3M™ Scotch-Weld™ Medical Grade Adhesives

Prescription for Productivity

Reliable assembly of the many material combinations in medical devices
Seconds fast bonding of most plastics, rubber, and metals is just one of the many advantages of these structural strength adhesives.

- Fast curing with handling strength in as fast as 3 seconds
- Adhering difficult-to-bond plastics and rubber with little or no surface preparation, expanding your material options

3M™ Scotch-Weld™ Medical Grade Instant Adhesives

- Low odor to reduce need for sophisticated ventilation
- Low/bloom/frosting for a more visually appealing product
- Flexibility for impact resistance
- Viscosities from wicking to gap filling
- Sizes matched to volume from prototyping to automated production

3M™ Scotch-Weld™ Medical Grade UV Curing Adhesives

Bond glass, most plastics and metals with clean, thin bond lines. Rapid cure and easy dispensing are among the many properties to help improve production and end use:

- Reach handling strength in as fast as 3 seconds to improve throughput
- Cures clear for the aesthetics of glass and plastic
- Temperature resistance up to 266°F (130°C)
- Range of UV curing or visible light curing to meet process and end use requirements
- Fluorescent capabilities for adhesive bond verification, improving process yield and quality
- Compatible with manual, semi-automatic, or fully automatic dispensing
3M™ Scotch-Weld™ Medical Grade Adhesives

<table>
<thead>
<tr>
<th>Product (Color)</th>
<th>Key Features</th>
<th>Mix Ratio (Volume) B:A</th>
<th>Approximate Viscosity 75°F (24°C) (cps)</th>
<th>Approximate Mixed Worklife at 75°F (24°C)</th>
<th>Approximate Time to Handling Strength at 75°F (24°C)</th>
<th>Average T-Peel at 75°F (24°C) (piw)</th>
<th>Overlap Shear (psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2216 B/A (Gray)</td>
<td>High performance; very flexible bonds</td>
<td>2:3</td>
<td>80,000</td>
<td>90 minutes</td>
<td>10 hours</td>
<td>25</td>
<td>3,000</td>
</tr>
</tbody>
</table>

NOTE: This technical information and data should be considered representative or typical only and should not be used for specification purposes.
Biocompatibility and Sterilization

3M™ Scotch-Weld™ Medical Grade Instant and Light Cure Adhesives are intended for use on a wide variety of materials and plastics used in the assembly of short term (<30 days) medical devices and single use disposable medical products. These medical grade Adhesives have been tested in accordance with USP Class VI designation. The tests include Systemic Toxicity and Intracutaneous Toxicity.

Certificates of Compliance and clinical summaries are available upon request. It is the user’s responsibility to determine the suitability of the adhesive for the medical device and its use including compliance to all regulatory standards.

3M™ Scotch-Weld™ Medical Grade
Adhesives are compatible with gamma, E-Beam and ethylene oxide sterilization methods. These products will have limited capability in autoclave sterilization and should be thoroughly tested for autoclave sterilization compatibility.

These products may be used in non-insertable, limited insertable (less than 24 hours), or prolonged insertable (less than 30 days) applications.

These products are not intended and should not be used for permanent applications defined as greater than 30 days contact duration. The adhesives are not intended for implantable medical devices or for direct application to the skin. It is the users responsibilities to complete all test and validate the adhesives suitability for medical grade applications.

For further information about the USP Class VI testing of adhesives please contact 3M at 800-362-3550 and request medical grade adhesive information.