Technical Data Sheet

3M™ Neoprene Contact Adhesive 10

Product Description

3M™ Neoprene Contact Adhesive 10 is a multi-purpose contact adhesive which may be used to bond plastic laminate, aluminum, steel, wallboard, wood, masonry, rubber and canvas.

Product Features

- Roll or brush-applied.
- Fast drying.
- Adhesion to a wide variety of materials.
- Excellent resistance to plastic flow (creep).
- 60 minute bonding range.
- Meets the specification requirements of MMM-A-121, MMM-A-130B, and A-A-1936A.

Technical Information Note

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

Typical Physical Properties

Property	Values	Additional Information
Solids Content by Weight	21 to 25 %	
Color	Light Yellow (wet and dry)	
*Note	When bonding wood veneers, success is dependent on many variables such as environmental conditions, bonding process, type of base material, type of veneer, adhesive type and top coat finishing systems to name a few. It is the user's responsibility to thoroughly test any adhesive for its suitability in bonding wood veneers. It is also recommended to follow the veneer manufacturers recommendation and industry guidelines.	
Flash Point	-25 °C	View
Notes: TCC		
Flash Point	-14 °F	View

Notes: TCC

Solvent Resistance	Petroleum distillate, acetone, toluene and n-hexane	
Coverage	288 sq ft/gal	View

Notes: @ 2.5 g/ft² dry wt.

Viscosity	450 to 700 cP	View

Test Condition: 80°F(27°C)

Notes: Brookfield Viscometer RVF #2 spindle @ 20 rpm

Typical Uncured Physical Properties

Property	Values	Additional Information
Base	Polychloroprene	
Net Weight	6.9 ± 0.2 lb/gal	

Typical Performance Characteristics

Property	Values	Additional Information
180° Peel Adhesion	160 oz/in	View

Dwell/Cure Time: 24.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel

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

180° Peel Adhesion	208 oz/in	View

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel

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

180° Peel Adhesion	272 oz/in	View

Dwell/Cure Time: 120.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel

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

180° Peel Adhesion	304 oz/in	View

Dwell/Cure Time: 168.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel

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

180° Peel Adhesion	352 oz/in	View

Dwell/Cure Time: 2.0
Dwell Time Units: week
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel

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

180° Peel Adhesion	368 oz/in	View

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel

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

180° Peel Adhesion	448 oz/in	View

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: -30C
Temp F: -22F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel
Failure Mode: SF

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

180° Peel Adhesion	144 oz/in	View

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 82C
Temp F: 180F
Environmental Condition: 50%RH
Substrate: Cotton Duck to Cold Rolled Steel

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

Overlap Shear Strength	430 lb/in²	View

Dwell/Cure Time: 2.0
Dwell Time Units: week
Temp C: 23C
Temp F: 72F
Test Condition: Room Temperature
Substrate: Birch Plywood
Failure Mode: SF

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

Overlap Shear Strength	433 lb/in²	View

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 23C
Temp F: 72F
Test Condition: Room Temperature
Substrate: Birch Plywood
Failure Mode: SF

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

Overlap Shear Strength	676 lb/in²	View

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 23C
Temp F: 72F
Test Condition: -30°F(-34°C)
Substrate: Birch Plywood
Failure Mode: SF

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

Overlap Shear Strength	111 lb/in²	View

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 23C
Temp F: 72F
Test Condition: 180°F(82°C)
Substrate: Birch Plywood

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

Overlap Shear Strength	70 lb/in²	View

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 23C
Temp F: 72F
Test Condition: 225°F(107°C)
Substrate: Birch Plywood

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

Storage and Shelf Life

Best storage temperature is 60-70°F (16-27°C). Continuous exposure to higher temperatures may cause some increase in viscosity. Quality is not affected until the adhesives becomes thickened so that it is difficult or impossible to spread. 3M™ Neoprene Contact Adhesive 10 will not freeze, but continuous exposure to low temperature will cause a considerable increase in viscosity. After storage at low temperatures and before using, the adhesive must be thawed and stirred vigorously until the entire container regains its original viscosity. The thawing process should be done at approximately room temperatures, never at elevated temperatures. Several days may be required for thawing – particularly with larger containers. Rotate stock on a “first in-first out” basis.
When stored at the recommended conditions in the original, unopened container this product has a shelf life of 30 months from date of manufacture.

Industry Specifications

MMM-A-121
MMM-A-130B
A-A-1936A

Automotive Disclaimer

Select Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Bottom Matter

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Trademarks

3M trademarks of 3M.

Handling/Application Information

Application Equipment

Note: 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. Brushes: Use fiber or animal hair brushes. Do not use nylon or other synthetic fibers.

2. Rollers: Use solvent resistant paint rollers, designed for applying oil based paints.

Directions for Use

Working Temperature

1. The temperature of the adhesive and surfaces to be bonded should be at 65°F (18°C) or above.

2. Warm the can of adhesive by placing in a warm room, not in stove, oven or other possible ignition source.

3. If the room must be warmed, turn off the heater before opening container.

4. Leave heater off until all vapors are gone.

Application

1. Stir thoroughly before using.

2. Apply adhesive generously in a uniform film on both surfaces with either a fiber or animal hair brush, or pour and spread with paint roller (solvent resistant texturing type).

3. Porous surfaces may require 2 coats of adhesive.

4. A glossy film when completely dry indicates adequate adhesive.

5. Dull spots after drying indicate not enough adhesive; these spots must have another coat.

Assembly

1. Allow to dry until adhesive is no longer tacky (5-10 minutes).

2. Position surfaces carefully before assembly.

3. No adjustment is possible after contact.

4. Spacers such as dowels or strips of laminate, may be used to prevent premature adhesive/adhesive contact and bonding.

5. Slide out the spacers and apply uniform pressure, working toward the edges.

6. A 3 in roller used with maximum body pressure should be used to help ensure adequate contact and bonding, especially on the edges.

7. Bonded assemblies can be machined, trimmed or finished immediately after bonding.

Drying Time

1. Drying time depends on temperature, humidity, air movement and porosity of materials bonded.

Cleanup

1. Excess adhesive may be removed with a solvent such as methyl ethyl ketone.*

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

Surface Preparation

Note: Read and follow precautions before using this product.

Surface Preparation

1. For best results, all surfaces to be bonded should be dry and free from dirt, dust, oil, loose paint, wax, grease, etc.

2. Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone.*

3. If used for decorative laminate, laminate should have reached moisture equilibrium for the shop conditions.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40069426/
Safety Data Sheet SDS	https://www.3m.com.sg/3M/en_US/company-en_US/sds/?search=1&q=10

Family Group

Link Tags:

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Products	Solids Content by Weight
10	21 to 25 %

ISO Statement

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

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-

Information

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