



# MEGUM™ 3340-1 Solvent-Based Adhesive

### DESCRIPTION

MEGUM 3340-1 is a one-coat adhesive for bonding polar elastomers to metals and other rigid substrates during vulcanization.

### Product Typical Properties

MEGUM 3340-1	
Appearance	Grey, liquid
Dry solid content (Non-volatile solids by weight)	23-26%
Viscosity, Brookfield (LV #2 spindle at 30 rpm)	50-250 mPa.s (cP)
Density (20°C)	0.90-0.94 g/cm <sup>3</sup>
Specific gravity (20°C)	0.92 g/cm <sup>3</sup>
Weight per gallon	7.7 lbs
Volume solids	13.9% (calculated)
VOC content per gallon	5.8 lbs (calculated)
Dry film density	1.62 g/cm <sup>3</sup> (calculated)
Flash point (Seta)	+4°C/39°F
These properties are typical and are not to be used for specifications purposes.	

### Main Features

**Composition :** MEGUM 3340-1 consists of reactive polymers and pigments in methyl isobutyl ketone (MIBK) and methyl ethyl ketone (MEK). It is formulated without reportable levels of lead or other toxic heavy metals.

**Elastomers :** NBR, HNBR, ACM, etc.

**Materials :** MEGUM 3340-1 adheres to hot and cold rolled steel, stainless steel, aluminium, brass, as well as thermoplastics such as polyamides and polyesters.

**Molding and Curing :** MEGUM 3340-1 can be used with all common molding and curing methods. Cure temperatures between 120°C and 205°C (250°F and 400°F) are recommended.

**Environmental Resistance :** Properly prepared bonds using MEGUM 3340-1 display resistance to external influences and high temperatures.

### DIRECTIONS FOR USE

#### Preliminary Surface Preparation

Properly preparing the metal surface is essential to obtaining consistent, high quality bonds.

A mechanical or chemical pre-treatment should follow degreasing. Common pre-treatments are grit blasting and phosphating. Further details are provided in our "Substrates Preparation Guide", please contact your usual Rohm and Haas commercial representative should you need a copy of this guide.

#### Mixing and Diluting

**Diluents :** Use ketones like MEK and MIBK.

First, thoroughly mix MEGUM 3340-1 with a propeller-type agitator. If diluting, slowly add the diluent to the adhesive while mixing constantly.

Continue to mix MEGUM 3340-1 while spraying or dipping to keep the dispersed solids from settling to the bottom. This will assure that a homogeneous mixture of the adhesive is applied.

#### Applying the Adhesive

MEGUM 3340-1 can be applied by brushing, dipping, spraying or other application methods.

#### Application Methods

##### **Brushing**

**Dilution ratio :** Use undiluted.

##### **Dipping**

**Dilution ratio :** 1 p.b.w. bonding agent + 0.1-0.5 p.b.w. diluent.

##### **Spraying with air**

**Dilution ratio :** 1 p.b.w. bonding agent + 0.5-2.0 p.b.w. diluent.

**Viscosity** : at 20°C/68°F.

5-25 mPa.s (cP) [Brookfield, LV#1 spindle at 60 rpm].

11-15 seconds [DIN-4-cup].

12-17 seconds [Ford-4-cup].

14-20 seconds [Zahn #2 cup].

**Spray gun** : Most spray equipment can be used.

**Nozzle** : e.g. 1.0 mm/0.04 in.

**Air pressure** : 2-4 bar/30-60 psi.

### Drying Time

The drying time is approximately 30 minutes at 20°C/68°F.

Drying at higher temperatures will reduce drying time accordingly, e.g. 5 minutes force drying at 80°C/176°F. Heated circulating air will further accelerate drying.

### Suggested Dry Film Thickness

Apply MEGUM 3340-1 at a dry film thickness of 3 to 15 microns (0.1 to 0.6 mil.).

### Dry Film Stability

MEGUM 3340-1 has excellent dry film stability. Inserts coated with MEGUM 3340-1 can be stored for several weeks, if protected from contamination.

### Theoretical Coverage

Applied at a dry film thickness of 10 microns (0.4 mil.), MEGUM 3340-1 will cover approximately 15 m<sup>2</sup>/kg (570 square feet/gallon).

### Cleaning

Cleaning should be done using recommended dilution solvents. Further details are given in our "General Guide to Use", please contact your usual Rohm and Haas commercial representative should you need a copy of this guide.

### Storage and Handling

Keep containers tightly closed. Store them in a cool, dry, well-ventilated area away from heat, direct sunlight and sources of ignition. Containers should be supported and grounded before opening, dispensing, mixing, pouring or emptying.

### Shelf Life

MEGUM 3340-1 has a shelf life of at least 9 months if stored unopened at temperatures below 25°C/77°F. If the material is kept beyond its recommended shelf life, a quality control evaluation should be performed prior to use. This check should include bond testing as well as evaluation of typical physical properties.

### Safety Information

Material Safety Data Sheets (MSDS) are available for all Rohm and Haas products. These sheets contain important information that you may need to protect your employees and customers against any known health and safety hazards associated with our products. We recommend that you obtain copies of our MSDS from your local Rohm and Haas technical representative before using our products in your facilities. We also suggest that you contact your suppliers of other materials recommended for use with our products for appropriate health and safety precautions before using them.

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