

3M

Scotch-Weld™

Low Odor Instant Adhesives

LO100 • LO1000

Technical Data

April, 2016

Product Description

3M™ Scotch-Weld™ Low Odor Instant Adhesives are formulated to have low volatility while maintaining bonding of a wide range of materials. Low volatility means that these products are not only low odor but also low blooming. White residues (chlorosis) of the joint area are eliminated to improve appearance in cosmetically critical applications. Lower odor can improve worker comfort in work areas where ventilation is limited. These products reduce the requirement for sophisticated ventilation systems that may be necessary when dispensing other cyanoacrylates.

Specific Features

- 3M™ Scotch-Weld™ Low Odor Instant Adhesive LO100 is a low viscosity cyanoacrylate for general purpose low odor bonding.
- 3M™ Scotch-Weld™ Low Odor Instant Adhesive LO1000 is a high viscosity low odor cyanoacrylate that has good gap-filling capability.

3M™ Scotch-Weld™ Low Odor Instant Adhesives LO100 • LO1000

Typical Uncured Physical Properties

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

	3M™ Scotch-Weld™ Low Odor Instant Adhesives	
	LO100	LO1000
Color	Clear	Clear
Base	Methoxyethyl	Methoxyethyl
Appearance	Liquid	Liquid
Specific Gravity (g/ml)	1.06	1.08
Viscosity (cps) ¹	70-110 ^{1a}	850 - 1250 ^{1b}
Time to Handling Strength (sec)*	<20	<30
Time to full cure (hr)	24	24

^{1a} Cone-Plate viscosity, CP75 @ 3000/s shear rate ; ^{1b} Cone-Plate viscosity, CP50 @ 100/s shear rate; * On EPDM. Time to handling is substrate dependent

Typical Cured Properties

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	3M™ Scotch-Weld™ Low Odor Instant Adhesives	
	LO100	LO1000
Temperature Range (°F)	-60 to 180	-60 to 180
Gap Fill (in)	0.006	0.008
	Overlap Shear Strength (psi) ¹	
Steel ²	2300	2200
Stainless Steel ²	3200	3300
Aluminum ²	2800	2900
ABS	800 ³	850 ³
Polycarbonate	850 ³	750 ³
PVC	850 ³	1050 ³
Nylon	300	350
Polypropylene ⁴	480	500
Silicone Elastomer ⁵	70	50

¹ ASTM D-1002 ² Grit blasted ³ Substrate failure ⁴ Primed with AC77 ⁵ Primed with AC79

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Hot Strength

Temp (F)	Percent of Initial Strength	
	LO100	LO1000
72	100	100
167	58	56
212	23	23
257	5	10

Handling Information

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.

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.

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™ Low Odor Instant Adhesive bonds are suitable for use up to about 160°F (71°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.

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

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Storage	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.
Shelf Life	3M™ Scotch-Weld™ Low Odor Instant Adhesives can be expected to have a shelf life of 12 months from the date of shipment from 3M when stored under refrigerated conditions.
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.
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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ISO 9001:2000

This product was manufactured under a quality system registered to ISO 9001:2000 standards.

3M Industrial Adhesives and Tapes Division

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