

 Scotchweld EC 2216 (5 pbw base / 7 pbw accelerator)

**PRODUCT**

<b>Material</b>	Scotchweld EC 2216
<b>Safety Data Sheet</b>	<a href="#">Safety Data Sheet</a>
<b>Product Data Sheet</b>	<a href="#">Product Data Sheet</a>
<b>General Information</b>	Flexible, two-part, room-temperature-curing epoxy
<b>Product Type</b>	2-part structural adhesive.
<b>Chemical Composition</b>	Modified Epoxy
<b>Manufacturer Name</b>	3M Belgium

**Address**

 3M Belgium	
<b>Name</b>	3M Belgium
<b>Address</b>	Hermes Laan, 7, B-1831 Diegem, Belgium
<b>Telephone</b>	+32 (0)2 722 51 11
<b>Fax</b>	+32 (0)2 720 02 25
<b>Website</b>	<a href="http://www.3m.com">www.3m.com</a>

**EXPERIENCE & AVAILABILITY**

<b>Development Status</b>	Commercial Product
<b>Cost Range</b>	Medium
<b>Lot Reproducibility</b>	Fair
<b>Space Experience</b>	Extensive

**GENERAL PROPERTIES**

<b>Pot Life</b>	90 min
<b>Quality Rating</b>	Manufacturer's data


**MECHANICAL PROPERTIES**

<b>Tensile Peel Strength</b>	3.6 N/mm
<b>Remarks</b> @ 24°C	
<b>Tensile Shear Strength</b>	21.3 MPa
<b>Remarks</b> @ 24°C	

**THERMAL PROPERTIES**

<b>Thermal Expansion Coefficient</b>	182 µstrain/°C
<b>Remarks</b> 40°C to 100°C 45 x 10 <sup>-6</sup> /°C for -100°C to 0°C	
<b>Specific Heat</b>	1.34 J/g.K
<b>Remarks</b> @ 0°C	
<b>Glass Transition Temperature</b>	11.8 °C
<b>Remarks</b> TMA	

**PROPERTIES RELEVANT TO SPACE USE**

<b>Flammability</b>	Pass
<b>Type of Test</b> NASA NHB 8060-1B	
<b>Outgassing status</b>	Pass
<b>Type of Test</b> NASA NHB 8060-1A	
<b>Temperature Range (Space)</b>	-50°C to 80°C.
<b>Type of Test</b> Long term.	
<b>Outgassing</b>	TML = 1.05%, RML = 0.58%, CVCM = 0.01%
<b>Outgassing Records</b>  Adhesive: 3M, Scotchweld EC2216	
<b>TML, Average</b>	1.05 %

For information purposes only.

**RML, Average** 0.579 %

**CVCM, Average** 0.00914 %

**Type of Test**

ECSS-Q-70-02

**SPECIAL RECOMMENDATIONS**

**Special Recommendations**

· The accelerator (catalyst) is sensitive to atmospheric humidity and CO2. Minimal exposure to atmosphere is recommended during storage and mixing. · Recommended cure is 2 hours at 70°C. · Quality control test by micro-VCM method (ECSS-Q-ST-70-02C) is recommended.

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