



# Technical Data Sheet

## 3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesive PR Gel

### Product Description

3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesives are designed to give exceptional performance on difficult-to-bond plastic and rubber substrates. These adhesives may be bonded to like substrates or in combination with metal or composite substrates. Superior performance is achieved on materials such as heavily plasticized PVC, EPDM, ABS, Nylon, Santoprene®, and Viton®.

### Product Features

- 3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesive PR Gel is a fast curing, very high viscosity, gap-filling cyanoacrylate. Its gel formulation is suitable for bonding poorly mating components and for porous substrates and can be used on vertical surfaces as it will not drip or slump.

### Technical Information Note

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

### Typical Uncured Physical Properties

| Property | Values | Additional Information |
|----------|--------|------------------------|
| Color    | Clear  | <a href="#">View</a>   |

Notes: Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

|           |                    |                      |
|-----------|--------------------|----------------------|
| Viscosity | 100,000-150,000 cP | <a href="#">View</a> |
|-----------|--------------------|----------------------|

Notes: Brookfield viscosity, Spindle TC @ 2.5 rpm

|      |              |  |
|------|--------------|--|
| Base | Ethyl Hybrid |  |
|------|--------------|--|





### Typical Mixed Physical Properties

| Property                  | Values | Additional Information |
|---------------------------|--------|------------------------|
| Time to Handling Strength | <25 s  | <a href="#">View</a>   |

Notes: Min time between bond creation and ability to support a 5 psi tensile load. Open and set times determined by RT environment. Higher temps will lengthen open and set times, while lower temperatures will shorten open time and set time.

|                   |       |                      |
|-------------------|-------|----------------------|
| Time to Full Cure | 24 hr | <a href="#">View</a> |
|-------------------|-------|----------------------|

Temp C: 23C  
Temp F: 73F

|                             |         |  |
|-----------------------------|---------|--|
| Percent of Initial Strength | 100 %   | View  |
| Temp C: 23C<br>Temp F: 73F  |         |  |
| Percent of Initial Strength | 84 %    | View  |
| Temp F: 167F                |         |  |
| Percent of Initial Strength | 41 %    | View  |
| Temp F: 212F                |         |  |
| Percent of Initial Strength | 13 %    | View  |
| Temp F: 257F                |         |  |
| Gap Fill                    | 0.02 in |  |

## Typical Physical Properties

| Property         | Values   | Additional Information |
|------------------|----------|------------------------|
| Specific Gravity | 1.1 g/mL |                        |
| Appearance       | Liquid   |                        |

## Storage and Shelf Life

For short term storage (<30 days), keep adhesive in a cool (60°F to 80°F [16°C to 27°C]), dry place out of direct sunlight. Keep containers tightly covered and free of moisture. Refrigeration (40°F [4°C]) gives optimum long term storage stability.

3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesives can be expected to have a shelf life of 15 months from date of manufacture when stored under refrigerated conditions.

## Bottom Matter

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## Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical

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## Handling/Application Information

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### Directions for Use

1. Ensure that parts are clean, dry, and free from oil and grease.
2. An instant adhesive activator may be required if there are bonding gaps or porous substrate surfaces, if substrates are low surface energy plastics (e.g., polyethylene, polypropylene) or if substrates have acidic surfaces (e.g., paper, leather).
3. Bond speed is typically very fast so ensure that parts are properly aligned before dispensing.
4. 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 slower cure speed and lower bond strength.

### Surface Preparation

For optimum strength structural bonds, paint, oxide films, oils, dust, mold release agents, and all other surface contaminants must be completely removed. However, the amount of surface preparation depends on the required bond strength and the environmental aging resistance desired by the user. Typical quick surface preparation would include wiping with a clean solvent (such as isopropyl alcohol\*), abrading the surface with a clean fine abrasive, and then wiping again with a clean solvent to remove loose particles.

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

### Cured Bond Characteristics

1. Full bond strength will typically be achieved within a 24 hour cure time.
2. Low humidity or low temperature conditions will slow down the cure rate.
3. After curing, 3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesive bonds are suitable for use up to about 180°F (82°C).
4. Cyanoacrylate bond resistance to most oils and solvents is excellent. Long term humidity, moisture, or water immersion may affect the strength of a cured cyanoacrylate bond depending on the substrates and the bond gap. Testing is recommended to evaluate the effect.

## References

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| Property              | Values  |
|-----------------------|---|
| 3m.com Product Page   | <a href="https://www.3m.com/3M/en_US/p/d/b40066915/">https://www.3m.com/3M/en_US/p/d/b40066915/</a>   |
| Safety Data Sheet SDS | <a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=PR Gel">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=PR Gel</a> |

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## Family Group

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Link Tags:

- PR40
- PR100
- PR600
- PR1500
- PR Gel

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**Products**

**Time to Full Cure**

|        |       |
|--------|-------|
| PR Gel | 24 hr |
| PR100  | 24 hr |
| PR1500 | 24 hr |
| PR600  | 24 hr |
| PR40   | 24 hr |

## ISO Statement

This product was manufactured under a quality system registered to ISO 9001 standards.

## 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.

## Information

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