Technical data sheet

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Manufacturer:	3M DEUTSCHLAND GMBH
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3M™ HYBRID ADHESIVE SEALANT 740

Tewipack Uhl GmbH
Industriestraße 15
D-75382 Althengstett

Telephone:
+49(0)7051/9297-0
Fax:
+49(0)7051/9297-99

E-Mail:
info@tewipack.de
Website:
www.tewipack.de

Managing director:
Alexander Uhl,
Michael Uhl
HRB 330424
Amtsgericht
Stuttgart

Bank details:
Sparkasse
Pforzheim
Calw
BLZ 666 500
85
Konto 17 787

Commerzbank
Sindelfingen
BLZ 603 400 71
Konto 8 001 166

Vereinigte
Volksbank AG
Böblingen
BLZ 603 900 00
Konto 80 089
003

Postbank
Stuttgart
BLZ 600 100
70
Konto 146
294 708

Hybrid Adhesive Sealant 740

Product Data Sheet

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Product Description

3M™ Hybrid Adhesive Sealant 740 is a one component sealant without isocyanates which forms permanent elastic bonds. It cures rapidly under the effect of atmospheric humidity to form a flexible and resistant joint with very good adhesion on most materials.
Is also suitable for car repairing (under body protection, chassis, spoilers, boots...)

Key Features

Features	Advantages
One component/moisture curing	• No Mixing • Simplifies production
Neutral product	• no isocyanates
Seals dissimilar materials	• Gives design flexibility
Adheres to a wide variety of materials	• Multiple uses and design flexibility
Permanently elastic	• Provides long lasting bonds
Fast curing	• Speeds production
Paintable	• yes

Technical Data

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

Properties	3M Hybrid Sealant 740
Tack-Free Time @ 23º C and 50% Relative Humidity	50 minutes +/- 10 minutes
Rate of Cure @ 23º C and 50% Relative Humidity	3 mm per 24 hours
Shore A Hardness (ISO 868-3 seconds)	>30
Density at 20º C	1,65 ± 0,05
Elongation at Break (ISO 37)	>300%
100% Modulus (ISO 37)	> 0,5 MPa (>73 psi)
Modulus at break (ISO 37)	> 1MPa (>140 psi)
Sagging (ISO 7390)	none
Service Temperature	-40ºC to + 90ºC
Colours	Grey, white
Application temperature	5ºC to + 35ºC

Resistance to dilute acids and bases	good
Water and salt spray resistance	Excellent
Consistency	Medium paste
UV resistance	Excellent
Compatibility with paints	Water based : yes Solvent based : testing required

UV Properties

The product has good resistance to UV aging and will retain strength and flexibility over long-term exposure to UV light. The white product may show some yellowing with long-term exposure to UV light.

Direction for use

Surface Preparation:

Surfaces to be sealed should be clean and dry. Surfaces should be free from grease, mould release, oil, water/condensation and other contaminates that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength. Suitable solvents include 3M™ Citrus Based Adhesive Remover, 3M™ Scotch-Weld™ Solvent No. 2 or methyl ethyl ketone (MEK).*

***When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures. Refer to product label and MSDS for further precautions. Always pre-test solvent to ensure it is compatible with substrates.**

Application:

Puncture seal in nozzle and knock out the thin seal at cartridge bottom before placing in a pneumatic caulking gun. (For flex packs cut off the small crimp at the end and then place in caulking gun barrel with the open end up). Assemble tip and retaining ring on gun, cut tip to desired size. Product should be used within 24 hours after seal is punctured and should be pressed firmly into the joint to ensure adequate contact of the sealant with the substrate. Apply product when temperatures are between 5º C and 35º C. In cold weather, store the product at about 20 ℃ befo re use. Do not apply on frozen surfaces or wet surfaces.
Do not apply over silicones or in the presence of curing silicones.
Avoid contact with alcohol and solvents during curing.
Sealant can be tooled immediately after applying to give desired appearance, such as using a putty knife to smooth the joint with soapy water.
Avoid any contact with non-cured hybrid sealant during curing.

Cleanup:

While sealant is still soft cleaning can be done with the same solvents used for surface preparation. If sealant is already cured, removal is done mechanically with razor knife, piano wire, sanding or 3M™ Scotch-Brite™ Moulding Adhesive and Stripe Removal Disc. This disc is available from 3M Automotive Aftermarket Division.

Application Equipment Suggestions	**Cartridge, Flex Pack, Bulk dispensing** Please contact your local 3M representative
Storage	3M Hybrid Sealant 740 must be stored in the original carton at 21℃ (70℉) & 50 % Relative Humidity for maximum sh elf life. Rotate stock on a “first in-first out” basis.
Shelf Life	When stored at the recommended conditions in original un-opened packaging, 3M Hybrid Sealant 740 has a shelf life of 12 months after date of manufacture.
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.se
For Additional Information	To request additional product information or to arrange for sales assistance, call: 08-92 22 50 Address correspondence to: 3M Svenska AB, Industri, 191 89 Sollentuna
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3M

3M Svenska AB
Industri
Bollstanäsvägen 3
191 89 Sollentuna
Tel: 08-92 22 50
Fax: 08-92 22 88
E-post: kundservice@mmm.com
www.3M.se/lim