

# 3M™ Scotch-Weld™ Repair Paste 2110 B/A & 3M™ Scotch-Weld™ Repair Paste 2220 B/A

## Instructions for dilution and spraying

### Equipment/Material Recommendations:

1. Air powered or non-spark producing mixer with agitator
2. 3M™ Accuspray™ ONE Spray Gun equipped with 1.4 mm atomizing head or equivalent HVLP applicator
3. Methyl Acetate (CAS: 79-20-9)
4. Parachlorobenzotrifluoride (PCBTF) (CAS: 98-56-6)

**WARNING!** When using solvents, extinguish all ignition sources. Read and follow solvent manufacturers warnings and directions for use.

Consult local air quality rules/regulations which may regulate solvent use.

### Mixing Instructions:

1. Add 105g of methyl acetate and 35g of PCBTF to a suitable container.
2. Turn on agitator to low speed, being careful not to splash the solvents.
3. Add one full cartridge of Repair Paste 2110 or Repair Paste 2220 (parts A and B). This equates to approximately 50g of the repair paste. Note: it is not necessary to mix the repair paste through a static mixer.
4. Slowly increase the mixer/agitator speed being careful not to splash the liquid outside of the container.
5. Agitate the mixture for at least 15 minutes or until the repair paste is fully dissolved in the solvents. The solution is now ready to be sprayed.

Note: To mix larger quantities, scale the mixture up with the same ratio of all components.

### Spray Instructions:

1. Apply the repair paste solution in thin layers of less than 1.0 mil dry thickness per layer.
2. Apply additional box coats with at least 5 minutes dry time between coats.
3. Allow to cure for at least 24 hours at room temperature before handling.

For Additional Health and Safety Information see product label and safety data sheet.

3M Automotive and Aerospace Solutions Division  
3M Center, St. Paul, MN 55144-1000  
1-800-364-3577

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

**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. **Product 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. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application. **Warranty, Limited Remedy, and Disclaimer:** Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 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 OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 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 where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.



Automotive & Aerospace Solutions Division  
3M Center  
St. Paul, MN 55144-1000  
Phone 1-800-328-1684  
Web [www.3M.com/aerospace](http://www.3M.com/aerospace)

2110/2220  
Issue date: 2/2018

3M is a trademark of 3M Company  
© 3M 2018. All rights reserved.