



# Scotch-Weld™

## TE-430 Thermoset Adhesive

### Product Data Sheet

Updated : June 2005  
Supersedes : February 2001

#### Product Description

Extrudable, long open time grade ideal for large part bonding, especially wood and some plastics. Some repositionability allows adjustment of bonded parts.

Scotch-Weld Thermoset Adhesives are a family of one-component, moisture

curing, urethane adhesives. These adhesives are applied warm and bond a wide variety of substrates such as wood, fibre reinforced plastic (FRP) and many other plastics to themselves, to metal and glass.

#### Features:

100% solids.  
Rapid rate of strength build-up.  
Broad substrate adhesion.  
Highly plasticiser resistant.  
High strength bonds. One component. Various set times.  
Can be used to bond heat sensitive materials.

#### Physical Properties (Uncured)

Not for specification purposes

<b>Application Temperature</b>	250 °F 121°C
<b>Viscosity</b> (at 250°F - 121°C)	3200 mPa.s
<b>Colour</b> (solid)	White/Off-White
<b>Open Time</b> <sup>2</sup>	6 to 10 minutes
<b>Set Time</b> <sup>3</sup>	6 minutes
<b>Density</b> molten g/ml	1.05
<b>Shelf Life</b>	6 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity
<sup>1</sup> Measured on Brookfield viscometer with Thermoses using spindle no. 27. <sup>2</sup> The bonding range of a 3.2mm/1/8" bead of molten adhesive on a non-metallic substrate. <sup>3</sup> The minimum amount of time required between when the bond is made and when it will support a 5 psi / 35 kPa tensile load.	

#### Physical Properties (Cured)

Not for specification purposes

<b>Shore D Hardness</b> <sup>1</sup>	60
<b>Modulus</b> <sup>2</sup>	NA
<b>100% Modulus</b> <sup>2</sup>	NA
<b>Tensile Strength at Break</b> <sup>2</sup>	40 MPa
<b>Elongation at Break</b> <sup>2</sup>	600%
<sup>1</sup> Measured on .090" - .110" thick bars (2.3 - 2.8mm) <sup>2</sup> ASTM D 638, Die C, measured on .011" - .017" (280-430µm) thick films cured 7 days at 77°F (25°C)/50% Relative Humidity.	

<b>Performance Characteristics</b> Not for specification purposes	<b>Overlap Shear Strength (MPa)</b>	Tested at 73°F (23°C)	
	<b>Substrate</b>		
	Fir wood Beech wood Polycarbonate PMMA Polystyrene All./Wood PVC	12.7 s.f. 16.2 s.f. 9.5 s.f. 1.6 a.f. 3.1 a.f. 6.9 a.f. on All. 7.1 s.f.	
	<sup>1</sup> s.f. :substrate failure a.f. : adhesive failure		

	<b>Overlap Shear Repositionability (MPa)</b> (on beech wood-sample moved from 25x25mm to 12.5x25mm after shown time)	Tested at 73°F (23°C)	Tested at 180°F(82°C)
	<b>Time</b>		
	Control After 3 min. After 5 min After 8 min.	16.2Mpas s.f. 15.5 Mpas s.f. 15.3 Mpas s.f. 12.1 Mpas s.f.	3.1 Mpa cf 2.1 Mpa cf 1.8 Mpa cf

	<b>180° Peel Strength (N/cm)</b>	Tested at 73°F (23°C)	
	<b>Substrate</b>		
	Polycarbonate PMMA Polystyrene PVC Aluminium	76 N/25 mm 22N/25 mm 26N/25 mm 160N/25 mm 193N/25 mm	
	<sup>1</sup> Cotton duck failed during test.		

	<b>Plasticised Vinyl, T-Peel (N/cm)</b>	Tested at 73°F (23°C)	
	<b>Condition</b>		
	Initial	NA	
	Aged at 160°F (71°C) for 2 weeks		
	<sup>1</sup> Substrate Failure		

<b>Environmental Resistance</b>	<b>FRP, Overlap Shear Strength (MPa)</b>	Tested at 73°F (23°C)	
	<b>Condition</b>		
	15 days at 25°F/50% RH Thermal Cycle <sup>1</sup>	NA	
	<sup>1</sup> Thermal cycle = 10 cycles of 16 hours at 100°F (38°C) / 100% RH. 4 hours at -20°F(-29°C) with bonds aged for 24 hours at 77°F (25°C) /50% RH prior to testing.		

<b>Typical Rate of Strength Build Up</b>	<b>FRP, Overlap Shear Strength (MPa)</b>	Tested at 73°F (23°C) at various times after bonding.	The FRP was conditioned for 7 days at 77°F (25°C)/ 50% RH prior to bonding.
	<b>Time</b>		
	10 minutes 1 hour 24 hours 1 week	NA	
	The cure rate will vary depending on air temperature, relative humidity, substrate and bond line thickness. Cure rate is more rapid on wood (moisture-rich substrate) than on plastic.		

<b>Test Procedures</b>	<p><b>Overlap Shear Strength</b> Overlap shear (OLS) strengths were measured on 25. mm wide 12.5mm overlap specimens. These bonds were made individually using 25. x 101.6 mm sample coupons. The thickness of the bond line was 75-150 µm (micrometer). The thickness of the substrates were : Plastics 3.2mm, Maple 9.5mm.</p> <p>All strengths were measured at 23°C except where noted. The separation rate of test jaws was 50 mm /minute.</p>	<p><b>180° Peel Strength</b> 180° peel strengths were measured on 25. x 203.2mm pieces of flexible cotton duck (canvas) bonded to rigid 25. x 101.6mm substrates. The rigid substrates were approximately 3.2mm thick and the separation rate of the testing jaws was 50. mm per minute. All strengths were measured at 73°F (23°C).</p> <p><b>T-peel Strength</b> T-peel strengths were measured on 25. mm wide pieces of plasticised vinyl at 73°F (23°C). The separation rate of the testing jaws was 50 mm per minute.</p>	<p><b>Cure Cycle</b> With the exception of rate of strength build up, all bonds, unless otherwise noted, were cured for a minimum period of 7 days at 77°F (25°C)/50% RH before testing or subjecting to further conditioning or environmental ageing. Bonds were prepared using the suggested procedure for the particular substrate tested.</p>
------------------------	---	--	---

---

**Directions for Use**

Apply to clean, dry surfaces. Remove oil, grease and other contaminants by wiping with isopropyl alcohol. For fibre reinforced plastics and other materials that are often contaminated with mold release agents. It is recommended that the surface be solvent wiped, abraded and solvent wiped. After heating to recommended application temperature, apply adequate amount of Scotch-Weld Thermoset Adhesive to one of the substrates to be bonded. Join the substrates within the adhesives specified open time and hold/fixture the bonded part until the adhesive has adequately set. Do not use to bond metal or glass to itself or each other or cure will not occur due to low moisture vapour transmission of the substrate.

**Important: Adhesive heated at application temperature for more than 16 hours should be discarded.**

Note: When using solvents, extinguish all ignition sources and observe manufacturers' directions and precautions for handling such materials.

**Dispensing Equipment**

Scotch-Weld Adhesive Cartridges can only be dispensed through the 3M Scotch-Weld Adhesive Applicator. Other container sizes can be dispensed through bulk equipment specifically designed for use with hot melt polyurethane reactive adhesives (PUR). For more information on PUR application equipment, contact your local 3M sales representative. All equipment must be used in strict accordance with the recommendations of the manufacturer.

**WARNING: Do not use Scotch-Weld Adhesive above 275°F (135°C). Scotch-Weld Adhesive should not be applied to substrates that exceed 275°F (135°C).**

**Caution: Wear heat resistant gloves and safety glasses when handling.**

**Container sizes available:**

10 fl. oz cartridge, 2 kg foil bag, five gallon pail, 55 gallon drum.

**Clean Up:**

Allow product to solidify. Remove uncured waxy material (usually within the first 20 minutes after application) by scraping with a putty knife or similar tool. For cured material, remove by cutting or sanding. **Do not use heat or flame to remove adhesive.**

---

**Surface Preparation****Plastic:**

Wipe with isopropanol soaked cheesecloth. Allow solvent to evaporate before bonding. **Note:** Scotch Weld Adhesives are not recommended for bonding untreated polyolefins.

**Plastic contaminated with mold release:**

Wipe with isopropyl soaked cheesecloth, abrade with fine grit abrasive, wipe with isopropyl alcohol soaked cheesecloth. Allow solvent to evaporate before bonding.

**FRP, Rubber and Aluminium (uncoated):**

Wipe with methyl ethyl ketone (MEK) soaked cheesecloth, abrade with fine grit abrasive, wipe with MEK soaked cheesecloth. Allow solvent to evaporate before bonding. Priming may be necessary on aluminium if part will be subjected to hot or humid conditions.

**Glass:**

Wipe with MEK soaked cheesecloth. Allow solvent to evaporate before bonding. Priming may be necessary on glass if part will be subjected to hot or humid conditions.

**Note:**

When using solvents, extinguish all ignition sources and observe manufacturers directions and precautions for handling such materials.

---

**Storage Conditions**

For maximum shelf life store product at 60°F (16°C) to 80°F (27°C), indoors and protect from exposure to moisture.

Products have a 6 month shelf life in unopened containers.

---

---

**Health and Safety  
Information**

Refer to the Product Label  
and Material Safety Data  
Sheet for Health and Safety  
Information before using this  
product.

---

3M and Jet-Weld 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.

**Industrial Adhesive & Tapes Division**

© 3M United Kingdom PLC 1996

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

Product Information :  
Tel 0870 60 800 50  
Fax 0870 60 700 99

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

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