

3M

Scotch-GripTM

Fire Resistant Rubber Based Adhesive

EC-4419

Technical Data

Issue No. 1

Introduction

3MTM Scotch-GripTM Fire Resistant Rubber Based Adhesive EC-4419 is a fire resistant, synthetic, rubber-based adhesive. It is commonly used for bonding gaskets in aircraft interiors and for attachment of de-icing boots.

Advantages

- Fire resistant
- Quick dry time
- Can be applied by brush or flow gun
- Controlled flow
- Even spreadability when brushed on

Physical Properties

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

Solids Content	39 ± 3%
Viscosity, Brookfield, RVF #6 at 20 RPM's @ 80°F in 1 pint can	10,000 - 18,000 cps
Net Weight	7.5 ± .3 lbs/gallon
Flash Point (closed cup)	-14°F (-26°C)
Color	Yellow
Base	Oil Resistant Elastomer
Consistency	Heavy Syrup

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Mechanical Properties	75°F (24°C) 180° Peel Strength 9-12 piw
	Nylon Webbing (MIL-W-4088, Type 17 Natural) to .063"
	Aluminum (2024-T3 or 7075-T6)

Fire Resistance	(60 Second Vertical Burn Test)		
		<u>Test Requirement</u>	<u>Test Result</u>
	Extinguish Time	5 second max	Pass
	Burn Length	5 inch max	Pass
	Drip Extinguishing	3 second max	Pass

Flame test conducted on a 5 mil dry coat of EC-4419 on 116 glass cloth.

Application	Surface must be clean, dry, and free from oil or grease. EC-4419 can be applied by brush or flow gun. Suggested Methods: A. 5 Gallon Pail Dispensing System 1) Pump – 5 to 1 minimum ratio double acting ball check, type pump 8.0 cubic inch/cycle, 3" air motor. 2) Primer – Single wiper follower plate. 3) Equipment – Graco Model 225-654 system which includes: Monark Pump 5 to 1 model number 204-392. Pyles Industries, Inc., Lincoln Engineering and Aro Corporation make similar equipment. B. 55 Gallon Drum Dispensing System 1) Pump – 5 to 1 minimum ratio double acting ball check, type pump 8.0 cubic inch/cycle, 3" air motor. 2) Primer – Inductor Plate. 3) Equipment – Graco 5 to Monark, Model Number 204227 with 204-490 inductor. Pyles Industries, Inc., Lincoln Engineering and Aro Corporation make similar equipment. C. Accessories 1) Hose – Samuel Moore Synflex hose or equivalent. 1,000 psi working pressure minimum. 2) Flow Gun – Graco model 203-420 with 1/8 tip or equivalent. D. Chemical Resistance Requirements Synthetic materials in contact with this material must be resistant to naphtha and toluol. E. Cleanup may be accomplished by using toluene.* *Note: When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.
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Storage	Store Product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature.
Shelf Life	3M Standard shelf life of EC-4419 adhesive is 6 months from date of shipment from 3M when stored in its original unopened can.

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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 or 651-737-6501.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free (800) 235-2376. Our fax number is (417) 869-5219. Address correspondence to: 3M Aerospace Central, 3211 E. Chestnut Expressway, Springfield, MO 65802.

Important Notice

3M MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M Adhesives Division product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which 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 of application.

Limitation of Remedies and Liability

If the 3M product is proved to be defective, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including, but not limited to, negligence, warranty, or strict liability.

ISO 9002

This Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



Adhesives Division

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