



Automotive Structural Adhesives

Scotch-Grip™ Fastener Adhesives 2510, 2510N (High Temp Formula)

Data Sheet

August 2004

Supersedes Data Sheet Dated June 2000

General Description



3M™ Scotch-Grip™ Fastener Adhesives are microencapsulated, room-temperature-curing adhesives which enhance the anchorage of threaded fasteners. The adhesives are designed to be coated on the fasteners and dried; they remain dormant until the shearing action of engaging the fastener into a nut or threaded cavity breaks the capsules and allows the adhesive to cure. Typical applications are fasteners for the engine compartment or safety-related parts.

Product Features	Performance Advantages	Customer Benefits
Epoxy chemistry	High torque values on coated fasteners Environmental resistance (to heat, automotive fluids, vibration, thermal and mechanical shock)	Robust, structural bonding performance
2-part (microencapsulated)	Extended shelf life (bulk adhesive and coated fasteners) Controlled reactivity (adhesive activates and cures upon insertion) Reusability (additional capsules break with each re-insertion)	Convenient handling by the end-users
Flow coatable formula	Allows controlled application to fasteners; viscosity can be adjusted to achieve target coating weights Penetrates oil coatings Fast drying Bonds to a broad range of fastener finishes	Broad handling, dispensing and drying windows for the applicators

Data Sheet 2510/2510N

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Product Descriptions	2353 (blue)	Normal Temp Formula. Designed for applications where the service temperature will not exceed 116°C (240°F)*. Refer to separate data page.	
	4844 (yellow)		
	2510 (orange)		High Temp Formula. Designed for applications where the service temperature might reach continuously up to 149°C (300°F), or intermittently up to 204°C (400°F).
	2510N (neutral)		

** While the functional service temperature upper limit for 2353/4844 is 116°C (240°F) the product can be exposed to temperatures as high as 177°C (350°F). At the higher temperatures there will be loss of adhesion but no damage to the adhesive. When temperature is lowered again, adhesion will be regained.*

Physical Properties	Bulk adhesive	2510/2510N
	Density	1006 kg/m ³ (8.4 lbs/gallon)
	% solids	52%
	Viscosity ¹	900-1500 cps
	Solvent base	Toluene

¹Brookfield viscometer, RVF #4 spindle at 20 rpm.

Handling/Process Properties	Bulk adhesive	2510/2510N
	Container sizes	18.9 liter (5 gallon) pails

Shelf life	Six months from date of receipt by customer Shelf life can be extended by re-mixing the adhesive regularly so that capsules do not coagulate on the bottom of the pails. Adhesive which is more than 6 months from the date of receipt should be checked for performance prior to application on fasteners.
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Storage conditions	Store pails at 4°- 38°C (40°- 100°F) PROTECT FROM FREEZING; storage below 0°C (32°F) for extended periods will freeze the adhesive and make it totally unusable. Storage above 49°C (120°F) will shorten the shelf life of the adhesive. Inventory should be rotated on a FIFO (first-in, first-out) basis.
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Coated fasteners	
Shelf life	One year from date of adhesive application Shelf life can be as long as four years, depending on the storage conditions. Fasteners which are more than one year from the date of adhesive application should be checked for performance prior to use.

Storage conditions	Store coated fasteners at 4°-38°C (40°- 100°F).
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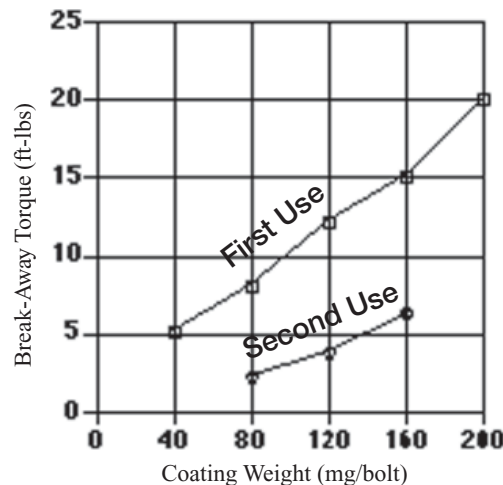
Performance Properties

Prevailing In Torque (PIT) initial ¹	2510/2510N 2 ft-lb (2.7 Nm)
Break-Loose Torque (BLT) initial ¹	35 ft-lbs (47.6 Nm)
Break-Away Torque (BAT) initial ¹ heat aging ² cycles ³ water immersion ⁴ gasoline immersion ⁵ hot motor oil immersion ⁶ transmission fluid immersion ⁷ anti-freeze immersion ⁸ at 275°F/135°C	12 ft-lbs (16.3 Nm) 25 ft-lbs (34.0 Nm) 32 ft-lbs (43.5 Nm) 33 ft-lbs (44.9 Nm) 24 ft-lbs (32.6 Nm) 23 ft-lbs (31.2 Nm) 32 ft-lbs (43.5 Nm) 25 ft-lbs (34.0 Nm) 7 ft-lbs (9.5 Nm)
Prevailing Out Torque (POT) initial ¹	9 ft-lbs (12.2 Nm)

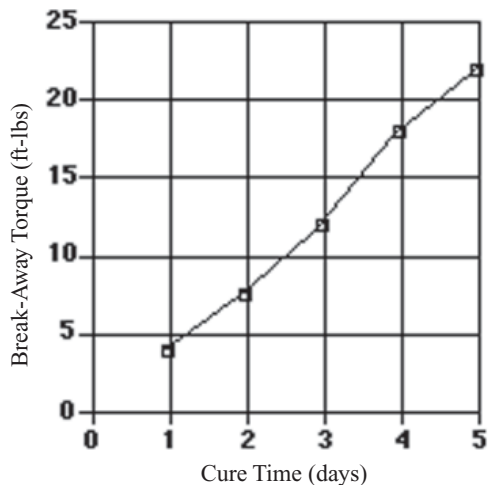
NOTE: These properties are representative of the products' performance, and are supported by laboratory test data. However, the values reported are not intended to be used for specification purposes. All testing, unless otherwise stated, was performed on 3/8" x 16" plain steel bolts with matching plain steel nuts.

- ¹ 72 hours at room temperature
- ² 3 weeks at 150°C (302°F)
- ³ Conditioned under 3 of the following cycles: 1 hour at 150°C (302°F), 2 hours at -30°C (-22°F), and 1 hour at 24°C (75°F)
- ⁴ Immersion in distilled water for 1 week at 24°C (75°F)
- ⁵ Immersion in regular, unleaded gasoline for 1 week at 24°C (75°F)
- ⁶ Immersion in SAE 30 motor oil for 1 week at 150°C (302°F)
- ⁷ Immersion in transmission fluid for 1 week at 150°C (302°F)
- ⁸ Immersion in a 50% solution of ethylene glycol in water for 1 week at 100°C (212°F)

Break-Away Torque (initial) vs Adhesive Coating Weight



Break-Away Torque vs Cure Time (at room temperature)



Definition of Terms

Prevailing In Torque (PIT): The maximum torque reading obtained during insertion of a bolt into a nut prior to seating, i.e., before fully torquing the bolt into place.

Break-Loose Torque (BLT): The initial torque reading obtained when a bolt is unscrewed after it has been seated, i.e., fully torqued into place.

Break-Away Torque (BAT): The initial torque reading obtained when a bolt is unscrewed after it has NOT been seated.

Prevailing Out Torque (POT): The maximum torque reading obtained when a bolt is being removed, excluding the BLT value; typically the value during the first full rotation of the bolt.

OEM Approvals

3M™ Scotch-Grip™ Fastener Adhesive 2510 meets the requirements of IFI 125 with a 72-hour room temperature cure and the following automotive specifications:

General Motors	6193M
Ford	ESA-M2G200-A ESS-M11P24-A1
Chrysler	PF-6616 MS-CC76

Health and Safety

Health and Safety Information: Read all Health Hazard, Precautionary, and First Aid statements found in the Material Safety Data Sheet (MSDS) and/or product label prior to handling or use. MSDSs are available on www.3M.com.

** Performance tests are run using standard test procedures. The values presented are typical values not to be used for specification purposes.

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Automotive Division

3M Center, Building 223-1S-02
St. Paul, MN 55144-1000
www.3M.com/Scotch-Grip



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