MEGUM™ 3276

Description

MEGUM™ 3276 is a vulcanizing adhesive primer used with MEGUM™ or THIXON™ cover coat adhesives for bonding most elastomers to various substrates. Also used as a one-coat for bonding polar rubber compounds such as nitrile or plychloroprene to metal or other materials.

Benefits & Features

Due to the unique chemical composition, this adhesive has shown extraordinary resistance to heat and hot water resistance under very demanding conditions. Either as a one-coat bonding polar rubber compounds or in conjunction with one of the fine THIXON™ or MEGUM™ cover coats it is a very durable primer adhesive.

Uncured Properties

<table>
<thead>
<tr>
<th>Uncured Properties</th>
<th>Nominal Value</th>
<th>Unit</th>
<th>Test Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Grey</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Solids Content</td>
<td>13 %</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>27 to 30 %</td>
<td></td>
<td>ASTM D2369</td>
</tr>
<tr>
<td>Density</td>
<td>0.938 to 0.969 g/cm³</td>
<td>ASTM D1475</td>
<td></td>
</tr>
<tr>
<td>Dry Film Density</td>
<td>1.8 g/cm³</td>
<td></td>
<td></td>
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<tr>
<td>VOC Content</td>
<td>5.80 lb/gal</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Flash Point</td>
<td>17.0 °C</td>
<td></td>
<td>DIN 53213</td>
</tr>
<tr>
<td>Viscosity (25°C, Brookfield LV)</td>
<td>0.20 to 0.60 Pa·s</td>
<td>ASTM D1084</td>
<td></td>
</tr>
<tr>
<td>Viscosity (25°C)</td>
<td>22 to 60 sec</td>
<td></td>
<td>Zahn Cup 3</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>22.0 m²/l</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Recommended Film Thickness</td>
<td>7.5 µm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Recommended Film Thickness Range</td>
<td>5.0 to 10 µm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Shelf Life (25°C)</td>
<td>24 month</td>
<td></td>
<td></td>
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</tbody>
</table>

Elastomer

This material is typically a primer coat for good environmental resistance under THIXON™ and MEGUM™ Cover and OSN-2 type coats. It can be used as a 1-coat bonding system for polar rubber compounds based on NBR, ACM, CR and AEM.

Substrate

Will bond various metals including hot and cold rolled steel, stainless steel alloys, brass, aluminum and zinc plated metals. Along with metals pre-treated with zinc, manganese and iron phosphate.

Surface Prep

Review Dow’s rubber-to-substrate bonding agent application guide or contact your account manager.

Mix Instructions

Diluents - MEK or MIBK

First, thoroughly mix MEGUM™ 3276 with a high speed propeller-type agitator. If diluting, slowly add the diluents to the adhesive while mixing constantly. Otherwise, the polymer base may precipitate from solution.

Continue to mix MEGUM™ 3276 while spraying or dipping to keep the dispersed solids from settling to the bottom. This will assure that a homogenous mixture of the adhesive is applied.

Application Technique

Brushing: use undiluted. To obtain the required film thickness, brush on a heavy wet film without brushing excessively.

Dipping: use without dilution or dilute 10 parts product with 1 part diluent.

Spraying: dilute two parts product with one part diluent.

Drying the Film

The drying time is approximately 60 minutes at 16°-27°C (60°-80°F). At lower temperatures, dry longer. The drying time can be shortened by force drying five minutes at 82°C (180°F). Do not dry at temperatures above 121°C (250°F).

Molding and Curing

Can be used with all common molding and curing methods. Cure temperatures between 100°C and 204°C (212 and 400°F) are recommended.
Pre-Bake Resistance
Coated inserts can be pre-baked for up to 5 minutes at 163°C (325°F) without adversely affecting bond quality.

Dry Film Stability
Excellent dry film stability. Inserts coated with product can be stored for several weeks if protected from contaminants.

Clean-up
Equipment clean up should be done using recommended dilution solvents.

Packaging/Sizes Available
Drums, pails and cans.

Storage & Stability
The shelf life of this material is assured for 12 months (from the date of manufacture) at temperatures below 78°F in an unopened container.

Toxicity and Safety Information
Read the Safety Data Sheet before using this material. Toxicity and safety information is included in the SDS.

Food Contact Applications
Dow Automotive products are not approved for direct or indirect food contact or drinking water applications. If your applications include food contact or drinking water requirements, please contact your Dow representative. For more information on the regulatory status of this product, please refer to the SDS for this product.

Notes
These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

1 By volume
2 Non-volatile solids by weight, 2 g/130°C/1 hour
3 Spindle #2, @ 30 RPM
4 Applied at a dry film thickness of 0.3 mil
5 Unopened
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Published: 2015-05-15

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