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.

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

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