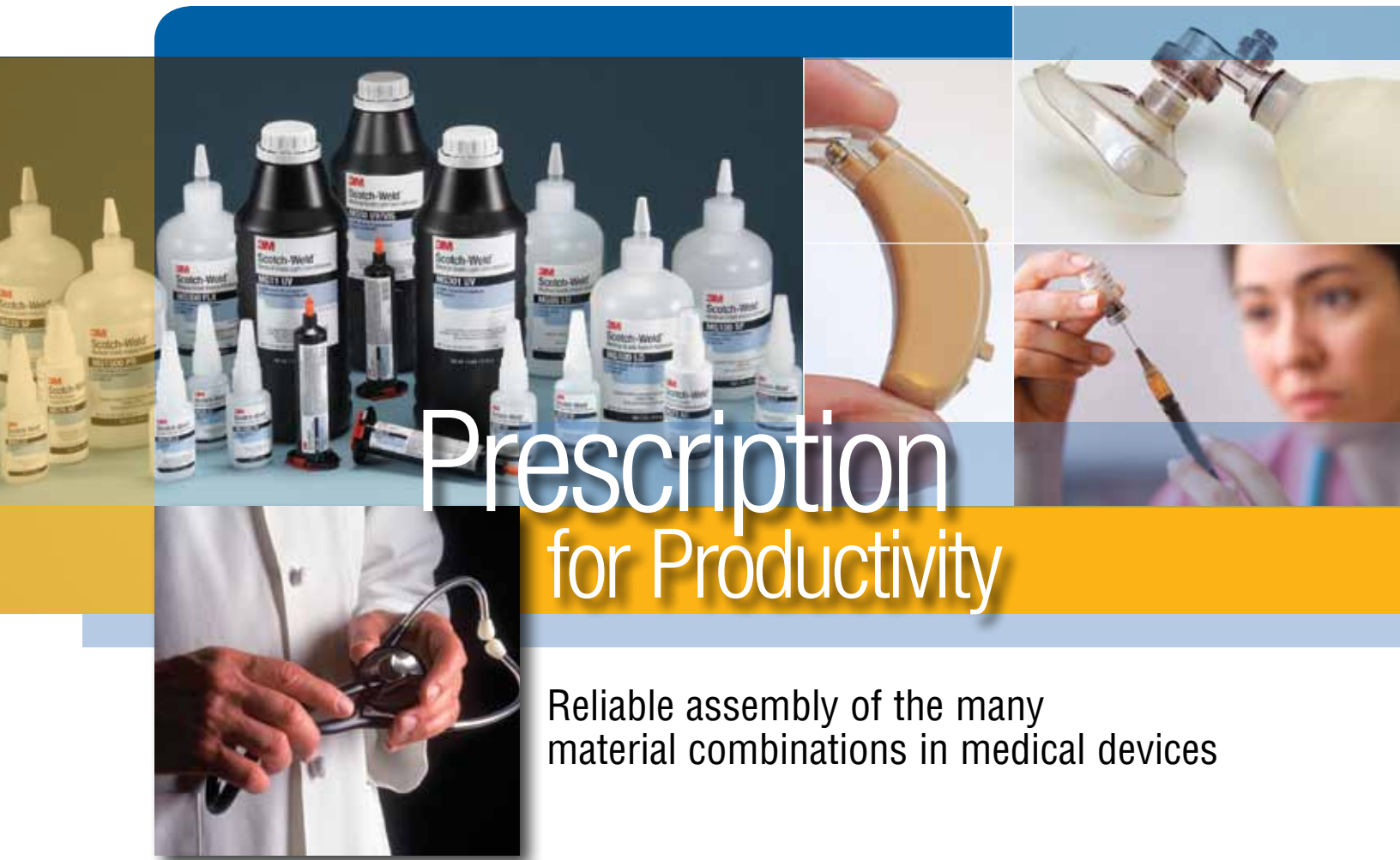


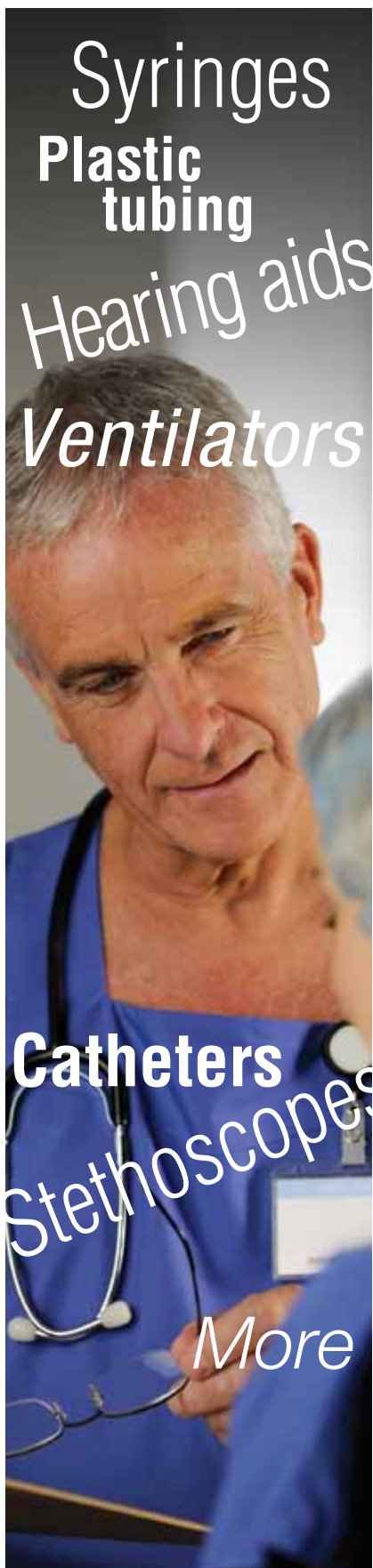
3M™ Scotch-Weld™ Medical Grade Adhesives



Prescription for Productivity

Reliable assembly of the many
material combinations in medical devices





3M™ Scotch-Weld™ Medical Grade Instant Adhesives

Seconds fast bonding of most plastics, rubber, and metals is just one of the many advantages of these structural strength adhesives.

- Fast curing with handling strength in as fast as 3 seconds
- Adhering difficult-to-bond plastics and rubber with little or no surface preparation, expanding your material options



- Low odor to reduce need for sophisticated ventilation
- Low/bloom/frosting for a more visually appealing product

- Flexibility for impact resistance
- Viscosities from wicking to gap filling
- Sizes matched to volume from prototyping to automated production

3M™ Scotch-Weld™ Medical Grade UV Curing Adhesives

Bond glass, most plastics and metals with clean, thin bond lines. Rapid cure and easy dispensing are among the many properties to help improve production and end use:

- Reach handling strength in as fast as 3 seconds to improve throughput
- Cures clear for the aesthetics of glass and plastic
- Temperature resistance up to 266°F (130°C)
- Range of UV curing or visible light curing to meet process and end use requirements
- Fluorescent capabilities for adhesive bond verification, improving process yield and quality
- Compatible with manual, semi-automatic, or fully automatic dispensing



3M™ Scotch-Weld™ Medical Grade Adhesives

Product	Typical Viscosity (cps)	Time to Handling (seconds)	Temperature Range	Description	UPC Number	Stock Number	Size
3M™ Scotch-Weld™ Instant Adhesives							
MG05 PR	5	10-30	-65° to 180°F (-54° to 82°C)	Exceptional performance on difficult-to-bond plastics and rubbers, together or in combination with metals and/or composites; superior performance on PVC, ABS, nylon, EPDM, and Sanoprene™; low viscosity wicking grade	000-5111-18826-2	62-6449-0350-2	28.3 g (1 fl. oz.)
					000-5111-18839-2	62-6449-3857-3	453 g (1 lb.)
MG1500 PR	1500	20-100	-65° to 180°F (-54° to 82°C)	Exceptional performance on difficult-to-bond plastics and rubbers, together or in combination with metals and/or composites; superior performance on PVC, ABS, nylon, EPDM, and Sanoprene™; high viscosity for gap filling	000-5111-18827-9	62-6465-0350-8	28.3 g (1 fl. oz.)
					000-5111-18840-8	62-6465-3857-9	453 g (1 lb.)
MG20 SF	20	3-30	-65° to 180°F (-54° to 82°C)	Super fast cure for high speed production; performance on difficult-to-bond plastics and rubbers; low viscosity	000-5111-18824-8	62-6451-0350-8	28.3 g (1 fl. oz.)
					000-5111-18831-6	62-6451-3857-9	453 g (1 lb.)
MG100 SF	100	3-30	-65° to 180°F (-54° to 82°C)	Super fast cure for high speed production; exceptional performance on difficult-to-bond plastics and rubbers; low viscosity	000-5111-18819-4	62-6474-0350-0	28.3 g (1 fl. oz.)
					000-5111-18830-9	62-6474-3857-1	453 g (1 lb.)
MG05 LO	5	5-60	-65° to 160°F (-54° to 71°C)	Low blooming/frosting for cosmetically critical applications; low odor to reduce requirement for sophisticated ventilation equipment; low viscosity wicking grade	000-5111-18825-5	62-6429-0350-4	28.3 g (1 fl. oz.)
					000-5111-18838-5	62-6429-3857-5	453 g (1 lb.)
MG100 LO	100	10-60	-65° to 160°F (-54° to 71°C)	Low blooming/frosting for cosmetically critical applications; low odor to reduce requirement for sophisticated ventilation equipment; low viscosity	000-5111-18828-6	62-6428-0350-6	28.3 g (1 fl. oz.)
					000-5111-18841-5	62-6428-3857-7	453 g (1 lb.)
MG300 FLX	300	10-35	-65° to 160°F (-54° to 71°C)	Extended resistance to impact, vibration, stress including peel, and humidity; faster curing than rubber toughened; medium viscosity	000-5111-18829-3	62-6459-0350-1	28.3 g (1 fl. oz.)
					000-5111-18842-2	62-6459-3857-2	453 g (1 lb.)
3M™ Scotch-Weld™ Instant Adhesive Primers							
MG77 AC	Polyolefin Instant adhesive primer; excellent for difficult-to-bond plastics, such as polyethylene and polypropylene; accelerate cure speed to increase throughput; acetone-based, may attack some sensitive plastics				000-51128-75928-8	62-6477-0850-2	56.6 g (2 fl.oz.)
MG79 AC	Elastomeric Instant adhesive primer; excellent for difficult-to-bond surfaces, including silicone, Santoprene™, EPDM and others; California compliant				000-51128-75934-9	62-6479-0850-8	56.6 g (2 fl.oz.)
3M™ Scotch-Weld™ UV Curing Adhesives							
MG90-77 UV	90	10	-58° to 248°F (-50° to 120°C)	Low viscosity, flexible, clear; bonds thermoplastics and metal	000-51111-07573-9	62-6480-5025-0	25 ml syringe
					000-51111-07574-6	62-6480-8350-9	1 Liter bottle
MG6500-74 UV/VIS	6500	3	-58° to 266°F (-50° to 130°C)	High viscosity, clear; bonds glass and metal; rapid cure	000-51111-07573-3	62-6482-5025-6	25 ml syringe
					000-51111-07678-1	62-6482-8350-5	1 Liter bottle
MG250-55 UV	250	5	-58° to 248°F (-50° to 120°C)	Medium viscosity, clear; bonds rigid PVC, polycarbonate, and other plastics; flexible for load-bearing and shock resistance	000-51111-18849-1	62-6478-5025-4	25 ml syringe
					000-51111-18857-1	62-6478-8350-3	1 Liter bottle

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity 75°F (24°C) (cps)	Approximate Mixed Worklife at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Average T-Peel at 75°F (24°C) (piw)	Overlap Shear (psi)		
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)
3M™ Scotch-Weld™ 2-Part Epoxy Adhesive									
2216 B/A (Gray)	High performance; very flexible bonds	2:3	80,000	90 minutes	10 hours	25	3,000	3,200	400

NOTE: This technical information and data should be considered representative or typical only and should not be used for specification purposes.

Biocompatibility and Sterilization

3M™ Scotch-Weld™ Medical Grade Instant and Light Cure Adhesives are intended for use on a wide variety of materials and plastics used in the assembly of short term (<30 days) medical devices and single use disposable medical products. These medical grade Adhesives have been tested in accordance with USP Class VI designation. The tests include Systemic Toxicity and Intracutaneous Toxicity.

Certificates of Compliance and clinical summaries are available upon request. It is the user's responsibility to determine the suitability of the adhesive for the medical device and its use including compliance to all regulatory standards.



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3M™ Scotch-Weld™ Medical Grade Adhesives are compatible with gamma, E-Beam and ethylene oxide sterilization methods. These products will have limited capability in autoclave sterilization and should be thoroughly tested for autoclave sterilization compatibility.

These products may be used in non-insertable, limited insertable (less than 24 hours), or prolonged insertable (less than 30 days) applications.

These products are not intended and should not be used for permanent applications defined as greater than

30 days contact duration. The adhesives are not intended for implantable medical devices or for direct application to the skin. It is the users responsibilities to complete all test and validate the adhesives suitability for medical grade applications.

For further information about the USP Class VI testing of adhesives please contact 3M at **800-362-3550** and request medical grade adhesive information.

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