

Technical data sheet



Product: 7260

Manufacturer: 3M DEUTSCHLAND GMBH

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

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3M SCOTCH-WELD 7260 NB B/A

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Scotch-Weld™ Epoxy Adhesive

7260 NB B/A

Product Data Sheet

Date: February 2017

Supersedes: NEW

Product Description

Scotch-Weld™ epoxy adhesive 7260 NB B/A is a toughened, two-part adhesive.

Possesses high shear and peel adhesion with high levels of durability.

Key Features

- Convenient (2:1) mix ratio by volume
- Good adhesion to metallic surfaces and thermosets and to many thermoplastics

Typical Uncured Properties

	Base	Accelerator
Base	Toughened Epoxy	Modified Amine
Colour	Black	Off-white
Specific Gravity ⁽¹⁾	1.28	1.27
Mix Ratio		
By Volume	100	50
By Weight	100	50
Viscosity ⁽²⁾ (Pa.s)	89	335
Worklife ⁽³⁾ (min)	570	

(1) Density measured using pycnometer at 23 °C.

(2) Viscosity measured using Brookfield RVF viscometer at 23 °C; reported viscosity at 2 rpm using spindle 7.

(3) Maximum time that adhesive can remain useable after a mix of 20g at 23 °C

Performance Characteristics

Overlap Shear Strength⁽⁴⁾

Test Conditions	Results (MPa)
-40 ± 2 °C	29,9 CF
23 ± 2 °C	34,8 CF
70 ± 2 °C	19,8 CF

4) Overlap shear values measured using EN-2243-1; adhesive allowed to cure for 3 hours at 65 °C; 200-300 µm bond line thickness; 12.5 mm overlap; samples pulled at 2.5mm/min s; all samples are FPL Etched Aluminium 2024T3 1.6 mm thick.

Failure modes:

AF: adhesive failure

CF: cohesive failure

SF: substrate failure

Performance Characteristics

Floating Roller Peel (N/25mm) width)⁽⁵⁾

Aluminium 2024T3 FPL Etched	7260 NB
23 °C	104 CF

(5) Floating roller peel values measured using EN 2243-2; adhesives allowed to cure for 3 hours at 65 °C; 200-300 µm bond line thickness; 25 mm wide samples; samples pulled at 150 mm/min; aluminium surfaces etched; substrates used were 1.6 mm thick and 0.5 mm thick aluminium.

Failure modes:

AF: adhesive failure CF: cohesive failure SF: substrate failure

Directions For Use

1. To obtain the highest strength structural bonds, paint, oxide films, oils, dust, mould release agents, and all other surface contaminants must be completely removed. The amount of surface preparation depends on the required bond strength and environmental aging resistance desired by user. For suggested surface preparations on common substrates, see the section on surface preparation.

2. Mixing

For Duo-Pak Cartridges

Store cartridges with cap end up to allow any air bubbles to rise towards the tip. To use, simply insert the cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. Then remove the cap and expel a small amount of adhesive to ensure material flows freely from both sides of cartridge. For automatic mixing, attach an EPX mixing nozzle to the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after obtaining a uniform colour.

3. Apply adhesive and join surfaces within the work life listed for the specific product. Larger quantities and/or higher temperatures will reduce this working time.

4. Allow adhesive to cure at 16 °C or above until completely firm. Applying heat up to 66 °C will increase cure speed.

5. Keep parts from moving during cure. Apply contact pressure or fixture in place if necessary. Optimum bond line thickness ranges from 100 to 500 µm; shear strength will be maximized with thinner bond lines, while peel strength reaches a maximum with thicker bond lines.

6. Excess uncured adhesive can be cleaned up with ketone type solvents*.

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

Surface Preparation

The following cleaning methods are suggested for common surfaces:

Steel & Aluminium:

1. Wipe free of dust and dirt with pure solvent such as acetone or isopropyl alcohol*.
2. Sandblast or abrade using clean fine grit abrasives.
3. Wipe again with clean solvent to remove loose particles*.
4. When using a primer, apply within 4 hours after surface preparation.

Where humid environments are likely to be encountered by metallic substrates we recommend additional priming with

3M™ Scotch-Weld™ 3901. Alternatively, chemical conversion coating

techniques combined with priming can offer the best durability.

Plastics/Rubbers:

1. Wipe with isopropyl alcohol*.
2. Abrade using fine grit abrasives.
3. Wipe with isopropyl alcohol*.

Glass:

1. Solvent wipe surface using acetone or MEK*.
2. Apply a thin coating of a silane adhesion promoter to the glass surfaces to be bonded and allow to dry completely before bonding.

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

Storage & Shelf Life

Store at 16°C – 25°C and 40-65 % relative humidity in its original box. The product can be stored up to 48 months after production.

Note: The shelf life may be shortened if the original packaging is not properly sealed or stored in an environment with high temperatures or humidity. Rotate stock on a "first in - first out" basis.

Precautionary Information

Refer to product label and Material Safety Data Sheet for health and safety information before using the product.
For information please contact your local 3M Office.
www.3M.com

For Additional Information

To request additional product information or to arrange for sales assistance, go to www.3M.be/bonding or www.3M.nl/bonding

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