

HUDCO Industrial Products, Inc.

Adhesives

Tile and Structural Adhesive

HUDCO Formula 3100

HUDCO Formula 3100 is a high-strength adhesive formulated to provide greater chemical and heat resistance than HUDCO Formula 3000. Supplied as two contrasting colored thixotropic pastes to enable the user to visually know when the system is completely mixed. Its buttery viscosity and highly thixotropic texture keeps HUDCO Formula 3100 in place during application. Although developed primarily for bonding ceramic tile to itself or to metal, it readily bonds to most other solid substrates and shows superior adhesion at temperatures up to 350° F. It is especially useful for bonding dissimilar materials where differential expansion and contraction during temperature variations or vibrations would cause release of other adhesives.

Typical Applications

- Installation of ceramic tile to steel or aluminum.
- All high strength bonding requirements for similar and dissimilar substrates.
- General purpose adhesive where high strength is required with lap-shear strength exceeding 3400 PSI.
- Demonstrates superior adhesion at temperatures up to 350° F.

Physical Properties

Initial Curing Time	2-4 Hours @ 70° F
Post Cure	8 Hours @ 200° F
Pot Life	45 Min. @ 70° F
Viscosity	approx. 6000 poise
Lap Shear Strength: (min)	
Steel to Steel (ASTM-D 1002)	3400 PSI @ 70° F
Concrete to Concrete (ASTM-C382)	2800 PSI (dry)
Volatile content cured system. max	0.3%
Water absorption (ASTM-D570) max	0.5%
Shrinkage during cure (ASTM-C383)	Passes
Temperature max	350° F

Packaging

Kit	Resin	Curing Agent	Kit Weight
2 Quarts	2.75 lbs.	3.25 lbs.	6 lbs.
2 Gallons	11 lbs.	13 lbs.	24 lbs.



This reference guide is not intended as a substitute for the product label for the products referenced herein. Product labels for the above products contain important precautions, directions for use and product warranty and liability limitations that must be read before using the product. Applicators must be in possession of the product label(s) at the time of application. Always read and follow all label directions and precautions.

Application Instructions

Surface Preparation:

(A) Surface of substrates must be clean and sound.

(B) Remove grease, oil, or other foreign material with a film free solvent or hot detergent wash.

(C) Roughen surface by grinding or sandblasting (3-5 mil surface profile) Surface must be completely dry with a minimum surface temperature of 75° F before applying. Acid etching the surface is acceptable if followed by thorough flushing with clean water.

Mixing: Combine equal amounts of HUDCO Formula 3100 Resin with HUDCO Formula 3100 Hardener by volume. Mix thoroughly for several minutes making sure all the resin is blended with the entire curing agent. Accurate measuring and mixing are vital to complete curing and optimum performance.

Application: Apply product to prepared surface and use supplied tools to achieve desired finish.

Curing: Initial cure will occur in 2-4 Hours. **In order for the product to reach its 350° F potential, it must be post cured for 4 hours at a temperature of 200° F or higher.**

Safety Precautions

CAUTION: For Industrial Use Only. Keep Away From Children.

HUDCO Formula 3100 Resin contains epoxy resin which is harmful if swallowed. After prolonged exposure it may irritate skin and cause sensitization and/or dermatitis.

HUDCO Formula 3100 Curing Agent contains organic amine compounds which are harmful if swallowed. After prolonged exposure or repeated skin contact it may cause irritation, sensitization and/or dermatitis.

Emergency and First Aid Procedures

- Eye Contact - Irrigate with clean water for 15 minutes and call a physician.
- Skin Contact - Wash with soap and water.
- Inhalation - Remove to fresh air and provide oxygen if necessary.
- Ingestion - Call a physician at once. Give milk or white of egg beaten with water. Then give a teaspoon of salt in a glass of warm water to induce vomiting.

Protection Procedures

If used in a confined or an enclosed area, use an air supplied mask or respirator with canister for organic vapors and provide mechanical exhaust ventilation. Use protective gloves, safety glasses, and protective clothing. Avoid contact with skin and clothing. Contaminated clothing should be laundered before wearing again. Contaminated shoes should be thoroughly cleaned before wearing again.

Storage

HUDCO Formula 3100 Resin and Hardener should be stored in a cool, dry area. Shelf life is a minimum of one year in unopened containers when stored at 70° F – 85° F.

Warranty

Because the storage, handling and application of these materials are beyond our control, we can accept no liability for the results of their use. Our liability is limited only to replacement of any material proven defective in manufacture. We suggest users try small applications to determine the suitability of the product for their intended use.

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