

**HUDCO Industrial Products, Inc.**

Adhesives

**Tile and Structural Adhesive**

**HUDCO Formula 3000**

HUDCO Formula 3000 is a high-strength structural adhesive designed to provide strong permanent bonds to ceramic tile, steel, aluminum and other substrates. The plural component system is convenient to mix in equal parts by weight or volume. Hudco Formula 3000 Resin and Hardener are formulated in contrasting colored thixotropic pastes, which the user can easily monitor while blending into the third final color. Its buttery viscosity has high “tack” features that wet substrates immediately and keeps HUDCO Formula 3000 in place during application. Although developed primarily for bonding ceramic tile to itself or to metal, it readily bonds to most other solid substrates with superior adhesion at temperatures up to 250°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 of similar and dissimilar substrates.
- Convenient 1:1 by weight or volume mix ratio.
- Demonstrates superior adhesion at temperatures up to 250° F.

**Physical Properties**

Initial Curing Time	8 Hours @ 70° F
Final Curing Time	3 Days
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 @ 70° F
Volatile content cured system. max	0.3%
Water absorption (ASTM-D570) max	0.6%
Shrinkage during cure (ASTM-C383)	Passes
Specific Gravity	1.5 Mixed
Temperature max	250° F

**Packaging**

Kit	Resin	Curing Agent	Kit Weight
2 Quarts	2.5 lbs.	2.5 lbs.	5 lbs.
2 Gallons	11 lbs.	11 lbs.	22 lbs.
10 Gallons	55 lbs.	55 lbs.	110 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) Surfaces must be clean and sound. Remove grease, oil, or other foreign material with acetone or detergent wash. Roughen the surface by sandblasting or sanding with coarse abrasive using a cross-hatch pattern. Etching the surface with an appropriate acid is acceptable if followed by thorough flushing and neutralizing with clean water.

(B) Surfaces must be completely dry with a minimum surface temperature of 65° F before applying Hudco Formula 3000.

Mixing: Combine equal amounts of HUDCO Formula 3000 Resin with HUDCO Formula 3000 Curing Agent (Hardener) by weight or volume. Mix thoroughly for several minutes making sure all of the resin is blended with the entire curing agent with no visible streaks. Accurate measuring and mixing are vital to complete curing and optimum performance.

Application: Apply product to prepared surfaces and join together immediately. Allow bonded components to lie undisturbed until product has developed initial cure.

Curing: Initial cure will occur in 8 hours. Final cure occurs in 3 days. Curing may be expedited by heating bonded components to 150 degrees F after initial cure. Maintain 150 to 180 degrees F for 2 hours then remove heat source. Bond strength and chemical resistance are greatly enhanced when components are post cured at 150 to 180 degrees F.

## Safety Precautions

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

HUDCO Formula 3000 Resin contains epoxy resin which is harmful if swallowed. After prolonged exposure it may irritate skin and cause sensitization and/or dermatitis.

HUDCO Formula 3000 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 3000 Resin and Curing Agent 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.

### **HUDCO Industrial Products, Inc.**

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