



Scotch-Weld™ Cyanoacrylate Adhesive LO100

Product Data Sheet

Date: February 2010
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Product Description Scotch-Weld LO100 is a medium viscosity Alkoxyethyl Cyanoacrylate adhesive. The product has low volatility compared to Ethyl types which means that the white deposit known as blooming or chlorosis can be eliminated. Its low odour can also improve worker comfort in work areas where ventilation is limited. It is suitable for the bonding of a very wide range of materials.

Key Features LO100 is formulated for general purpose bonding of most plastics, rubbers and other common substrates. Recommended for use on close-fitting parts and smooth, even surfaces. It will not attack many low density foams such as expand poly-styrene, allowing the use of Cyanoacrylate to bond these substrates

Physical Properties

Base	Alkoxyethyl Cyanoacrylate
Soluble In	Acetone, MEK
Viscosity (cps)	Range 80-120 Typical Value 100
Specific Gravity	1.06
Colour	Clear

Performance Characteristics

Maximum Gap Fill (best results are obtained with very thin bond lines)	0.15mm
Fixture Time	10-60secs
Tensile Strength MPa (ISO 6922)	- after 3 minutes 4 – 11 - after 24 hours 9 - 20
Full Cure	24hrs
Speed of Cure	The speed of cure of cyanoacrylates varies according to the substrate to be bonded. Acidic surfaces such as paper and leather will have longer cure times than most plastics and rubbers.
Moisture Resistance	Low resistance to high levels of moisture and humidity over time.
Service Temperature Range	-50 to +70°C

Additional Product Information	Scotch-Weld Activators AC11 and AC12 may be used in conjunction with Scotch-Weld cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most Scotch-Weld cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30%.
Application Techniques	Bond speed is very fast so ensure that parts are properly aligned before bonding. Scotch-Weld Activators may be required if there are gaps or porous surfaces. Some plastics may require application of Scotch-Weld AC77 Primer. Ensure parts are clean, dry and free from oil and grease. Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.
Storage Conditions	Refrigerate to 5°C. Under such conditions shelf life will be 6 months. When stored in a cool, dry place away from direct sunlight shelf life will be reduced. Do not store in temperatures exceeding 21°C
Shelf Life	6 months from date of despatch by 3M when stored in the original carton at 5°C
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 information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA
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