



# Technical Data Sheet

## 3M™ Scotch-Weld™ Super Fast Instant Adhesive SF100

### Product Description

3M™ Scotch-Weld™ Super Fast Instant Adhesives rely less on surface moisture for cure speed than standard cyanoacrylates. They are designed to join together difficult-to-bond plastics and rubbers, acidic and/or contaminated surfaces such as woods, leathers, cardboard, and oily surfaces. These cyanoacrylates can be used for a super fast cure in high speed production applications.

### Product Features

3M™ Scotch-Weld™ Super Fast Instant Adhesive SF100 is a low viscosity super fast cyanoacrylate.

### 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	70 to 110 cP	<a href="#">View</a>
Notes: Cone-Plate viscosity, CP75 at 3000/s shear rate		
Base	Ethyl Hybrid	

### Typical Mixed Physical Properties


Property	Values	Additional Information
Time to Handling Strength	<10 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  
Temp F: 73F

Percent of Initial Strength	75 %	View 
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Temp F: 167F

Percent of Initial Strength	59 %	View 
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Temp F: 212F

Percent of Initial Strength	18 %	View 
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Temp F: 257F

Gap Fill	0.006 in
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## Typical Physical Properties

Property	Values	Additional Information
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Specific Gravity	1.06 g/mL
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Appearance	Liquid
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## 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™ Super Fast Instant Adhesives can be expected to have a shelf life of 15 months from the date of manufacture when stored under refrigerated conditions.

## Bottom Matter

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## Trademarks

3M and Scotch-Weld are trademarks of 3M Company.

## Automotive Disclaimer

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## Handling/Application Information

### 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™ Super Fast 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

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/p/d/b40066913/">https://www.3m.com/3M/en_US/p/d/b40066913/</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=SF100">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=SF100</a>

## Family Group

Link Tags:

- SF20
- SF100

Products	Time to Full Cure
SF100	24 hr

SF20

24 hr

## ISO Statement

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

## Precautionary Information

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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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