



# Scotch-Weld™ 1022

## 3M™ Universal Adhesive Sprayable 1022

### Product Data Sheet

#### Product Description

3M™ Universal Adhesive Sprayable 1022 is a high strength, fast setting nitrile based adhesive. Provides strong flexible bonds to leather, nitrile rubber, most plastics ideal for gasket attachment.

#### Key Features

- Excellent resistance to many fuels and oils
- Provides strong flexible bonds
- Bonds leather, nitrile rubbers, most plastics gasketing materials and metals to a variety of substrates.
- Used for bonding PVC floor tiles suspended floor panels..
- Optional heat cure improves physical properties, increases bond strength

#### Typical Physical Properties

<b>Consistency</b>	Light syrup
<b>Viscosity</b> (Brookfield RVF) ( ISO 2555 )	280 mPAs (#3 spindle @ 20 rpm)
<b>Solids Content</b> (EN ISO 827 )	25%
<b>Base</b>	Nitrile Rubber
<b>Colour (wet &amp; dry)</b>	Dark Brown
<b>Specific Gravity</b> ( EN ISO 2811.1 )	0.87 g/cm
<b>Solvent</b>	Acetone, Toluene, MEK

#### Typical Adhesive Performance Characteristics

<b>180 Peel Strength Canvas / Aluminium</b>	ISO 8510-2 Speed of pulling : 50mm/min	
<b>Time @ 23°C</b>	<b>Test Temp</b>	<b>Value (daN/cm)</b>
<b>96 hours</b>	<b>23°C ± 2°C</b>	<b>10.0</b>

#### Handling/Application Information

##### Directions for Use:

**1. Surface Preparation:** Surfaces must be dry and free from dust, oil, release agents and other contaminants. The surfaces are cleaned with compatible solvents and / or by roughening with Scotch-Brite or sandpaper. 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:** Apply by brush, spatula or spray. For best results the temperature of the adhesive and surfaces to be bonded should be at least 18°C

**3. Application:** Stir well before using

**Porous Surface(s):** Brush, flow or spray a thin, even coat of adhesive to one or both surfaces. Coating both surfaces is preferred since it gives greater strength and permits longer open time before bonding. Porous and absorbent materials may require more than one coat. Bond while adhesive is still wet or aggressively tacky. Join surfaces with firm pressure.

**Non-Porous Surfaces:** Brush, flow or spray a thin, even coat of adhesive to both surfaces. Allow adhesive to dry until tacky. Join surfaces with firm pressure.

**4. Drying Time:** Drying time depends on temperature, humidity, air movement, and porosity of the materials bonded. Greater immediate strength may be obtained by heat or solvent reactivation. See Reactivation below.

**5. Reactivation:** Reactivation by solvent can be done up to 6 months after gluing. For solvent reactivation, coat both surfaces with adhesive. Allow to dry tack-free. Lightly wipe one surface with a solvent such as methyl ethyl ketone (MEK).<sup>\*</sup> Complete bond within 30 seconds.

Reactivation by heat suitable for pre-coating gaskets for future heat reactivation. Coat both surfaces with adhesive. Allow adhesive to dry completely. Reactivate by heating one or both surfaces to a minimum of 82°C. Assemble immediately (while hot), using firm pressure to ensure contact.

**6. Curing:** 3M™ Universal Adhesive Sprayable 1022 may be heat cured to obtain improved physical properties. Cure assembled parts at time and temperature listed using 100 psi pressure on the bond line.

**7. Clean-up:** Excess adhesive may be removed with a solvent such as methyl ethyl ketone (MEK) or acetone, preferably while adhesive is still wet. When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

**Storage**

Store product at 15-27°C for maximum storage life. Higher temperatures will reduce shelf life. Lower temperatures will increase viscosity of a temporary nature. Rotate stock on a "first in-first out" basis.

**Shelf Life**

3M™ Universal Adhesive Sprayable 1022 has a shelf life at least 24 months

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**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](http://www.3M.com)

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**For Additional Information**

Further information on the safe handling of this product can be found in the safety data sheet.

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**Important Notice**

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 for 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

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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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Prix d'un appel local

[www.3m.com/fr](http://www.3m.com/fr)