



# Scotch-Grip™

## Fire Resistant Rubber Based Adhesive

### EC-4419

#### Technical Data

Issue No. 1

#### Introduction

3M™ Scotch-Grip™ Fire Resistant Rubber Based Adhesive EC-4419 is a fire resistant, synthetic, rubber-based adhesive. It is commonly used for bonding gaskets in aircraft interiors and for attachment of de-icing boots.

#### Advantages

- Fire resistant
- Quick dry time
- Can be applied by brush or flow gun
- Controlled flow
- Even spreadability when brushed on

#### Physical Properties

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

<b>Solids Content</b>	39 ± 3%
<b>Viscosity, Brookfield, RVF #6 at 20 RPM's @ 80°F in 1 pint can</b>	10,000 - 18,000 cps
<b>Net Weight</b>	7.5 ± .3 lbs/gallon
<b>Flash Point (closed cup)</b>	-14°F (-26°C)
<b>Color</b>	Yellow
<b>Base</b>	Oil Resistant Elastomer
<b>Consistency</b>	Heavy Syrup

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**Mechanical Properties**      75°F (24°C)    180° Peel Strength    9-12 piw  
Nylon Webbing (MIL-W-4088, Type 17 Natural) to .063"  
Aluminum (2024-T3 or 7075-T6)

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**Fire Resistance**                      (60 Second Vertical Burn Test)

	<u>Test Requirement</u>	<u>Test Result</u>
Extinguish Time	5 second max	Pass
Burn Length	5 inch max	Pass
Drip Extinguishing	3 second max	Pass

Flame test conducted on a 5 mil dry coat of EC-4419 on 116 glass cloth.

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**Application**                      Surface must be clean, dry, and free from oil or grease. EC-4419 can be applied by brush or flow gun.

**Suggested Methods:**

- A. 5 Gallon Pail Dispensing System
  - 1) Pump – 5 to 1 minimum ratio double acting ball check, type pump 8.0 cubic inch/cycle, 3" air motor.
  - 2) Primer – Single wiper follower plate.
  - 3) Equipment – Graco Model 225-654 system which includes: Monark Pump 5 to 1 model number 204-392.  
Pyles Industries, Inc., Lincoln Engineering and Aro Corporation make similar equipment.
- B. 55 Gallon Drum Dispensing System
  - 1) Pump – 5 to 1 minimum ratio double acting ball check, type pump 8.0 cubic inch/cycle, 3" air motor.
  - 2) Primer – Inductor Plate.
  - 3) Equipment – Graco 5 to Monark, Model Number 204227 with 204-490 inductor.  
Pyles Industries, Inc., Lincoln Engineering and Aro Corporation make similar equipment.
- C. Accessories
  - 1) Hose – Samuel Moore Synflex hose or equivalent. 1,000 psi working pressure minimum.
  - 2) Flow Gun – Graco model 203-420 with 1/8 tip or equivalent.
- D. Chemical Resistance Requirements  
Synthetic materials in contact with this material must be resistant to naphtha and toluol.
- E. Cleanup may be accomplished by using toluene.\*  
**\*Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

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**Storage**                      Store Product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature.

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**Shelf Life**                      3M Standard shelf life of EC-4419 adhesive is 6 months from date of shipment from 3M when stored in its original unopened can.

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**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 or 651-737-6501.

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**For Additional Information** To request additional product information or to arrange for sales assistance, call toll free (800) 235-2376. Our fax number is (417) 869-5219. Address correspondence to: 3M Aerospace Central, 3211 E. Chestnut Expressway, Springfield, MO 65802.

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This Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



**Adhesives Division**  
3M Center, Building 220-8E-05  
St. Paul, MN 55144-1000  
1-800-364-3577 or 612-737-6501



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