

# 3M

## Scotch-Weld™

### Adhesive/Sealant

#### EC-3537-NA B/A

Technical Data

June, 2002

#### Introduction

3M™ Scotch-Weld™ Adhesive/Sealant EC-3537-NA B/A is designed to cure at room temperature of 70-80°F [21-27°C] (cure rate may be accelerated by the application of mild heat) and the cured material exhibits excellent flexibility and adhesion.

Scotch-Weld EC-3537-NA B/A low flow, soft paste viscosity permits application on vertical or overhead surfaces with a minimum of run-off and the contrasting colors of base and hardener components permit visual checking on thoroughness of mixing.

#### Product Description

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

	<b>B (Base)</b>	<b>A (Hardener)</b>
<b>Color:</b>	Off white	Medium gray
<b>Base:</b>	Epoxy resin	Modified amine
<b>Weight/Gallon:</b>	11.3 lbs.	10.9 lbs.
<b>Consistency:</b>	Paste	Thixotropic paste
<b>Recommended Mixing Ratio:</b>	Parts by weight 30 Parts by volume 29	70 71

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## Product Performance

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

The following product performance data has been obtained in the 3M Laboratory under the conditions specified. General application methods are described later.

1. Mixed flow – A 0.1 inch thick by 1 inch wide bead of freshly mixed 3M™ Scotch-Weld™ Adhesive/Sealant EC-3537-NA B/A showed no significant sag on a vertical surface over a 120 minute period at 73°F (23°C).
2. Hardness – A 1/4 inch thick section of Scotch-Weld EC-3537-NA B/A cured for 24 hours at 73°F (23°C) had a Shore A hardness of approximately 72. After curing for 4 days at 73°F (23°C) the Shore A hardness was measured at 78.

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## Product Application

Proper application is as important as proper design and sealant or adhesive (choice to obtain maximum properties. Improper application techniques can result in a partial or complete failure of an assembly.

### I. Surface Preparation

A thoroughly cleaned, dry, grease-free surface is essential for maximum performance. Surface preparations should be fully evaluated with the adhesive, especially if resistance to specific environments are anticipated.

### II. Mixing and Spreading of Adhesive

#### A. Mixing Ratios

	<u>Weight</u>	<u>Volume</u>
Parts Base – B (Off White)	30	29
Parts Hardener – A (Gray)	70	71

#### B. Work Life

The work life of mixed Scotch-Weld EC-3537-NA B/A is approximately two (2) hours in a mass of 100 grams at an ambient temperature of 75°F (24°C). The work life will be lengthened by reducing the temperature or amount of adhesive and will be shortened by higher temperatures or larger amounts of adhesive.

C. The mixed adhesive may be applied by means of a spatula, notched trowel, or by suitable extrusion equipment.

#### D. Cleanup

Excess adhesive and equipment may be cleaned up, prior to curing, with Ketone\* type solvent. \***Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

#### E. Cure Time and Temperature

The following cure times and temperatures are required to achieve optimum properties.

- 3-7 days at 75 ± 2°F
- 2 hours at 150 ± 3°F
- 30-60 minutes at 200 ± 5°F

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**Storage Conditions**

Store 3M™ Scotch-Weld™ Adhesive/Sealant EC-3537-NA B/A at 73°F (23°C) or lower for maximum storage life. Rotate stock on a “first-in-first-out” basis. Upon request, your 3M Sales Representative will be pleased to advise you of the anticipated shelf life of this product under the storage conditions in your plant.

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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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**Important Notice**

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M Engineered Adhesives Division product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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If the 3M product is proved to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including, but not limited to, contract, negligence, warranty, or strict liability.

ISO 9002

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



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