

# Safe Handling of a 3M™ Plastic Bonding Adhesive Syringe in a Heated Dispenser

## Safety Information

**Warning:** Hot syringes are a possible burn or explosion hazard.

To insure safe handling of 3M™ Plastic Bonding Adhesive 2665, 2665B, 2669, and 2679B syringes, 3M recommends the following:

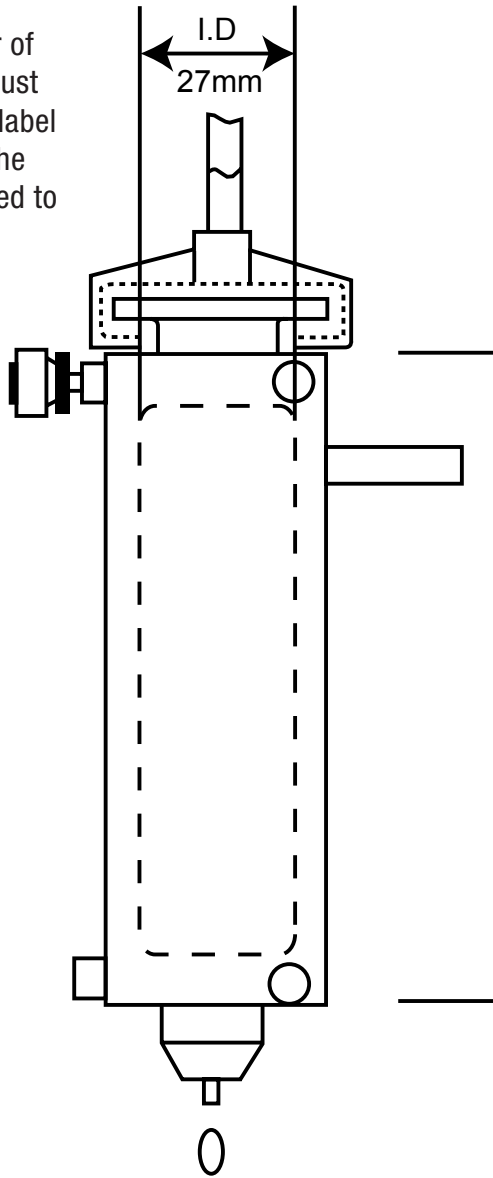
1. Consult the Material Safety Data Sheet for precautionary measures before use. Use gloves and the recommended personal protective equipment when handling hot syringes to prevent burns or injury.
2. Do not remove the aluminum label from the syringe. It is designed to make the temperature of the syringe more uniform.
3. The syringe heater must have an opening sufficient to accommodate easy insertion and removal of the syringe including the aluminum label. This opening should be a minimum of 27 mm—see the drawing on page 2. The heater block should extend the full length of the syringe to just under the attachment of the pressure cap.
4. Do not exceed 110°C (230°F) syringe temperature. Failure of the syringe could result.
5. Do not exceed 4.1 Bar (60 p.s.i.) dispensing pressure. Failure of the syringe could result.
6. Use only dry air for dispensing to prevent premature curing of the product.
7. If adhesive does not flow from the needle, **do not increase pressure or temperature in order to force the adhesive to flow.** Instead, first turn off the air pressure and take out the syringe. Check if the adhesive will flow out from the tip of the syringe when the needle is removed. If it does flow, this indicates the needle is plugged and should be replaced. If there is no flow from the syringe itself, this indicates a blockage from cured material in the tip. Use a sharp pin to remove the cured adhesive from the tip of the syringe.

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## Safety Information (continued)

8. Always release air pressure from the dispensing unit before removing the syringe from the heater.
9. Heated dispenser dimensions:

The inner diameter of the heater block must accommodate the label and expansion of the syringe when heated to 110°C (230°F)



The heater block should extend the full length of the syringe to just under the attachment of the pressure cap

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## For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-251-8634. Address correspondence to: 3M, Electronics Markets Materials Division, 3M Center, Building 225-3S-06, St. Paul, MN 55144-1000. Our fax number is 651-778-4244 or 1-877-369-2923. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

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