



# Scotch-Grip<sup>TM</sup>

## Spray 80 Neoprene Contact Adhesive

---

### Product Data Sheet

---

Updated : August 1995  
Supersedes : November 1993

---

#### Product Description

Spray 80 Adhesive is a high performance neoprene contact adhesive with good plasticiser resistance. It features the high strength performance normally associated with bulk sprayable and brushable contact adhesives.

The good plasticiser resistance plus the ability to produce high strength heat resistant bonds to most

substrates makes Spray 80 Adhesive ideal for many demanding jobs.

The controlled lace-like spray pattern reduced overspray and misting allowing accurate adhesive application. The aerosol applied adhesive dries quickly, allowing bonds to be made four minutes after adhesive application in contrast to the 15-20

minutes drying needed with most traditional contact adhesives. For operations requiring a longer bonding range you have up to 30 minutes to make the bond.

---

#### Physical Properties

Not for specification purposes

<b>Base</b>	Neoprene Elastomer	
<b>Solvent</b>	Cyclohexane, Pentane, Acetone and Toluene	
<b>Flash Point</b>	-42°C approximately	
<b>Propellant</b>	Dimethyl Ether	
<b>Contents</b>	376g (500ml)	
<b>Consistency</b>	Thin liquid in aerosol	
<b>Colour</b>	Yellow	
<b>Shelf Life</b>	12 months from date of receipt by customer when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

---

#### Performance Characteristics

Not for specification purposes

<b>Service Temperature Range</b>	-30°C to 92°C	
<b>Water Resistance</b>	Very Good	
<b>Weathering Resistance</b>	Good	
<b>Plasticiser/Oil Resistance</b>	Good	

Date : August 1995  
 Spray 80 Neoprene Contact  
 Adhesive

### Additional Product Information

#### Peel Adhesion:

180° canvas to clear coat  
 paint peel adhesion at 24°C.

Bonds were made at a 15  
 minute open time and tested  
 at a pull rate of 50mm per  
 minute.

	N/CM	(P.I.W.)
1 Hour	5.3	(3.0)
2 Hours	7.7	(4.4)
4 Hours	9.1	(5.2)
1 Day	34.9	(19.9)
3 Days	42.4	(24.2)
7 Days	43.0	(24.5)

#### Heat Resistance:

180° canvas to clear coat  
 paint peel adhesion at 24°C.

Bonds were made at a 15  
 minute open time and aged  
 7 days at 24°C before  
 testing. Bonds tested at a  
 pull rate of 50mm per  
 minute.

	N/CM	(P.I.W.)
24°C	43.0	(24.5)
49°C	37.7	(21.5)
71°C	22.8	(13.0)
82°C	18.4	(10.5)
93°C	13.0	(7.4)

#### Plasticiser Resistance:

180° supported vinyl to  
 clear coat paint peel  
 adhesion at 24°C.

Bonds were made at a 15  
 minute open time and aged  
 at 24°C and 71°C before  
 testing. Bonds tested at a  
 pull rate of 50mm per  
 minute.

	N/CM	(P.I.W.)
7 days at 24°C	10.4	(5.9)
7 days at 71°C	6.0	(3.4)

### Storage Conditions

Cool dry place at 16 - 27°C  
 for maximum storage life.  
 Storage temperatures must  
 not exceed 49°C.

Date: August 1995  
 Spray 80 Neoprene Contact  
 Adhesive

---

### Directions for Use

Ensure all surfaces to be bonded are clean, dry and free from dust, oil or grease before application of adhesive.

Ensure that the nozzle points away from all persons and towards the surface to be sprayed. Turn the nozzle so that the tip points to the dot on the can rim.

Shake the can well before using, 5-10 seconds should be sufficient.

Hold the can 12-18cm away from the surface and apply at least two uniform and overlapping coats of adhesive to both bonding surfaces. When spraying push the nozzle of the can all the way down to avoid spluttering and to produce a uniform pattern.

After application, allow at least four minutes drying time before bonding.

To prevent nozzle from blocking, at the end of each day turn the can upside down and press the tip until the spray is clear of adhesive, and wipe tip.

---

### Clean Up and Aerosol Spray Tip Maintenance

Excess adhesive may be removed using Scotch-Grip Solvent No.2. The spray insert of the aerosol actuator used with Spray 80 Aerosol causes some adhesive build-up which may cause the spray pattern to become narrow and non-uniform.

#### Adhesive build-up may be minimised by:

1. Shaking the can well before using.
2. Fully depressing the nozzle when spraying to avoid spluttering.

Adhesive which accumulates around the "V" portion of the spray tip opening may be removed by wiping the "V" portion of the tip insert with a rag soaked in Solvent No. 2.

If adhesive should plug the nozzle, remove the nozzle from the can and immerse in a container of Solvent No. 2. Return the nozzle to the aerosol can when the adhesive has been removed.

**NOTE:** Solvent No. 2 is highly flammable. When using solvents for clean up it is essential that the proper precautionary measures are taken.

---

### Applications

Spray 80 Adhesive is suitable for bonding rubbers, supported vinyl's, wood, decorative laminates, metal, particle board, plastics\* and flexible foams to themselves or to other substrates.

\* Not recommended for polyethylene and polypropylene. For this use Spray Adhesive 76 or 90.

Date : August 1995  
 Spray 80 Neoprene Contact  
 Adhesive

## Health & Safety Information

### Precautions:

Highly flammable. Vapours may ignite explosively. Vapour may be harmful. Keep away from heat. Keep away from sources of ignition including pilot lights and sparks - No Smoking. Avoid prolonged breathing of vapours/spray. Do not use in confined areas or areas with little or no air movement. Do not spray directly into eyes. Avoid prolonged or repeated contact with the skin. Keep out of reach of children.

### WARNING:

Pressurised container. Protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn, even after use. Do not spray on a naked flame or incandescent material.

### First Aid:

#### Eye Contact:

Rinse immediately with plenty of water and seek medical advice.

#### Skin Contact:

Wash with soap and water.

For further information please contact our Toxicology Department at the Bracknell Head Office on (01344) 858000.

3M and Scotch-Grip are trademarks of the 3M Company.

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.



## Specialty Tapes & Adhesives

3M United Kingdom PLC  
 3M House,  
 28 Great Jackson Street,  
 Manchester,  
 M15 4PA

Customer Service :  
 Tel 0161 236 8500  
 Fax 0161 237 1105

3M Ireland  
 3M House, Adelphi Centre,  
 Upper Georges Street,  
 Dun Laoghaire, Co. Dublin,  
 Ireland

Customer Service :  
 Tel (01) 280 3555  
 Fax (01) 280 3509

© 3M United Kingdom PLC 1996