

3M™ Scotch-Weld™ Repair Paste RP-2220 B/A

Technical Data Sheet

Product Description

3M Scotch-Weld Repair Paste RP-2220 B/A is a clear two-part urethane 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, boot products, leading edges, 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™ Applicator System.

3M Scotch-Weld Repair Paste RP-2220 B/A:

- 100% solids urethane paste
- 1:1 mix ratio
- Cures to a transparent, erosion resistance polyurethane elastomer
- Designed to repair polyurethane films, tapes, boots, 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

Notes: 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		
Color Part A/B	Visual	Transparent
Density Part A Part B	ASTM D1875	A: 1.11 g/mL B: 1.08 g/mL
Viscosity Part A Part B	ASTMD2556	A: 20000-50000 cps B: 30000-45000 cps

Property	Test Method	Typical Value
Cured		
Color	Visual	Transparent
Density	ASTM D792	1.12 g/mL
Time to Full Cure @ 77°F (25°C)	ASTM D440	24 hours
Hardness Shore A	ASTM D2240	68
Taber	ASTM D4060	0.02 g
Work Life	3M Test Method, C-548	15 minutes
Tack Free Time	3M Test Method, C-3173	2 hours
Adhesion to Polyurethane	ASTM D3330, Method A	21 in/lb

Temperature (°C)	Gel Point (Min)	Time to full Cure (Min.)	Time to 95% Cure (Min.)
15	66	2147	1438
25	33	517	271
32	19	398	135
50	6	266	39
65	4	155	22
80	3	100	10

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.

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