



# Technical Data Sheet

## 3M™ Neoprene Contact Adhesive 10



[Product Details](#)



[Regulatory Info/SDS](#)

### Product Description

3M™ Neoprene Contact Adhesive 10 is a multi-purpose contact adhesive which may be used to bond plastic laminate, aluminum, steel, wallboard, wood, masonry, rubber and canvas.

### Product Features

- Roll or brush-applied.
- Fast drying.
- Adhesion to a wide variety of materials.
- Excellent resistance to plastic flow (creep).
- 60 minute bonding range.
- Meets the specification requirements of MMM-A-121, MMM-A-130B, and A-A-1936A.

### Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

### Typical Uncured Physical Properties

Attribute Name	Value
Net Weight	0.83 ± 0.02 kg/L (6.9 ± 0.2 lb/gal)
Base	Polychloroprene

### Typical Physical Properties

Attribute Name	Temperature	Value
Color		Light Yellow (wet and dry)
Solids Content by Weight		21 — 25 %
Solvent Resistance		Petroleum distillate, acetone, toluene and n-hexane
Coverage		7.1 m <sup>2</sup> /L (290 ft <sup>2</sup> /gal) <sup>1</sup>
Flash Point		-25 °C (-14 °F) <sup>2</sup>
Viscosity	27 °C (80 °F)	450 — 700 cP <sup>3</sup>

<sup>1</sup> @ 27 g/m<sup>2</sup> (2.5 g/ft<sup>2</sup>) dry

<sup>2</sup> TCC

<sup>3</sup> Brookfield Viscometer RVF #2 spindle @ 20 rpm

Attribute Name	Value
*Note	When bonding wood veneers, success is dependent on many variables such as environmental conditions, bonding process, type of base material, type of veneer, adhesive type and top coat finishing systems to name a few. It is the user's responsibility to thoroughly test any adhesive for its suitability in bonding wood veneers. It is also recommended to follow the veneer manufacturers recommendation and industry guidelines.

## Typical Performance Characteristics

### 180° Peel Adhesion

Substrate: Cotton Duck to Cold Rolled Steel

Dwell Time	Temperature	Value
24 h	23 °C (73 °F)	18 N/cm (160 oz/in) <sup>1</sup>
72 h	23 °C (73 °F)	23 N/cm (210 oz/in) <sup>1</sup>
120 h	23 °C (73 °F)	30 N/cm (270 oz/in) <sup>1</sup>
168 h	23 °C (73 °F)	33 N/cm (300 oz/in) <sup>1</sup>
2 week	23 °C (73 °F)	39 N/cm (350 oz/in) <sup>1</sup>
3 week	23 °C (73 °F)	40 N/cm (370 oz/in) <sup>1</sup>
3 week	-30 °C (-22 °F)	49 N/cm (450 oz/in) (SF) <sup>1</sup>
3 week	82 °C (180 °F)	16 N/cm (140 oz/in) <sup>1</sup>

<sup>1</sup> AF: adhesive failure CF: cohesive failure SF: substrate failure

### Overlap Shear Strength

Substrate: Birch Plywood

Temperature: 23 °C (73 °F)

Dwell Time	Test Condition	Value
2 week		300 N/cm <sup>2</sup> (430 lb/in <sup>2</sup> ) (SF) <sup>1</sup>
3 week		300 N/cm <sup>2</sup> (430 lb/in <sup>2</sup> ) (SF) <sup>1</sup>
3 week	-34 °C (-30 °F)	470 N/cm <sup>2</sup> (680 lb/in <sup>2</sup> ) (SF) <sup>1</sup>
3 week	82°C (180 °F)	76 N/cm <sup>2</sup> (110 lb/in <sup>2</sup> ) <sup>1</sup>
3 week	107 °C (225 °F)	48 N/cm <sup>2</sup> (70 lb/in <sup>2</sup> ) <sup>1</sup>

<sup>1</sup> AF: adhesive failure CF: cohesive failure SF: substrate failure

## Handling/Application Information

### Directions for Use

#### Working Temperature

1. The temperature of the adhesive and surfaces to be bonded should be at 65°F (18°C) or above.
2. Warm the can of adhesive by placing in a warm room, not in stove, oven or other possible ignition source.
3. If the room must be warmed, turn off the heater before opening container.
4. Leave heater off until all vapors are gone.

#### Application

1. Stir thoroughly before using.
2. Apply adhesive generously in a uniform film on both surfaces with either a fiber or animal hair brush, or pour and spread with paint roller (solvent resistant texturing type).
3. Porous surfaces may require 2 coats of adhesive.
4. A glossy film when completely dry indicates adequate adhesive.
5. Dull spots after drying indicate not enough adhesive; these spots must have another coat.

#### Assembly

1. Allow to dry until adhesive is no longer tacky (5-10 minutes).
2. Position surfaces carefully before assembly.
3. No adjustment is possible after contact.
4. Spacers such as dowels or strips of laminate, may be used to prevent premature adhesive/adhesive contact and bonding.
5. Slide out the spacers and apply uniform pressure, working toward the edges.
6. A 3 in roller used with maximum body pressure should be used to help ensure adequate contact and bonding, especially on the edges.
7. Bonded assemblies can be machined, trimmed or finished immediately after bonding.

#### Drying Time

1. Drying time depends on temperature, humidity, air movement and porosity of materials bonded.

#### Cleanup

1. Excess adhesive may be removed with a solvent such as methyl ethyl ketone.\*

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

## Surface Preparation

**Note:** Read and follow precautions before using this product.

### Surface Preparation

1. For best results, all surfaces to be bonded should be dry and free from dirt, dust, oil, loose paint, wax, grease, etc.
2. Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone.\*
3. If used for decorative laminate, laminate should have reached moisture equilibrium for the shop conditions.

## Application Equipment

**Note:** Appropriate application equipment enhances adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

1. Brushes: Use fiber or animal hair brushes. Do not use nylon or other synthetic fibers.
2. Rollers: Use solvent resistant paint rollers, designed for applying oil based paints.

## Industry Specifications

MMM-A-121  
MMM-A-130B  
A-A-1936A

## Storage and Shelf Life

Best storage temperature is 60-70°F (16-27°C). Continuous exposure to higher temperatures may cause some increase in viscosity. Quality is not affected until the adhesives becomes thickened so that it is difficult or impossible to spread. 3M™ Neoprene Contact Adhesive 10 will not freeze, but continuous exposure to low temperature will cause a considerable increase in viscosity. After storage at low temperatures and before using, the adhesive must be thawed and stirred vigorously until the entire container regains its original viscosity. The thawing process should be done at approximately room temperatures, never at elevated temperatures. Several days may be required for thawing - particularly with larger containers. Rotate stock on a "first in-first out" basis. When stored at the recommended conditions in the original, unopened container this product has a shelf life of 30 months from date of manufacture.

## Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577

## Automotive Disclaimer

### Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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## **ISO Statement**

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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