion to vinyl      TV - Vinyl tore before bond failed

**Note:** The above adhesion values will vary for other grades of vinyl depending upon the amount and type of plasticizer present.

\*30 parts per hundred resin of dioctyl phthalate plasticizer.

**Storage**

Store product at 60-80°F (15-26°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a “first-in first-out” basis.

**Shelf Life**

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 15 months.

# 3M™ Scotch-Weld™

## Plastic Adhesive

### 2262

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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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#### Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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#### Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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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.



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