



# Scotch-Weld™

## Neoprene Rubber & Gasket Adhesive

2141

**Technical Data**

**October, 2010**

---

### Features

- A light colored, high strength adhesive with a long tack range.
- Excellent water, oil and grease resistance.
- Bonds neoprene, natural, reclaim SB-R and butyl rubber to most substrates.

---

### Typical 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>Viscosity (approx.):</b>	900 - 1500 cps
<b>Brookfield Viscometer:</b>	RVF #2 Sp. @ 20 rpm @ 80°F (27°C)
<b>Solids (by wt.):</b>	28 - 32%
<b>Base:</b>	Polychloroprene
<b>Color:</b>	Yellow
<b>Net weight (approx.):</b>	7.0 - 7.4 lbs./gal.
<b>Flash point:</b>	-14°F [-26°C] (T.C.C.)
<b>Solvent:</b>	Petroleum Distillate, Toluene, Acetone and n-Hexane

# 3M™ Scotch-Weld™ Neoprene Rubber & Gasket Adhesive 2141

## Typical Adhesive Performance Characteristics

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

Adhesive was brush applied to substrates and bonded while still tacky. The bonds were then tested in 180° peel and shear after aging for times indicated.

### 180° Peel Strength – Canvas/Steel

### Overlap Shear Strength – 1/8" Birch/Birch

Time @75°F (24°C)	Test Temperature	Value (lbs./in. width)	Time @75°F (24°C)	Test Temperature	Value (psi)
1 day	75°F (24°C)	6	3 weeks	75°F (24°C)	377
3 days	75°F (24°C)	10			
5 days	75°F (24°C)	24	after 3 weeks	180°F (82°C)	68
7 days	75°F (24°C)	32			
2 weeks	75°F (24°C)	32			
3 weeks	75°F (24°C)	30			
after 3 weeks	-30°F (-34°C)	14			
after 3 weeks	150°F (66°C)	24			
after 3 weeks	180°F (82°C)	22			

## Handling/Application Information

### Directions For Use:

- Surface Preparation:** Surfaces must be clean, dry and dust free. Wiping with a solvent such as methyl ethyl ketone (MEK) will aid in removing oil and dirt.\*
- Application Temperature:** For best results, the temperature of the adhesive and the surfaces being bonded should be at least 65°F (18°C).
- Application:** Stir or agitate well before using.  
 Porous Surface(s): Apply a uniform generous brush coat of adhesive to one or both surfaces. Highest strengths are obtained when both surfaces are coated. Highly absorbent materials may require two coats.  
 Non-Porous Surface(s): Brush an even coat of adhesive on both surfaces. Press surfaces together firmly to ensure contact.
- Drying Time:** When applying adhesive to only one surface, the bond must be made immediately, while the adhesive is wet. When applying adhesive to both surfaces, allow the adhesive to dry until tacky, but does not transfer to knuckle when touched (typically 5-10 minutes, depending on temperature, humidity, etc.).
- Bonding:** After drying, you have up to 15 minutes to make the bond. Press surfaces together firmly to ensure contact.
- Cleanup:** Excess adhesive may be removed with a solvent such as 3M™ Scotch-Weld™ Solvent No. 2, methyl ethyl ketone (MEK), or 3M™ Citrus Base Cleaner.\*

**\*Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

# 3M™ Scotch-Weld™ Neoprene Rubber & Gasket Adhesive 2141

---

## Application Equipment Suggestions

Appropriate application equipment enhances adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

### 1. Pumping:

- A. **5 gallon or less dispensing system:** Use a pressure pot rated for 100 psi operating pressure.
- B. **55 gallon dispensing system:** Use a 2:1 ratio divorced design double acting ball check type pump, bung mounted. Packings and glands in contact with the adhesive should be PTFE.

2. **Hoses:** All material hoses should be nylon lined.

3. **Brushes:** Brushes designed to be used with oil based paints may be used.

---

## Storage and Handling

Store product at 60-80°F (15-26°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a "first-in first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 15 months.

---

## 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.

---

## Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

---

## Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

---

## Warranty, Limited Remedy, and Disclaimer

Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

---

## Limitation of Liability

Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

**ISO 9001:2000**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



### Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06  
St. Paul, MN 55144-1000  
800-362-3550 • 877-369-2923 (Fax)  
www.3M.com/industrial



*Recycled Paper*  
40% pre-consumer  
10% post-consumer

3M and Scotch-Weld are trademarks  
of 3M Company.  
Printed in U.S.A.

©3M 2010 78-6900-0266-8 (10/10)