



Scotch-Weld™ Neoprene High Performance Contact Adhesive 1357

Product Data Sheet

Date: May 2017
Supersedes: October 2014

Product Description

3M™ Scotch-Weld™ Neoprene High Performance Contact Adhesive 1357 can be used to bond most rubber, cloth, metal, wood, foamed glass, paper honeycomb, decorative plastic laminates and many other substrates.

Key Features

- Long bonding range.
- Good initial strength.
- High heat resistance.

Typical Physical Properties

	1357
Viscosity (Brookfield RVF (#3 spindle @ 20 rpm) (ISO 2555)	288 mPAs
Solids Content (EN ISO 827 / EN 3251)	20,8 %
Base	Polychloroprene
Colour (wet & dry)	Grey/Green
Specific Gravity (EN ISO 2811.1)	0.81 g/cm
Solvent	petroleum distillate, acetone, MEK, toluene, n-hexane

Typical Adhesive Performance Characteristics

180 ° Peel Strength - Tissue / Tissue ISO 8510-2 (Speed of pulling : 50 mm/min)		
Time @ 23 °C	Test Temp	Value (daN/cm)
24 h	23 °C ± 2 °C	11.9

Handling/Application Information

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

Directions for Use:

1. Surface Preparation: Remove all dust, dirt, oil, grease, wax, loose paint, etc.

Wiping with a solvent such as methyl ethyl ketone (MEK) or 3M™ Citrus Base Cleaner will aid in preparing the surface for bonding.*

2. Application Temperature: For best results the temperature of the adhesive and surfaces to be bonded should be at least 18 °C. If stored below -1 °C, warm-up to room temperature in a warm room only (do not exceed 50 °C followed by thorough agitation).

3. Application: Stir or agitate well before using for optimum results.

4. Drying Time: The adhesive dries in about 10 minutes. High humidity will slow drying-high temperatures speed the drying. This adhesive has a bonding range of approximately 30 minutes when applied to both bond surfaces under conditions of 21 °C and 35 % R.H. If the adhesive becomes too dry, apply another thin coat of adhesive to one surface, allow to become slightly tacky, and bond. Relative humidity above 50 % can cause blushing (condensation of moisture on surface) and a false bond.

To avoid this, we recommend a force drying temperature of 82 – 104 °C. Force drying will also help remove the solvent more rapidly.

5. Assembly: Spacers, such as dowels or strips of laminate, may be used to help prevent premature adhesive/adhesive contact and bonding prior to positioning.

Slide out of the spacers and apply uniform pressure, working toward the edges. A roller should be used with maximum body pressure to help ensure adequate contact and bonding, especially on edges. The use of a pinch roll is preferred for optimum performance. Bonded assemblies may be machined, trimmed, etc. immediately after bonding.

6. Clean-up: Adhesive residue of 3M™ Scotch-Weld™ Neoprene High Performance Contact Adhesive 1357 may be removed from exposed surfaces with solvents such as Methyl Ethyl Ketone (MEK), or 3M™ Citrus Base Industrial Cleaner.

* For flushing fluid lines use MEK.

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

Storage & Shelf Life

Store at 16 °C - 25 °C and 40 - 65 % relative humidity in its original box.

Higher temperatures reduce normal storage life. Lower temperatures

cause increased viscosity of a temporary nature.

Rotate stock on a "first in-first out" basis.

The product can be stored up to 30 months after production.

Note: The shelf life may be shortened if the original packaging is not properly sealed or stored in an environment with high temperatures or humidity.

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 product information or to arrange for sales assistance, call.....

Address correspondence to: 3M

Important Notice

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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

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