3M™ Scotch-Grip™ Fire Resistant Rubber Based Adhesive EC-4419

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

<table>
<thead>
<tr>
<th>Physical Property</th>
<th>Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Solids Content</td>
<td>39 ± 3%</td>
</tr>
<tr>
<td>Viscosity, Brookfield, RVF #6</td>
<td>10,000 - 18,000 cps</td>
</tr>
<tr>
<td>at 20 RPM's @ 80°F in 1 pint can</td>
<td></td>
</tr>
<tr>
<td>Net Weight</td>
<td>7.5 ± .3 lbs/gallon</td>
</tr>
<tr>
<td>Flash Point (closed cup)</td>
<td>-14°F (-26°C)</td>
</tr>
<tr>
<td>Color</td>
<td>Yellow</td>
</tr>
<tr>
<td>Base</td>
<td>Oil Resistant Elastomer</td>
</tr>
<tr>
<td>Consistency</td>
<td>Heavy Syrup</td>
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</table>
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 incudes: 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.
**Scotch-Grip™**  
**Fire Resistant Rubber Based Adhesive**  
**EC-4419**

<table>
<thead>
<tr>
<th><strong>Storage</strong></th>
<th>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.</th>
</tr>
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<tbody>
<tr>
<td><strong>Shelf Life</strong></td>
<td>3M Standard shelf life of EC-4419 adhesive is 6 months from date of shipment from 3M when stored in its original unopened can.</td>
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