

3M™ Scotch-Weld™ Repair Paste 2110

Technical Data Sheet

Product Description

3M™ Scotch-Weld™ Repair Paste 2110 is a two-part urethane paste that cures to an erosion resistant polyurethane elastomer. It is designed to repair polyurethane coatings or films commonly used for erosion protection on aircraft, including helicopter rotor blades, leading edges, engine components and other areas susceptible to erosion damage. It is supplied in 50 ml dual syringe plastic Duo-Pak cartridges with a 1:1 mix ratio as part of the 3M™ EPX™ Plus II Applicator System (with 3M™ 1:1/2:1 Plunger for EPX Plus II 10/CV). 3M™ Scotch-Weld™ Repair Paste 2110 is also available as a kit.

3M Scotch-Weld Repair Paste 2110:

- 100% solids urethane paste
- 1:1 mix ratio
- Cures to a black, erosion resistant polyurethane elastomer
- Designed to repair polyurethane films and coatings
- Has excellent sand and rain erosion resistance properties
- Convenient 50 ml Duo-Pak cartridges for easy application with minimal waste

Typical Physical Properties

Note: 1) The following technical information and data should be considered representative or typical only and should not be used for specification purposes. Metric values are listed in parenthesis. 2) ASTM = American Society for Testing and Materials.

Property	Test Method		Typical Value
Uncured Properties			
Color	Part A	Visual	Transparent
	Part B		Black
Density	Part A	ASTM D1875	1.05 g/ml
	Part B		1.05 g/ml
Viscosity	Part A	ASTM D2556	200,000 – 250,000 cps
	Part B		70,000 – 80,000 cps

Property	Test Method	Typical Value
Cured Properties		
Color	Visual	Black
Density	ASTM D792	1.05 g/ml
Time to Full Cure @ 77°F (25°C)	ASTM D4440	24 hours
Hardness (Shore A)	ASTM D2240	70
Taber Abrasion	ASTM D4060	0.020 g
Work Life	3M test method C-548	10 minutes
Tack Free Time	3M test method C-3173	6 hours
Adhesion to Polyurethane	ASTM D3330, Method A	20 lb/in
Adhesion to Epoxy Glass Fiber Composite	ASTM D3330, Method A	12 lb/in
Fluid Resistance Water JP4/JP8 Aviation Fluid De-icing Fluid Hydraulic Fluid (MIL-PRF-83282) Motor Oil (MIL-PRF-21260E)	24 hour immersion	Little or no apparent effect
Humidity Resistance	95% RH @ 140°F for 30 days	Little or no apparent effect

Directions For Use

I. Surface Preparation:

For best adhesion, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. Surface abrasion and cleaning with isopropanol* is recommended when bonding to polyurethane.

II. Dispensing:

3M™ Scotch-Weld™ Repair Paste 2110 is supplied in a dual syringe plastic Duo-Pak cartridge as part of the 3M™ EPX™ Applicator System. To use, simply insert the Duo-Pak cartridge into the EPX™ applicator and start the plunger into the cylinders using light pressure on the trigger. Next, remove the Duo-Pak cartridge cap, attach the static mixer and expel a small amount of adhesive (about the size of a quarter) to be sure both sides of the Duo-Pak cartridge are flowing evenly and freely. Pushing the plunger slowly will minimize air bubbles and ensure good mixing of the paste.

III. Hand Mixing:

Hand mixing is not recommended.



IV. Clean-up:

Excess uncured paste can be removed by wiping with solvent* and should be allowed to cure before disposal. Unmixed paste should be handled and stored per the SDS recommendation. Mixed paste that has cured does not require special waste handling procedures. Dispose of gloves, tape and other items containing cured sealant accordingly gloves and tools that have been in contact with any unmixed paste should be treated and disposed of per the SDS recommendation. Wash hands with soap and water.

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

Storage

Store products at 60-80°F (16-27°C) for maximum storage life. Rotate stock on a "first-in first-out" basis.

Shelf Life

When stored in the original, unopened container at the storage conditions suggested, this product has a shelf life of 12 months from the date of shipping

Precautionary Information

Refer to product label and Safety Data Sheet (SDS) for health and safety information before using this product. For SDS visit our website https://www.3m.com/3M/en_US/company-us/SDS-search/.

Additional Information

In the U.S. call toll free 1-800-235-2376, or fax 1-800-435-3082 or 651-737-2171. For U.S. Military, call 1-866-556-5714. If you are outside of the U.S., please contact your nearest 3M representative.

These products were manufacture under a 3M Quality Management System registered to the AS9100 standard

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information. **Product Selection and Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property. **Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price. **Limitation of Liability:** Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

