



# Technical Data Sheet

## 3M™ Scotch-Weld™ Polyurethane Reactive Adhesive TE200



[Product Details](#)



[Regulatory Info/SDS](#)

### Product Description

3M™ Scotch-Weld™ Polyurethane Reactive Adhesives are a family of one-component, moisture curing, urethane adhesives. These adhesives are applied warm and bond a wide variety of substrates such as wood, fiber reinforced plastic (FRP) and many other plastics to themselves, to metal and to glass.

3M™ Scotch-Weld™ TE200 is an extrudable grade adhesive with fast set time, long open time ideal for bonding wood. Yields thin glue lines.

### Product Features

- 100% solids
- High strength bonds
- Rapid rate of strength build-up
- One component
- Broad substrate adhesion
- Various set times
- Highly plasticizer resistant
- Can be used to bond heat sensitive materials

### Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

### Typical Uncured Physical Properties

Attribute Name	Temperature	Value
Color (solid)		White/Off-White
Viscosity	121 °C (250 °F)	3,000 cP <sup>1</sup>
Density (molten)		1.07 g/cm <sup>3</sup> (8.9 lb/gal)

<sup>1</sup> Measured on Brookfield viscometer with Thermosel using spindle #27

### Typical Mixed Physical Properties

Attribute Name	Value
Open Time	4 min <sup>1</sup>
Time to Handling Strength	120 s <sup>2</sup>

<sup>1</sup> Max time allowed after applying adhesive to a substrate before bond must be closed and fixed. Cure times approximate and depend on adhesive temperature. Hotmelts: The approx. bonding range of a 3.2 mm (1/8 in) bead of molten adhesive on a non-metallic surface.

<sup>2</sup> Min time between bond creation and ability to support a 34 kPa (5 psi) tensile load. Open and set times determined by RT environment. Higher temps will lengthen open and set times, while lower temperatures will shorten open time and set time.

### Typical Cured Characteristics

Temperature: 23 °C (73 °F)

Attribute Name	Test Method	Dwell Time	Value
Modulus	ASTM D638, ISO 527	7 d	67 MPa (9700 lb/in <sup>2</sup> ) <sup>1</sup>
Shore D Hardness	ASTM D2240		60

<sup>1</sup> Die C, measured on 0.3 - 0.4 mm (0.011 - 0.017 in) thick films

## Typical Performance Characteristics

### 180° Peel Adhesion

Temperature: 25 °C (77 °F)

Dwell Time: 168 h

Substrate	Value
ABS	140 N/cm (80 lb/in) (Cotton duck failed during testing) <sup>1</sup>
Acrylic (PMMA)	81 N/cm (46 lb/in) (Cotton duck failed during testing) <sup>1</sup>
Aluminum	N/R N/cm (N/R lb/in) <sup>1</sup>
Fiber-Reinforced Plastic	140 N/cm (80 lb/in) (Cotton duck failed during testing) <sup>1</sup>
Glass	N/R N/cm (N/R lb/in) <sup>1</sup>
Polycarbonate (PC)	158 N/cm (90 lb/in) <sup>1</sup>
Polystyrene	16 N/cm (9 lb/in) <sup>1</sup>
Polyvinyl chloride (PVC)	140 N/cm (80 lb/in) (Cotton duck failed during testing) <sup>1</sup>

<sup>1</sup> N/R - Not Recommended. 25 x 203 mm (1 x 8 in) flexible cotton duck (canvas) bonded to rigid 25 x 102 x 3.2 mm (1 x 4 x 0.125 in) substrates. Jaw separation 51 mm/min (2 in/min). Bonds were prepared using the suggested procedure for the particular substrate tested.

Temperature: 23 °C (73 °F)

Dwell Time: 7 d

Attribute Name	Test Method	Substrate	Value
Elongation at Break	ASTM D638, ISO 527		625 % <sup>1</sup>
Tensile Strength at Break	ASTM D638, ISO 527		28 MPa (4000 lb/in <sup>2</sup> ) <sup>1</sup>
T-Peel Adhesion	ASTM D1876	Plasticized Vinyl	0.1 MPa (12 lb/in <sup>2</sup> ) <sup>2</sup>

<sup>1</sup> Die C, measured on 0.3 - 0.4 mm (0.011 - 0.017 in) thick films

<sup>2</sup> The separation rate of the testing jaws was 51 mm/min (2 in/min).

Bonds were prepared using the suggested procedure for the particular substrate 25 mm wide (1 in) tested.  
AF: adhesive failure CF: cohesive failure SF: substrate failure

## Handling/Application Information

### Directions for Use

Apply to clean, dry surfaces. Remove oil, grease and other contaminants by wiping with isopropyl alcohol.\* For fiber reinforced plastics and other materials that are often contaminated with mold release agents, it is recommended that the surface be solvent wiped, abraded and solvent-wiped.\* For additional information, see section on surface preparation. After heating to recommended application temperature, apply adequate amount of 3M™ Scotch-Weld™ Polyurethane Reactive Adhesive to one of the substrates to be bonded. Join the substrates within the adhesives specified open time and hold/fixture the bonded part until the adhesive has adequately set. Do not use to bond metal or glass to itself or each other or cure will not occur due to low moisture vapor transmission of the substrate.

(Important: Adhesive heated at application temperature for more than 16 hours should be discarded.)

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

**Cleanup:** Allow product to solidify. Remove uncured waxy material (usually within the first 20 minutes after application) by scraping with a putty knife or similar tool. For cured material, remove by cutting or sanding. Do not use heat or flame to remove adhesive.

**Cure Time:** The cure rate will vary depending on air temperature, relative humidity, substrate type and bond line thickness. Cure rate is more rapid on wood (moisture rich substrate) than on plastic.

## Surface Preparation

**Plastic:**Wipe with isopropanol soaked cheesecloth.\* Allow solvent to evaporate before bonding. Note: 3M™ Scotch-Weld™ Polyurethane Reactive Adhesives are not recommended for bonding untreated polyolefins.

**Plastic contaminated with mold release:**Wipe with isopropyl alcohol soaked cheesecloth, abrade with fine grit abrasive, wipe with isopropyl alcohol soaked cheesecloth.\* Allow solvent to evaporate before bonding. FRP, Rubber and Aluminum (uncoated):Wipe with methyl ethyl ketone (MEK) soaked cheesecloth, abrade with fine grit abrasive, wipe with MEK soaked cheesecloth.\* Allow solvent to evaporate before bonding. Priming may be necessary on aluminum if part will be subjected to hot/humid conditions.

**Glass:**Wipe with MEK-soaked cheesecloth.\* Allow solvent to evaporate before bonding. Priming may be necessary on glass if subject part will be subjected to hot/humid conditions.

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

## Dispensing Equipment

3M™ Scotch-Weld™ Polyurethane Reactive Adhesive Cartridges can only be dispensed through the 3M™ Scotch-Weld™ Polyurethane Reactive Adhesive Applicator. Other container sizes can be dispensed through bulk equipment specifically designed for use with hot melt polyurethane reactive adhesives (P.U.R.). For more information on P.U.R. application equipment, contact your local 3M sales representative. All equipment must be used in strict accordance with the recommendations of the manufacturer.

**WARNING:**Do not use Scotch-Weld polyurethane reactive adhesive above 275°F (135°C). Scotch-Weld polyurethane reactive adhesive should not be applied to substrates that exceed 275°F (135°C).

**Caution:**Wear heat resistant gloves and safety glasses when handling.

**Container sizes available:**10 fl. oz. cartridge, 2 kilogram foil bag, 1 gallon can, five gallon pail, 55 gallon drum.

## Storage and Shelf Life

For maximum shelf life, store product at normal indoor warehouse storage (below 120°F/49°C), indoors and protected from exposure to moisture. For best performance, use unopened 10 fluid ounce cartridge and 2 kg within 12 months and other sizes within 6 months from date of manufacture.

## Available Sizes - Detailed

### Available Package Sizes:

1/10th gallon cartridge<sup>1</sup> 2 Kilo bag<sup>3</sup> 5 gallon pail 55 gallon drum  
10 fluid oz/295ml 2 Kgs(4.4 lb) 36 pounds (16.3 kg) 400 pounds (181.4 kg)  
Thread size for nozzle M15 X 1.5 Slug OD. - 5.0in (127 mm) Pail ID. - 11.25in (285.8mm) Drum ID. - 23.6in (600.5 mm)  
Pail Ht. - 13.5in (343 mm) Drum Ht. - 34.8in (883.9 mm)  
<sup>1</sup>5 -1/10th gallon cartridges per case.  
<sup>2</sup>10 disposable plastic nozzles are supplied with each case of adhesive.  
<sup>3</sup>6 -2kg bags per case.

### Approximate Coverage per container:

(Linear ft per container based on 1/8in dia. Bead size)  
1/10th gallon cartridge 2 Kilo bag 5 gallon pail 55 gallon drum  
250ft (76.2m) 1650ft (502.9m) 13,500ft (4114.8m) 170,200ft (51876.9m)

## Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577

## Automotive Disclaimer

### Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

## Information

**Technical Information:** The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

**Product Selection and Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

**Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

**Limitation of Liability:** Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

**Disclaimer:** 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit [www.3M.com](http://www.3M.com).

## **ISO Statement**

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

3M™ Industrial Adhesives and Tapes Division  
3M Center, St. Paul, MN 55144-1000  
[3M.com/iatd](http://3M.com/iatd)

©3M 2024 (9/24)