



# Scotch-Weld™ Cyanoacrylate Adhesive PR20

## Product Data Sheet

Updated :February 2010  
Supersedes:February 2007

**Product Description** Scotch-Weld PR20 is a low viscosity Ethyl Cyanoacrylate adhesive. PR20 is formulated for very high speed, high strength bonding of plastics and rubbers.

**Key Features** PR20 is specially formulated for the building of most plastics and rubbers, but will also bond other common substrates. Recommended for use on close-fitting parts and smooth, even surfaces. Can be post-applied to pre-assembled parts.  
**Scotch-Weld PR grade cyanoacrylates are certified to USP Class VI**

### Physical Properties

<b>Base</b>	Ethyl
<b>Soluble In</b>	Acetone, MEK
<b>Viscosity (cps)</b>	Range 17-22 Typical Value 20
<b>Specific Gravity</b>	1.06
<b>Colour</b>	Clear

### Performance Characteristics

<b>Maximum Gap Fill</b> (best results are obtained with very thin bond lines)	0.10mm
<b>Fixture Time</b>	2-20secs
<b>Tensile Strength</b> (ISO 6922)	20 N/mm <sup>2</sup>
<b>Full Cure</b>	24hrs
<b>Speed of Cure</b>	The speed of cure of cyanoacrylates varies according to the substrate to be bonded. Acidic surfaces such as paper and leather will have longer cure times than most plastics and rubbers.
<b>Moisture Resistance</b>	Low resistance to high levels of moisture and humidity over time.
<b>Service Temperature Range</b>	-50 to +80°C

<b>Additional Product Information</b>	Scotch-Weld Activators AC11 and AC12 may be used in conjunction with Scotch-Weld cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most Scotch-Weld cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30%
<b>Application Techniques</b>	Bond speed is very fast so ensure that parts are properly aligned before bonding. Scotch-Weld Activators may be required if there are gaps or porous surfaces. Some plastics may require application of Scotch-Weld AC77 Primer. Ensure parts are clean, dry and free from oil and grease. Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.
<b>Storage Conditions</b>	Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months.  Refrigeration to 5°C gives optimum storage stability.
<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
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