SNAPSHOOT
ENGINEERED FOR A SAFER TOMORROW

현장을 이해하고, 필요한 솔루션을 연결합니다.

산업안전 · 추락방지 시스템
산업용 소재 · 건축자재
제품 제안부터 공급·시공·설치·교육까지



COMPANY INFORMATION

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TECHNICAL DOCUMENTS

인증서 · 데이터시트 · 기술자료

제품의 규격과 성능, 인증 및 적용 조건을 확인하기 위한 자료입니다.

ABOUT SNAPSHOOT

제품 공급을 넘어, 현장에 맞는 해결책으로

스냅슛은 산업현장의 작업 환경과 요구 조건을 바탕으로
적합한 제품과 시스템을 제안합니다. 현장 실사를 통해 설치 조건을 확인하고,
공급부터 시공·설치 및 사용 교육까지 필요한 과정을 함께합니다.

추락방지 시스템

안전대부착설비 · 수평·수직 라이프라인
레일 시스템 · 리지드 포스트

밀폐공간 진입·구조 솔루션

데빗암 · 삼각대 · 구조용 윈치
윈치 안전블록 · 구조장비

산업안전 보호구

전신형 안전대 · 랜야드 · 안전블록
작업 환경에 맞춘 개인보호구

산업용 소재·건축자재

산업용 테이프 · 접착제 · 기능성 소재
구조용 스크류 · 목조건축 자재

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홈페이지 바로가기 →
문서 라이브러리 바로가기 →
시공사례 바로가기 →
문의하기 →

본 페이지는 스냅슛의 자료 제공 안내용 표지입니다. 첨부된 인증서 및 기술자료의 발행 주체, 인증 대상과 적용 범위는 해당 원문을 기준으로 확인해 주세요.



English-US

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Supersedes: June, 2024

Technical Data Sheet

3M™ Scotch-Weld™ Polyurethane Reactive Adhesive TE015

Regulatory Info/SDS

Product Description

3M™ Scotch-Weld™ Polyurethane Reactive Adhesives are a family of one-component, moisture curing, urethane adhesives. These adhesives are applied warm and bond a wide variety of substrates such as wood, fiber reinforced plastic (FRP) and many other plastics to themselves, to metal and to glass.

3M™ Scotch-Weld™ TE015 is an extrudable, low viscosity adhesive that has a fast set time ideal for bonding wood. Yields thin glue lines.

Product Features

- 100% solids
- High strength bonds
- Rapid rate of strength build-up
- One component
- Broad substrate adhesion
- Various set times
- Highly plasticizer resistant
- Can be used to bond heat sensitive materials

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 Uncured Physical Properties

Attribute Name	Temperature	Value
Color (solid)		White/Off-White
Viscosity	121 °C (250 °F)	7,000 cP [1]
Density (molten)		8.9 lb/gal

[1] Measured on Brookfield viscometer with Thermosel using spindle #27

Typical Mixed Physical Properties

Attribute Name	Value
Open Time	1.5 min [1]
Time to Handling Strength	15 s [2]

[1] Max time allowed after applying adhesive to a substrate before bond must be closed and fixed. Cure times approximate and depend on adhesive temperature. Hotmelts: The approx. bonding range of a 3.2 mm (1/8 in) bead of molten adhesive on a non-metallic surface.

[2] Min time between bond creation and ability to support a 34 kPa (5 psi) tensile load. Open and set times determined by RT environment. Higher temps will lengthen open and set times, while lower temperatures will shorten open time and set time.

Typical Cured Characteristics

Temperature: 23 °C (73 °F)

Attribute Name	Test Method	Dwell Time	Value
Modulus	ASTM D638, ISO 527	7 d	25,000 lb/in² [1]
Shore D Hardness	ASTM D2240		65

[1] Die C, measured on 0.3 - 0.4 mm (0.011 - 0.017 in) thick films

Typical Performance Characteristics

180° Peel Adhesion

Temperature: 25 °C (77 °F)
Dwell Time: 168 h

Substrate	Value
ABS	93 lb/in width (Cotton duck failed during testing) [1]
Acrylic (PMMA)	21 lb/in width [1]
Aluminum	N/R lb/in width [1]
Fiber-Reinforced Plastic	28 lb/in width [1]
Glass	N/R lb/in width [1]
Polycarbonate (PC)	100 lb/in width (Cotton duck failed during testing) [1]
Polystyrene	N/R lb/in width [1]
Polyvinyl chloride (PVC)	100 lb/in width (Cotton duck failed during testing) [1]

[1] N/R – Not Recommended. 25 x 203 mm (1 x 8 in) flexible cotton duck (canvas) bonded to rigid 25 x 102 x 3.2 mm (1 x 4 x 0.125 in) substrates. Jaw separation 51 mm/min (2 in/min).
Bonds were prepared using the suggested procedure for the particular substrate tested.

Temperature: 23 °C (73 °F)
Dwell Time: 7 d

Attribute Name	Test Method	Substrate	Value
T-Peel Adhesion	ASTM D1876	Plasticized Vinyl	12 lb/in² [1]
Elongation at Break	ASTM D638, ISO 527		750 % [2]
Tensile Strength at Break	ASTM D638, ISO 527		3,950 lb/in² [2]

[1] The separation rate of the testing jaws was 51 mm/min (2 in/min).
Bonds were prepared using the suggested procedure for the particular substrate 25 mm wide (1 in) tested.
AF: adhesive failure CF: cohesive failure SF: substrate failure

[2] Die C, measured on 0.3 - 0.4 mm (0.011 - 0.017 in) thick films

Handling/Application Information

Directions for Use

Apply to clean, dry surfaces. Remove oil, grease and other contaminants by wiping with isopropyl alcohol.* For fiber reinforced plastics and other materials that are often contaminated with mold release agents, it is recommended that the surface be solvent wiped, abraded and solvent-wiped.* For additional information, see section on surface preparation. After heating to recommended application temperature, apply adequate amount of 3M™ Scotch-Weld™ Polyurethane Reactive Adhesive to one of the substrates to be bonded. Join the substrates within the adhesives specified open time and hold/fixture the bonded part until the adhesive has adequately set. Do not use to bond metal or glass to itself or each other or cure will not occur due to low moisture vapor transmission of the substrate.

(Important: Adhesive heated at application temperature for more than 16 hours should be discarded.)

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

Cleanup: Allow product to solidify. Remove uncured waxy material (usually within the first 20 minutes after application) by scraping with a putty knife or similar tool.
For cured material, remove by cutting or sanding. Do not use heat or flame to remove adhesive.

Cure Time: The cure rate will vary depending on air temperature, relative humidity, substrate type and bond line thickness. Cure rate is more rapid on wood (moisture rich substrate) than on plastic.

Surface Preparation

Plastic: Wipe with isopropanol soaked cheesecloth.* Allow solvent to evaporate before bonding. Note: 3M™ Scotch-Weld™ Polyurethane Reactive Adhesives are not recommended for bonding untreated polyolefins.
Plastic contaminated with mold release: Wipe with isopropyl alcohol soaked cheesecloth, abrade with fine grit abrasive, wipe with isopropyl alcohol soaked cheesecloth.* Allow solvent to evaporate before bonding.
FRP, Rubber and Aluminum (uncoated):Wipe with methyl ethyl ketone (MEK) soaked cheesecloth, abrade with fine grit abrasive, wipe with MEK soaked cheesecloth.* Allow solvent to evaporate before bonding. Priming may be necessary on aluminum if part will be subjected to hot/humid conditions.
Glass: Wipe with MEK-soaked cheesecloth.* Allow solvent to evaporate before bonding. Priming may be necessary on glass if subject part will be subjected to hot/humid conditions.
*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

Dispensing Equipment

3M™ Scotch-Weld™ Polyurethane Reactive Adhesive Cartridges can only be dispensed through the 3M™ Scotch-Weld™ Polyurethane Reactive Adhesive Applicator. Other container sizes can be dispensed through bulk equipment specifically designed for use with hot melt polyurethane reactive adhesives (P.U.R.). For more information on P.U.R. application equipment, contact your local 3M sales representative. All equipment must be used in strict accordance with the recommendations of the manufacturer.
WARNING: Do not use Scotch-Weld polyurethane reactive adhesive above 275°F (135°C). Scotch-Weld polyurethane reactive adhesive should not be applied to substrates that exceed 275°F (135°C).
Caution: Wear heat resistant gloves and safety glasses when handling.
Container sizes available:10 fl. oz. cartridge, 2 kilogram foil bag, 1 gallon can, five gallon pail, 55 gallon drum.

Storage and Shelf Life

For maximum shelf life, store product at normal indoor warehouse storage (below 120°F/49°C), indoors and protected from exposure to moisture. For best performance, use unopened 10 fluid ounce cartridge and 2 kg within 12 months and other sizes within 6 months from date of manufacture.

Available Sizes - Detailed

Available Package Sizes:

1/10th gallon cartridge[1] [2] 2 Kilo bag[3] 5 gallon pail 55 gallon drum
10 fluid oz/295ml 2 Kgs(4.4 lb) 36 pounds (16.3 kg) 400 pounds (181.4 kg)
Thread size for nozzle M15 X 1.5 Slug OD. – 5.0in (127 mm) Pail ID. – 11.25in (285.8mm) Drum ID. – 23.6in (600.5 mm) Pail Ht. – 13.5in (343 mm) Drum Ht. – 34.8in (883.9 mm)
[1]5 -1/10th gallon cartridges per case.
[2]10 disposable plastic nozzles are supplied with each case of adhesive.
[3]6 -2kg bags per case.

Approximate Coverage per container:

(Linear ft per container based on 1/8in dia. Bead size)

1/10th gallon cartridge	2 Kilo bag	5 gallon pail	55 gallon drum
250ft (76.2m)	1650ft (502.9m)	13,500ft (4114.8m)	170,200ft (51876.9m)

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 1-800-364-3577

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.

Information

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ISO Statement

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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