



# Scotch-Weld™ Acrylic Adhesive SA30 and Scotch-Weld™ Liquid Activator AC38

## Product Data Sheet

Updated : February 2010  
Supersedes: April 2007

### Product Description

Scotch-Weld SA30 is a two component, toughened acrylic adhesive system, which must be cured with Scotch-Weld AC38 Liquid Activator. Scotch-Weld SA30 does not require mixing prior to use and cures to give a tough, impact resistant bond with good peel strength.

### Physical Properties SA30

<b>Chemical Type</b>	Methacrylate ester
<b>Appearance</b>	Pale cream
<b>Specific Gravity</b>	1.03
<b>Viscosity cPs</b>	17,500 - 26,000 (Typical value 22,000)

### Physical Properties AC38

<b>Chemical Type</b>	Hydrocarbon
<b>Appearance</b>	Dark brown liquid
<b>Specific Gravity</b>	0.79
<b>Viscosity</b>	0.6 mm <sup>2</sup> /s
<b>Flash Point</b>	-4°C

### Performance Characteristics (SA30 cured with AC38)

<b>Max Gap Fill</b>	1mm The larger the bond gap the slower the cure speed. Initial fixture time with a bond thickness of 0.5mm can be up to 30mins. Bond strength dramatically decreases with bond gaps over 0.25mm
<b>Initial Fixture Time</b> (time to achieve 1 N/mm <sup>2</sup> on steel ASTM D1002)	90 secs
<b>Full Cure</b> (at 20°C)	24hrs
<b>Tensile Shear Strength</b> (ASTM D1002 on steel, 24hr cure)	15-22N/mm <sup>2</sup>
<b>Service Temperature Range</b>	-50 to +130°C -50 to +150°C (Intermittent)

---

<b>Application Techniques</b>	For best results ensure that parts are clean, dry and free from oil and grease, although good bonds may still be achieved on 'as received' or slightly oily parts. Scotch-Weld SA30 Adhesive should be applied to the most absorbent surface as beads or spread as a thin layer using a flat edge. Scotch-Weld AC38 Activator should be brushed on to the least porous surface and allowed to evaporate for at least one minute. The two parts should then be brought together and clamped or held in position to achieve best results.
<b>Additional Product Information</b>	Due to the anaerobic nature of this product, cure is faster when one of the substrates to be bonded is a metal. Some anti-corrosion chemicals inhibit the cure system in this type of product. Adhesive fillets squeezed outside the joint will remain slightly soft. SA30 is not recommended for use in pure oxygen or chlorine lines. It is recommended that testing is carried out on plastics prior to bonding as uncured Scotch-Weld SA30 may induce stress cracking in some circumstances.
<b>Storage Conditions</b>	Store the adhesive in a cool place away from direct sunlight.
<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C
<b>Precautionary Information</b>	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. <a href="http://www.3M.com">www.3M.com</a>
<b>For Additional Information</b>	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
<b>Important Notice</b>	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

---

Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

---

3M and Scotch-Weld are trademarks of the 3M Company.

3M United Kingdom PLC  
3M House,  
28 Great Jackson Street,  
Manchester,  
M15 4PA

Product Information :  
Tel 0870 60 800 50  
Fax 0870 60 700 99

3M Ireland Limited  
The Iveagh Building  
The Park, Carrickmines  
Dublin 18,  
Ireland

Customer Service :  
Tel (01) 280 3555  
Fax (01) 280 3509