



Scotch-Weld™

7231 B/A Structural Flooring Adhesive

Product Data Sheet

Updated : October 2001
Supersedes : November 2000

Product Description

Scotch-Weld™ Structural Flooring Adhesive 7231 B/A is a grey, two part, room temperature curing structural adhesive which has good green strength and low viscosity for ease of application.

Features:

The adhesive is specially suited to bonding typical flooring materials used in the transportation market.

Also has good adhesion to plastics, metal and glass.

Physical Properties

Not for specification purposes

	Base	Accelerator
Specific Gravity	1.35	1.15
Viscosity (mPa.s at 24°C)	2,500	11,000
Mixed Ratio - by weight	10	7
Colour	Black	Cream
Work Life	60 mins (2.5kg mixed product) 120 mins (200g mixed product)	
Time to handling strength	6 to 8 hours	
Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

Additional Product Information

Adhesive Mixing:

Mix only those amounts of adhesive which can be used within the work life of the mixture. To achieve optimum physical properties of the adhesive, mixing of the base and accelerator must be very thorough.

Care should be taken not to incorporate excessive air into the adhesive during mixing and application as entrapped air will tend to give a porous and weakened bond. When weighing the components, be sure that containers are free of wax or oil. When thoroughly mixed, the adhesive should be a uniform colour.

Work Life:

After mixing, the mixture remains workable for a time before it becomes too viscous to properly wet the surface to which it is applied.

The work life and rate of cure are both greatly affected by temperature and to some extent humidity, curing faster as temperature and humidity are raised. Use the mixed material within 20 minutes.

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Equipment Suggestions:

Application can be made with a spatula, trowel or flow equipment. Suitable two-part metering and mixing equipment is available.

Contact your 3M representative for assistance in selecting application equipment to suit your specific needs.

Coverage: 160-250 grams/m² Glueline thickness is determined by spreader.

Clean Up:

Excess adhesive can be cleaned up prior to curing with 3M Solvent No.2.

Note: 3M Solvent No.2 is flammable. When using solvents for clean up it is essential that proper safety precautions are observed.

Cure Cycle:

Keep parts from moving during cure, contact pressure only is necessary. Allow to cure at minimum 16°C (60°F).

Application

Characteristics :

Proper adhesive application is as important as proper bond design and adhesive choice to obtain maximum joint properties.

Improper adhesive application techniques can result in partial or complete failure of an assembly.

Surface Preparation

A thoroughly cleaned, dry, grease-free surface is essential for maximum performance.

Cleaning methods which will produce a breakfree water film on metal surfaces are generally satisfactory.

Storage Conditions

Store product at 16°C to 27°C (60°F to 80°F) for maximum storage life. High temperatures reduce normal storage life. Rotate stock on a "first in - first out" basis.

Additional Information

For any additional information please contact your local 3M representative

Health & Safety Information

For Health & Safety information, please contact the Product Responsibility Department
 Tel: 01344 860678

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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.



Tapes & Adhesives

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