

## 3M Scotch-Weld™ 2216 B/A Tan NS Epoxy Adhesive

Category : Polymer , Thermoset , Epoxy , Epoxy Adhesive

### Material Notes:

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A is a flexible, two-part, room temperature curing epoxy with high peel and shear strength.

Scotch-Weld epoxy adhesive 2216 B/A is identical to 3M Scotch-Weld Epoxy Adhesive EC-2216 B/A in chemical composition. Scotch-Weld epoxy adhesive 2216 B/A may be used for aircraft and aerospace applications if proper Certificates of Test have been issued and material meets all aircraft manufacturer's specification requirements. Information provided by 3M

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_3M-Scotch-Weld-2216-BA-Tan-NS-Epoxy-Adhesive.php](http://www.lookpolymers.com/polymer_3M-Scotch-Weld-2216-BA-Tan-NS-Epoxy-Adhesive.php)

Physical Properties	Metric	English	Comments
Brookfield Viscosity	75000 - 150000 cP	75000 - 150000 cP	Base, RVF #7 spindle, 20 rpm
	550000 - 900000 cP	550000 - 900000 cP	Accelerator, RVF #7 spindle, 20 rpm

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	65 - 70	65 - 70	
Shear Modulus	0.342 GPa	49.6 ksi	Torsion Pendulum Method
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	1.509 GPa	218.8 ksi	Torsion Pendulum Method
	@Temperature 0.000 °C	@Temperature 32.0 °F	
	1.946 GPa	282.3 ksi	Torsion Pendulum Method
	@Temperature -40.0 °C	@Temperature -40.0 °F	
Shear Strength	2.1984 GPa	318.85 ksi	Torsion Pendulum Method
	@Temperature -60.0 °C	@Temperature -76.0 °F	
	2.74 GPa	398 ksi	Torsion Pendulum Method
	@Temperature -100 °C	@Temperature -148 °F	
	4.21 MPa	610 psi	Overlap, Polyphenylene Oxide/PPO; ASTM D1002
	7.65 MPa	1110 psi	Overlap, Acrylic/Acrylic; ASTM D1002
	7.86 MPa	1140 psi	Overlap, ABS/ABS Plastic; ASTM D1002
	8.89 MPa	1290 psi	Overlap, PC/ABS Alloy / PC/ABS Alloy; ASTM D1002
	11.4 MPa	1650 psi	Overlap, Fiber Reinforced Polyester/Reinforced Polyester; ASTM D1002

Mechanical Properties	Metric	English	Comments
	11.9 MPa	1730 psi	Overlap, Polycarbonate/Polycarbonate; ASTM D1002
	16.2 MPa	2350 psi	Overlap, Al/Al; ASTM D1002
	18.3 MPa	2650 psi	Overlap, Etched Al, 100% RH at 49°C for 30 days
	18.6 MPa	2700 psi	Overlap, Etched Al, Tap water at RT for 30 days
	19.0 MPa	2750 psi	Overlap, Etched Al, JP-4 for 30 days
	21.0 MPa	3050 psi	Overlap, Etched Al, Anti-icing Fluid at RT for 7 days
	21.4 MPa	3100 psi	Overlap, Etched Al, Hydrocarbon Fluid for 7 days
	21.4 MPa	3100 psi	Overlap, CRS/CRS; ASTM D1002
	22.4 MPa	3250 psi	Overlap, Etched Al, Tap water at RT for 14 days
	22.8 MPa	3300 psi	Overlap, Etched Al, Salt Spray at RT for 30 days
	23.4 MPa	3400 psi	Overlap, Etched Al, 100% RH at 49°C for 14 days
	24.1 MPa	3500 psi	Overlap, Etched Al, Hydraulic Oil at RT for 30 days
	26.9 MPa	3900 psi	Overlap, Etched Al, Salt Spray at RT for 14 days
	30.51 MPa	4425 psi	Overlap, Etched Al, Air at 71°C for 35 days
	30.7 MPa	4450 psi	Overlap, Etched Al, Air at 149°C for 40 days
	2.76 MPa @Temperature 82.0 °C	400 psi @Temperature 180 °F	Overlap, Etched Aluminum; ASTM D1002
	13.8 MPa @Temperature -53.0 °C	2000 psi @Temperature -63.4 °F	Overlap, Etched Aluminum; ASTM D1002
	17.2 MPa @Temperature 24.0 °C	2500 psi @Temperature 75.2 °F	Overlap, Etched Aluminum; ASTM D1002
Peel Strength	4.38 kN/m	25.0 pli	T-Peel

Processing Properties	Metric	English	Comments
Cure Time	480 - 720 min	8.00 - 12.0 hour	Time to Handling Strength

Processing Properties Descriptive Properties	Metric	English Value	Comments Comments
Appearance		Tan	Accelerator
		Tan	
		White	Base

**Contact Songhan Plastic Technology Co.,Ltd.**

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