

Scotchweld

3M

MARCH 1987

Structural Void Filling Compound 3584 B/A

PRODUCT SPECIFICATION

INTRODUCTION

Scotchweld void filling compound 3584 B/A is a two part room temperature curing epoxy based product with extremely low density. Developed for the Aircraft Industry it offers the following properties:—

- ★ Flame Retardant.
- ★ Solvent free.
- ★ Cures to a strong low density material within 16 hours at ambient temperatures above 21°C (70°F).
- ★ The product has thixotropic properties for ease of application.
- ★ One component is blue, the other yellow, so that complete mixing of components gives a light green product.

DESCRIPTION

	3584 B (Base)	3584 A (Accelerator)
Colour:	Blue	Yellow
Base:	Epoxy	Modified Amine
Solvent:	None	None
S.G.:	.62 (approx.)	.24 (approx.)
Mixing ratio by weight:	Equal parts.	

APPLICATION

Surface Preparation

A clean dry grease free surface is essential for maximum performance.

Mixing

3584 B/A may be mixed by hand or machine until a uniform green colour is obtained. Do not mix any more than can be used within the pot life of the material. A two hundred (200) gram mix has a work life of approximately 2 hours. Larger quantities will give a shorter work life.

Application

3584 B/A may be applied by spatula or trowel. Apply by working the material in place to reduce internal voids, and allow to set for two hours before finishing the surface. Large masses of material should be avoided until suitable tests are run to determine the possibility of an exothermic situation.

NOTES:

STORAGE

Storage stability — Store product at 24°C (75°F) or below. Rotate stock on first in — first out basis. When using solvents for cleanup, it is essential that proper precautionary measures for handling such materials be observed. For flammable solvents, also extinguish all sources of ignition in the area.

ADDITIONAL INFORMATION

For any additional information, please contact your local 3M representative.

CAUTION

Liquids are irritating to the eyes. May cause skin irritation. Avoid eye and skin contact. If eye contact does occur, flush immediately with plenty of water and obtain medical attention. If skin contact does occur wash with soap and water. Provide exhaust ventilation on curing ovens. Avoid inhalation of dust during cutting and grinding of cured products.

TEST RESULTS

50 grams of 3584 B and 50 grams of 3584 A were hand mixed for 2–3 minutes then cast into a block 2" x 2" x 4" and cured 5 hours at 51°C (125°F). 1" x 1/2" x 1/2" specimens were cut from the cured block. Density was calculated by weighing and dividing by the volume.

Density: 0.33 grams/cc
20.8 lbs./ft. 3

Compressive Strength

Measured by applying force on 1/2" x 1/2" faces of specimen. Compression rate was 0.02"/minute.

Test Temperature

24°C (75°F) 1200 psi

Flammability

Extinguish immediately when tested according to Federal Test Method Standard No. 406 Method 2021

Our recommendations on the use of our products are based on tests believed to be reliable, but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability, direct or consequential for loss or damage caused as a result of our recommendations.

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The 3M logo consists of the letters '3', 'M', and 'M' in a bold, sans-serif font. The '3' is significantly larger than the two 'M's, which are positioned to its right and slightly below its top edge.