



**Scotch-Weld™**  
Structural Adhesive



# Product Selection Guide

Matching 3M Structural Adhesives to your design, performance and process requirements

June 2024



# Design with Confidence. Build to Last.

In today's world, successful new products demand advancements in design, manufacturing processes and end-use performance. Industrial engineering and design professionals around the world depend on 3M™ Scotch-Weld™ Structural Adhesives to help them design beyond the limits of mechanical fasteners to create next generation products.

## Trusted innovations from aerospace to office space

With over 60 years of experience developing innovative structural adhesives for aerospace, automotive and hundreds of other industries, 3M delivers the solutions you can trust. Our advanced formulations create durable bonds, even on challenging materials or in extreme conditions.

## 3M global service and support

3M supports our customers with the testing, technology, and training needed to help our customers create better products. Our world-wide support staff has the experience you can rely on.

- 3M Application Engineers can work directly with you to test the strength performance of multiple adhesives, using your specific substrates under different heat, humidity and force tests.
- Finite Element Analysis (FEA) and data modeling.
- Online and video-based training services, online product comparison and selection tools and real-time customer support live chat.

## 3M Bonding Process Center

Improving your production process is a must if you want to stay ahead of the competition. 3M can help. We've created a state-of-the-art Bonding Process Center with three locations around the world where our scientists and engineers can work with you in person or remotely to address your production challenges. Whether you want to try new innovations in dispensing and automation or are simply looking for a better tape or adhesive to bond your parts together, the 3M Bonding Process Center will work with you to find customized solutions for your production challenges.

We'll work with you to explore bonding with different types of adhesives and dispensing options from powered manual dispensers all the way to fully programmable machinery.

For more information, please visit [3M.com/bondingprocesscenter](https://www.3m.com/bondingprocesscenter).

**3M™ Scotch-Weld™ Structural Adhesives are transforming the way engineers think.**

# Advancing design, process and performance

The benefits of designing and building products with 3M™ Scotch-Weld™ Structural Adhesives help drive product success. Eliminating mechanical fasteners provides a wide range of benefits for all stages of product development.



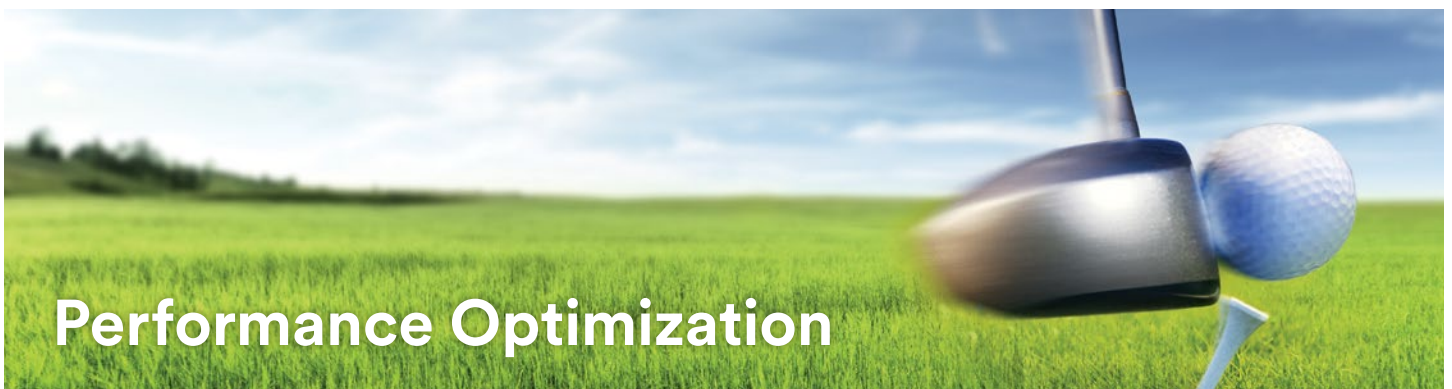
**Improve Aesthetics:** Improve product appearance with invisible joints and smoother bond lines, reduce weight and noise, enhance corrosion and fatigue resistance, and more.

**Freedom of Design:** Join composites to metal, build with hard-to-bond plastics, and use thinner, lighter weight materials.



**Enhance Productivity:** Reduce labor and material costs, build faster with minimal surface prep and match cure rates to your process needs.

**Accurate and Easy:** Dispense by hand or with automated equipment, and choose from a wide range of viscosities and flow rates.



**Strong, Flexible Bonds:** Adhesives bond and seal simultaneously, eliminate stress concentration and absorb shock and vibration for durable bonds.

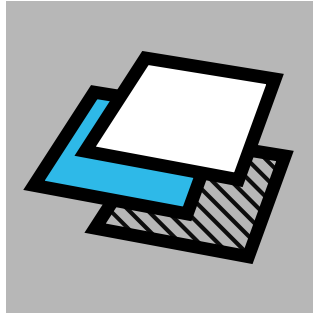
**Increased Durability:** Resist chemicals, environment, galvanic corrosion, fatigue, and material separation along edges or corners.

# Simplifying Adhesive Decisions for Your Application

The following questions will help you narrow adhesive choices to a few possibilities for evaluation.

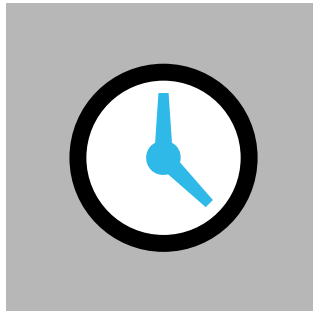
## Q: What materials will be bonded?

A: Structural adhesives work by adhering to the top surface of the bonded parts, so it's important to know the exact material and condition on those surfaces. For metals, will the adhesive be applied to bare metal, or will there be a paint or coating on the surface? For plastics, exactly which base resin? Could there be residual release agents on the surfaces used for mold release?



## Q: What is the preferred cure speed?

A: The chosen structural adhesive must have enough work life (open time, pot life) to allow proper mixing and application of the adhesive and assembling of the bonded parts. Smaller assemblies or shorter cycle time production processes may be able to use a faster curing adhesive with a work life of only five minutes or less, while larger assemblies that require alignment and clamping will probably need a work life of 20 minutes or more.



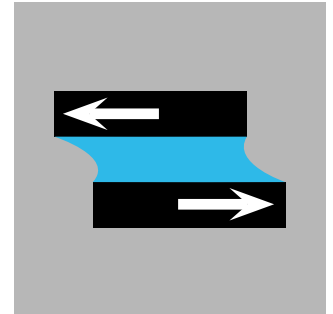
## Q: What surface preparation will be required?

A: Structural adhesives generally prefer clean, rough, dry surfaces for highest bond strength. This typically means either light abrasion and solvent cleaning of the surface, or solvent cleaning followed by chemical etching or applying a primer. Adhesion tests should be performed to determine the adequate surface preparation for a specific application.



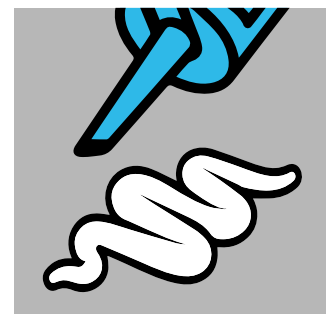
## Q: What types of joints are best for structural adhesives?

A: Joint designs that put the adhesive bond under shear, tension, or compression forces will provide the highest strength. Designs that tend to apply peel or cleavage forces to the adhesive, where the applied stresses are not distributed over the entire bond area, will have lower bond strength, but the bond may still be sufficient for the needs of the application. In addition, optimum bond line thickness typically ranges from 0.005" to 0.020". The adhesive qualification process should always include testing of prototype assemblies to ensure the adhesive will provide enough performance.



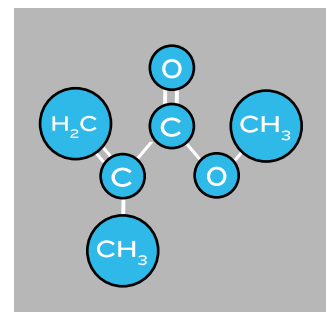
## Q: How are structural adhesives used and applied?

A: Structural adhesives come in many forms, including low viscosity liquids and non-sag pastes, one- and two-component formulations, short and long work lives, and various package sizes and shapes. Most two-part structural adhesives are available in both bulk containers and convenient, easy-to-use cartridge mixing systems.



## Q: What are the general characteristics of the different types of structural adhesives?

A: All structural adhesives provide at least 1,000 psi of overlap shear strength to aluminum, but the different adhesive chemistries have various properties:



- **Epoxy adhesives** come in both two-part adhesives (that cure upon mixing the two components) and one-part adhesives (that cure with temperature). They generally have the highest strength and overall performance. They also provide the best resistance to high temperatures, solvents and outdoor weathering. They adhere well to metals, woods and concrete, and the flexible epoxy adhesives also bond to some plastics and rubbers. Epoxy adhesives usually require clean, abraded surfaces to obtain maximum bond strength.

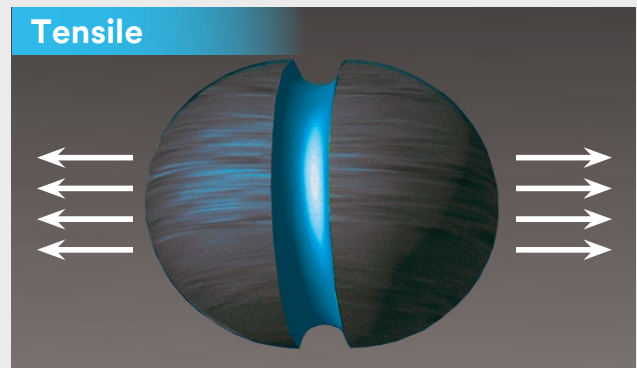
- **Acrylic adhesives** are two-part adhesives that provide excellent bond strength and durability, although slightly lower than epoxy adhesives. However, they have several features that make them easier to use in many applications and manufacturing processes. These benefits include a much faster cure speed, higher tolerance for oily or unprepared bonding surfaces and the ability to bond a wide variety of materials, including nearly all plastics. Newer acrylic adhesive formulations are room temperature stable with a long shelf life, and some have much lower odor than regular acrylic adhesives.

- **Urethane adhesives** are two-part adhesives that are relatively flexible when cured, and therefore tend to have excellent impact resistance and good adhesion to most plastics. They also bond well to woods, concrete and rubbers, but they tend to have reduced resistance to solvents and high temperatures. Uncured adhesive components are sensitive to moisture.

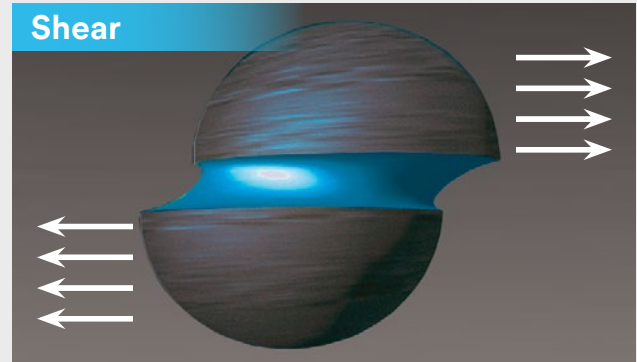
- **Cyanoacrylate adhesives** (instant adhesives) are one-component, lower viscosity liquids that cure extremely quickly with just contact pressure and surface moisture. They adhere well, with thin bond lines, to plastics, metals and rubbers. With the use of primers, they can also adhere to low surface energy plastics and elastomers. They tend to have low flexibility, peel strength and impact resistance compared to other structural adhesives. They are generally used for applications such as gasket bonding and smaller assemblies.

- **Anaerobic adhesives** are one-part adhesives that cure on active metal surfaces when oxygen gets excluded from the bond line. These products keep your factory running efficiently, reducing maintenance and leakage. They do not bond well to glass, plastics or rubbers, and are primarily used for applications such as locking threads and sealing pipe connections.

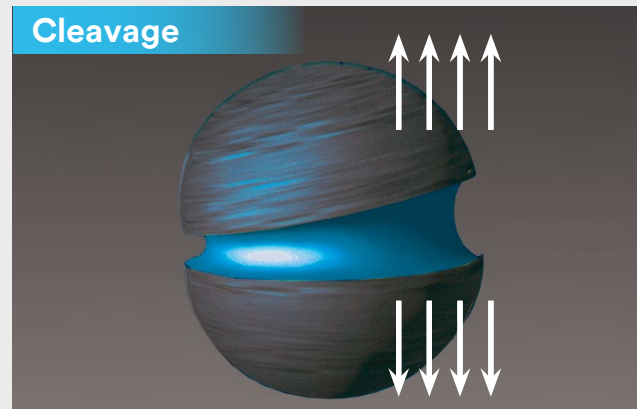
- **PUR adhesives** (Polyurethane-reactive adhesives) are one-part adhesives that apply like a hot melt, but cure with ambient moisture for near structural strength bonds. Fast set times and build strength over the next 24-48 hours can reach as much as 1,000 psi in overlap shear strength. They are flexible and resistant to temperature extremes and most solvents. Most commonly used in bonds where at least one substrate contains or transmits moisture (such as wood or plastic).



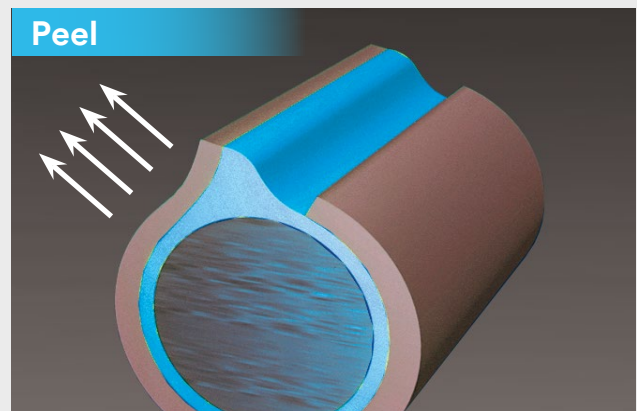
**Tensile** is pull exerted equally over the entire joint. Pull direction is straight and away from the adhesive bond.



**Shear** is pull directed across the adhesive, forcing the substrates to slide over each other.



**Cleavage** is pull concentrated at one edge of the joint, exerting a prying force on the bond. The other edge of the joint is theoretically under zero stress.



**Peel** is concentrated along a thin line at the edge of the bond where one substrate is flexible.

# Key Markets & Applications

For 3M™ Scotch-Weld™ Structural Adhesives



## Sporting Goods

### Key Features & Benefits:

- Excellent impact resistance of high stressed bonds
- High strength for small joints
- High strength bonding of rubber, composites and metals to each other

### Key Products:

DP420NS, DP8010, DP8710NS, PR100, DP8910NS

## Specialty Vehicle

### Key Features & Benefits:

- Weight reduction
- High strength
- Vibration & fatigue resistance

### Key Products:

DP6330NS, DP8410NS, DP8610NS, LSB60NS, TL42



## Signage

### Key Features & Benefits:

- One adhesive to bond all of your substrates
- Strong formulations and thin bond lines
- Weather resistance
- UL recognition

### Key Products:

DP100 Plus, DP8405NS, DP8710NS, DP8805NS, PR Gel

## Metalworking

### Key Features & Benefits:

- High strength and durability
- Reduced surface preparation before bonding, and no grinding after bonding
- Save weight and improve appearance with adhesives instead of welds or rivets

### Key Products:

DP420NS, DP8407NS, DP8410NS



## Electronics

### Key Features & Benefits:

- Low halogen formulations available to meet customer needs
- Fast cure to speed production
- Protect sensitive electrical connections from the environment

### Key Products:

DP270, DP8705NS, DP8910NS, TS230, PR100, 6101



## Appliance

### Key Features & Benefits:

- Simplify operations by bonding after powdercoating
- Eliminate the challenge of bonding rigid to flexible substrates
- Noise damping
- Reduce complexity-bond and seal glass to metal in one step

### Key Products:

DP125, DP6310NS, DP8610NS, DP8710NS, DP8810NS, TS230, TL42

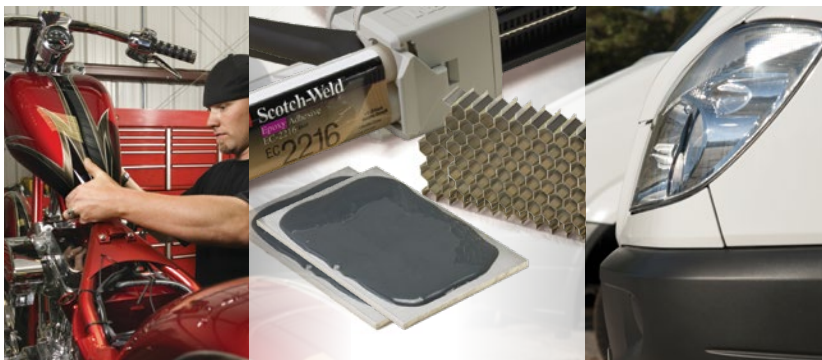
## Aerospace

### Key Features & Benefits:

- Available in UL94 or FST compliant options
- Strong, yet flexible bond lines

### Key Products:

2216, DP100FR, DP420NS, DP640, TL71



## Plastics, Composite, Rubber & Nylon

### Key Features & Benefits:

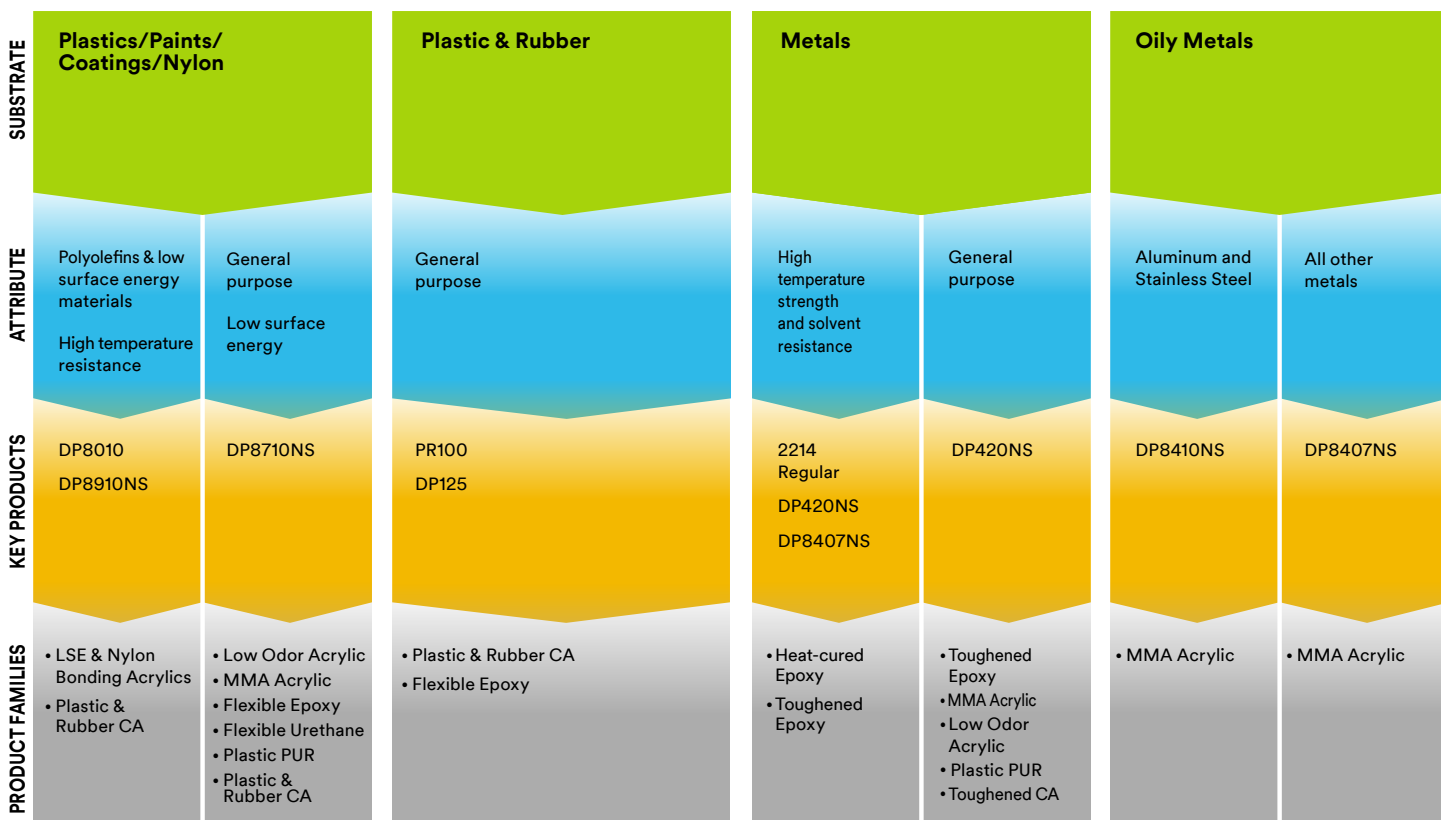
- Bonding of low surface energy plastics without priming
- Impact resistant composite and nylon bonding

### Key Products:

DP100 Plus, DP6310NS, DP8010, DP8405NS, DP8810NS, DP8910NS, TS230, PR100

# 3M™ Scotch-Weld™ Adhesives Selector Guide

**Step 1: Select Most Difficult Substrate**   **Step 2: Determine Key Attribute**   **Step 3: Select Product Family**



\*See chart in back of guide for more details.

**SUBSTRATE**   **ATTRIBUTE**   **KEY PRODUCT**   **PRODUCT FAMILIES**

## Structural Adhesive Families

**Rigid Epoxy Adhesives** — Higher tensile strength at lower elongations for greater long-term holding power. Mostly used for rigid substrates (metals) with high static loads.

**Flexible Epoxy Adhesives** — Lower tensile strength at higher elongations for greater capability to withstand differential movement of bonded parts; higher peel strength and higher adhesion to most plastics.

**Toughened Epoxy Adhesives** — Higher tensile strength at lower elongations for fatigue resistance; best suited for dynamic stresses. They have long-term holding power, higher peel strength, and exceptional higher resistance against shock, vibration and impact loads. Lower adhesion to most thermoplastics.

**Heat-cured Epoxy Adhesives** — One-component, rigid adhesives with outstanding strength at elevated temperatures. These adhesives require a thermal cure, typically around 250-350°F (120-180°C) for 40-60 minutes.

**MMA Acrylic Adhesives** — Provides greater adhesion to a wide variety of materials including most plastics and paint systems, are tolerant of many surface contaminations. High impact resistance for metal bonds.

**Low Odor Acrylic Adhesives** — Less odor than typical acrylic adhesives and faster rate of strength build than most two-part structural adhesives. Excellent adhesion to a variety of materials, including plastics and paint systems. They provide high impact resistance for plastic bonds; and are tolerant of many surface contaminations.

**LSE and Nylon Bonding Acrylic Adhesives** — Outstanding adhesion to polyolefin materials such as polypropylene, polyethylene, nylon, and TPO without surface treatment.

**Semi-rigid Urethane Adhesives** — Higher tensile modulus and lower elongation capability, with greater long-term holding power.

**Flexible Urethane Adhesives** — Lower tensile modulus and higher elongation capability. Excellent adhesion to most plastics.

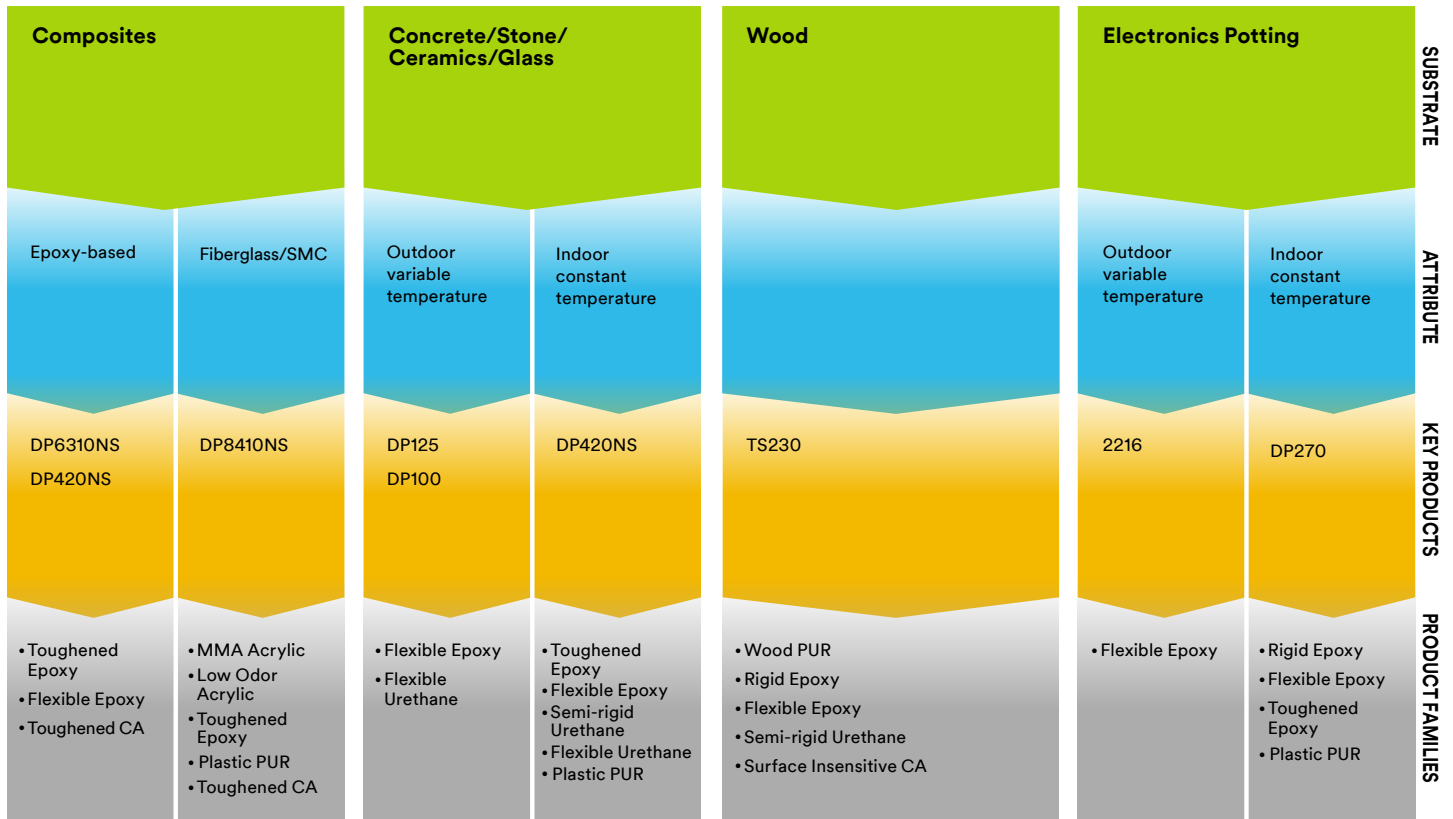
## Instant Adhesive Families

**Plastic & Rubber (PR) Instant Adhesives** bond to the widest variety of materials, have an extremely fast cure speed, and come in a wide range of viscosity.

**Surface Insensitive (SI) Instant Adhesives** cure even on acidic surfaces (such as wood, paper, leather, and ceramic); these adhesives have a slower cure speed than traditional instant adhesives.



**Step 1: Select Most Difficult Substrate**   **Step 2: Determine Key Attribute**   **Step 3: Select Product Family**



\*See chart in back of guide for more details.

■ SUBSTRATE   ■ ATTRIBUTE   ■ KEY PRODUCT   ■ PRODUCT FAMILIES

**Low Odor (LO) Instant Adhesives** provide a reduced blooming effect for applications that require an improved appearance.

**General Purpose (EC) Instant Adhesives** are slightly less expensive products that have lower strength and impact resistance compared to traditional instant adhesives.

**Super Fast (SF) Instant Adhesives** provide the fastest rate of cure speed for most applications.

**Rubber Toughened (RT) Instant Adhesives** can be used for applications that require improved impact strength or vibration resistance; preferred for applications bonding two rigid materials together.

**Metal (MC) Instant Adhesives** provide improved performance on metal substrates.

**Engineered Grade (EG) Instant Adhesives** provide excellent overall performance for most applications.

**Anaerobic Adhesive Families**

**Threadlockers (TL)** hold screws and other threaded fasteners in place to prevent loosening from shock, vibration, and thermal expansion and contraction; these adhesives replace lock washers and nylon-insert nuts.

**PUR Adhesive Families**

**Wood PUR** – Higher shear strength at lower elongations for long term holding power. Mostly used for rigid wood substrates and some plastics.

**Plastic PUR** – Higher impact strength, elongation and flexibility for greater capacity to withstand movement of bonded parts. Higher adhesion to most plastics, glass and aluminum.

# Substrate Selector

Step 1: Select Substrate Step 2: Determine Key Attribute Step 3: Select Product (see definitions below)

	Plastic/Paints/Coatings			Metals			Oily Metals		Composites		Concrete/Stone/Ceramics/Glass			
	Low Surface Energy	General Purpose	Rubber	Temperature and Solvent Resistant	Stainless Steel & Aluminum	Other Metals	Stainless Steel & Aluminum	Other Metals	Fiberglass/SMC	Epoxy	Indoor	Outdoor	Wood	
Plastic/Paints/Coatings	Low Surface Energy	LSE Acrylic* Plastic & Rubber CA	LSE Acrylic* Plastic & Rubber CA	Plastic & Rubber CA*	N/A	LSE Acrylic	LSE Acrylic	LSE Acrylic	LSE Acrylic	LSE Acrylic Toughened CA*	LSE Acrylic Toughened CA*	LSE Acrylic	LSE Acrylic	LSE Acrylic Surface Insensitive CA*
	General Purpose	LSE Acrylic* Plastic & Rubber CA	LO Acrylic MMA Acrylic Plastic PUR Epoxy Plastic & Rubber CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy	LO Acrylic MMA Acrylic Flexible Epoxy Plastic PUR Plastic & Rubber CA	DP8407NS Toughened Epoxy Flexible Epoxy Plastic PUR Plastic & Rubber CA	LO Acrylic MMA Acrylic	DP8407NS	Semi-rigid Urethane MMA Acrylic LO Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane MMA Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR Toughened CA	Flexible Epoxy Rigid Urethane Flexible Urethane Plastic PUR	Flexible Epoxy Flexible Urethane Plastic PUR	Wood PUR Flexible Epoxy Rigid Urethane Surface Insensitive CA
Rubber	Plastic & Rubber CA*	Plastic & Rubber CA* Plastic PUR	Plastic & Rubber CA*	N/A	Flexible Epoxy Plastic PUR	Flexible Epoxy Plastic PUR	N/A	N/A	Plastic & Rubber CA* Plastic PUR	Plastic & Rubber CA* Plastic PUR	Flexible Epoxy Plastic PUR	Flexible Epoxy Plastic PUR	Surface Insensitive CA* Plastic PUR Flexible Epoxy	
Metals	Temperature and Solvent Resistant	N/A	Toughened Epoxy Flexible Epoxy	N/A	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Flexible Epoxy	One-part Heat-cured Epoxy Toughened Epoxy	Heat-cured Epoxy	Heat-cured Epoxy	Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy	Flexible Epoxy	Toughened Epoxy Plastic PUR Flexible Epoxy
	Stainless Steel & Aluminum	LSE Acrylic	LO Acrylic MMA Acrylic Flexible Epoxy Plastic PUR Plastic & Rubber CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy	LO Acrylic MMA Acrylic Toughened Epoxy Flexible Epoxy Rigid Epoxy Toughened CA	Heat-cured Epoxy Toughened Epoxy	LO Acrylic MMA Acrylic	DP8407NS Heat-cured Epoxy	Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy MMA Acrylic LO Acrylic Plastic PUR Toughened CA	Toughened Epoxy Flexible Epoxy	Flexible Epoxy	Plastic PUR Toughened Epoxy Rigid Epoxy Flexible Epoxy Surface Insensitive CA
	Other Metals	LSE Acrylic	DP8407NS Toughened Epoxy Flexible Epoxy Plastic PUR Plastic & Rubber CA	Plastic & Rubber CA* Plastic PUR	Heat-cured Epoxy Toughened Epoxy	Heat-cured Epoxy Toughened Epoxy	Toughened Epoxy Flexible Epoxy Heat-cured Epoxy DP810	DP8407NS Heat-cured Epoxy	DP8407NS Heat-cured Epoxy	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy Heat-cured Epoxy Plastic PUR	Toughened Epoxy Heat-cured Epoxy	Flexible Epoxy	Plastic PUR Toughened Epoxy
Oily Metals	Stainless Steel & Aluminum	LSE Acrylic	LO Acrylic MMA Acrylic	N/A	Heat-cured Epoxy	LO Acrylic MMA Acrylic	DP8407NS Heat-cured Epoxy	LO Acrylic MMA Acrylic	DP8407NS	MMA Acrylic LO Acrylic	MMA Acrylic LO Acrylic Heat-cured Epoxy	N/A	N/A	N/A
	Other Metals	LSE Acrylic	DP8407NS	N/A	Heat-cured Epoxy	DP8407NS Heat-cured Epoxy	DP8407NS Heat-cured Epoxy	DP8407NS	DP8407NS Heat-cured Epoxy	DP8407NS	Heat-cured Epoxy	N/A	N/A	N/A
Composites	Fiberglass/SMC	LSE Acrylic Toughened CA*	Semi-rigid Urethane MMA Acrylic LO Acrylic Flexible Epoxy Plastic PUR Toughened CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane MMA Acrylic LO Acrylic Flexible Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	MMA Acrylic LO Acrylic	DP8407NS	Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Flexible Epoxy Urethane Plastic PUR	Semi-rigid Urethane Toughened Epoxy Rigid Urethane Flexible Epoxy Plastic PUR
	Epoxy	LSE Acrylic Toughened CA*	Semi-rigid Urethane MMA Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR Toughened CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy MMA Acrylic LO Acrylic Plastic PUR Toughened CA	Toughened Epoxy Flexible Epoxy Heat Cured Epoxy Plastic PUR	MMA Acrylic LO Acrylic Heat Cured Epoxy	Heat Cured Epoxy	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR
Concrete/Stone/Ceramics/Glass	Indoor	LSE Acrylic	Flexible Epoxy Rigid Urethane Flexible Urethane Plastic PUR	Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Heat Cured Epoxy	N/A	N/A	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy Rigid Urethane Flexible Urethane	Flexible Epoxy Flexible Urethane	Flexible Epoxy Plastic PUR Flexible Urethane
	Outdoor	LSE Acrylic	Flexible Epoxy Flexible Urethane Plastic PUR	Flexible Epoxy Plastic PUR	Flexible Epoxy	Flexible Epoxy	Flexible Epoxy	N/A	N/A	Semi-rigid Urethane Flexible Epoxy Flexible Urethane Plastic PUR	Semi-rigid Urethane Flexible Epoxy Plastic PUR	Flexible Epoxy Flexible Urethane	Flexible Epoxy Flexible Urethane	Flexible Epoxy Plastic PUR Flexible Urethane
Wood	LSE Acrylic Surface Insensitive CA*	Wood PUR Flexible Epoxy Rigid Urethane Surface Insensitive CA	Wood PUR Surface Insensitive CA*	Toughened Epoxy Plastic PUR Flexible Epoxy	Wood PUR Toughened Epoxy Rigid Epoxy Flexible Epoxy Surface Insensitive CA	Wood PUR Toughened Epoxy	N/A	N/A	Semi-rigid Urethane Toughened Epoxy Rigid Urethane Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Flexible Epoxy Plastic PUR Flexible Urethane	Flexible Epoxy Plastic PUR Flexible Urethane	Wood PUR Rigid Epoxy Toughened Epoxy Rigid Urethane Surface Insensitive CA	

Bold = Best In Class Product Light = Suggested Alternate Product \* = With Primer

# 3M™ Scotch-Weld™ Structural Adhesives

## Coverage Guide

### Approximate Coverages for 3M™ Scotch-Weld™ Adhesives in Duo-Pak Cartridges

Bead Size Dimension* inches/mm	Linear ft/m per 37 mL (2:1 Cart.)	Linear ft/m per 43 mL (2:3 Cart.)	Linear ft/m per 45 mL (10:1 Cart.)	Linear ft/m per 50 mL (1:1 & Cart.)	Linear ft/m per 200 mL (1:1 & 2:1 Cart.)	Linear ft/m per 400 mL (1:1 & 2:1 Cart.)	Linear ft/m per 490 mL (10:1 Cart.)	Linear ft/m per 295 mL (1/10 gal. Cart.)
1/2 in (12.7 mm)	2 ft (0.6 m)	2 ft (0.7 m)	2 ft (0.7m)	2.5 ft (0.8 m)	10 ft (3 m)	21 ft (6 m)	26 ft (8 m)	20 ft (6 m)
3/8 in (9.5 mm)	3.5 ft (1 m)	4 ft (1 m)	4 ft (1 m)	4.5 ft (1 m)	18 ft (6 m)	37 ft (11 m)	45 ft. (14 m)	35 ft (11 m)
1/4 in (6.4 mm)	8 ft (2 m)	9 ft (3 m)	9 ft (3 m)	11 ft (3 m)	41 ft (13 m)	83 ft (25 m)	102 ft (31 m)	79 ft (24 m)
1/8 in (3.2 mm)	31 ft (9 m)	36 ft (11 m)	37 ft (11 m)	42 ft (13 m)	165 ft (50 m)	331 ft (101 m)	405 ft (123 m)	312 ft (95 m)
1/16 in (1.6 mm)	122 ft (37 m)	142 ft (43 m)	147 ft (45 m)	165 ft (50 m)	656 ft (200 m)	1,313 ft (400 m)	1,600 ft (488 m)	1,234 ft (376 m)

### Coverages per Gallon for Various Thicknesses of 100% Solids 3M Adhesives

Wet Thickness inches/mm	Ft <sup>2</sup> /gal (m <sup>2</sup> /liter)	Gal/1,000 ft <sup>2</sup> (liter/1,000 m <sup>2</sup> )
1/2 in (12.7 mm)	3 ft <sup>2</sup> (0.1 m <sup>2</sup> )	312 gal (12,700 liter)
1/8 in (3.2 mm)	13 ft <sup>2</sup> (0.3 m <sup>2</sup> )	78 gal (3,175 liter)
1/16 in (1.6 mm)	26 ft <sup>2</sup> (0.6 m <sup>2</sup> )	39 gal (1,587 liter)
1/32 in (0.8 mm)	51 ft <sup>2</sup> (1 m <sup>2</sup> )	20 gal (794 liter)
25 mils (0.64 mm)	64 ft <sup>2</sup> (1.5 m <sup>2</sup> )	16 gal (635 liter)
5 mils (0.13 mm)	320 ft <sup>2</sup> (8 m <sup>2</sup> )	3 gal (127 liter)

### Coverages per Gallon for Various Bead Sizes of 100% Solids 3M Adhesives

Bead Size Dimension* inches/mm	Approx. lineal ft/gal (m/liter)	Approx. gal/1,000 lineal ft (liter/1,000 m)
1/2 in (12.7 mm)	196 ft (16 m)	5 gal (63 liter)
3/8 in (9.5 mm)	350 ft (28 m)	3 gal (36 liter)
1/4 in (6.4 mm)	785 ft (63 m)	1.3 gal (16 liter)
1/8 in (3.2 mm)	3,130 ft (252 m)	0.3 gal (4 liter)
1/16 in (1.6 mm)	12,420 ft (1,000 m)	0.1 gal (1 liter)

\* Bead size is semi-circular bead with width equal to size noted and height at center of bead equal to 1/2 the width.

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### Coverage for 3M™ Scotch-Weld™ PUR Adhesives

Approximate coverage per container (lineal foot per container based on 1/8" dia. bead size)

1/10 Gallon Cartridge	2 Kilo Bag	5 Gallon Pail	55 Gallon Drum
250' (76.2m)	1,650' (502.9m)	13,500' (4144.8m)	170,200' (51876.9m)

### 3M™ Scotch-Weld™ Low Odor and MMA Acrylic Adhesives

3M's Low Odor and MMA Acrylic Adhesives are designed for all of your sign application needs. They provide excellent impact strength, high peel strength and greatly extended shelf life compared to ordinary structural adhesives.

With high structural strength, fast cure and environmental resistance, they are the first choice for the sign industry.

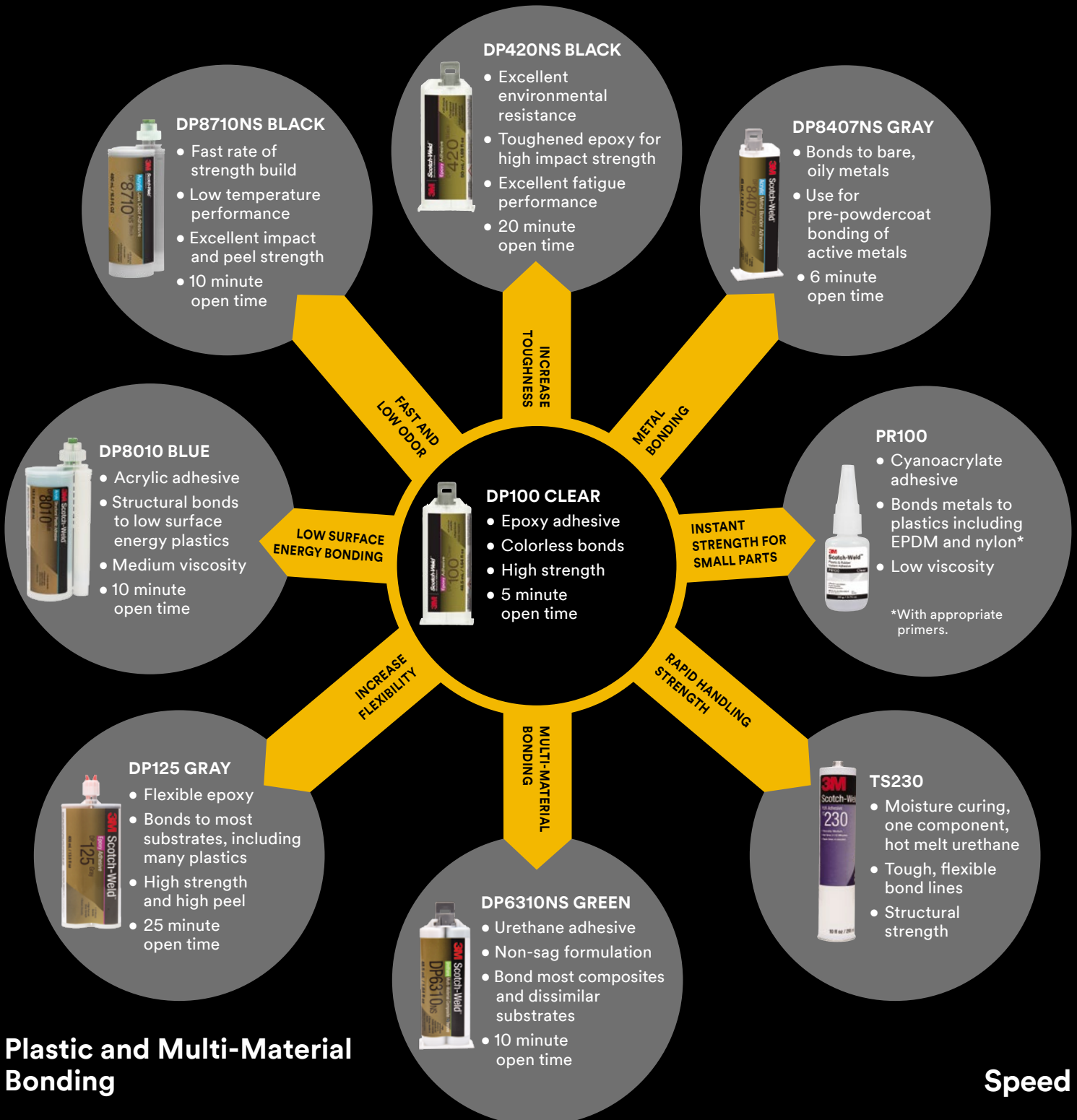
DP8705NS, DP8710NS, DP8725NS, DP8405NS, DP8407NS, DP8410NS, DP8425NS, DP8610NS and DP8625NS





# Go-to products for Structural Bonding

## High Strength and Metal Bonding



## 3M™ Scotch-Weld™ Rigid Epoxies

KEY PRODUCT	Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PU (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
								-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
								48.5mL	200mL	5 gal. pail A			
KEY PRODUCT	DP100 100 (Clear)	General purpose Rigid bonds	1:1	13,000	5 minutes	20 minutes	2 (4)	900 (6)	1,500 (10)	300 (2)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08994-1 00-021200-87260-0 00-021200-87261-7 00-021200-82345-9 00-021200-82344-2	7100148763 7100075490 7000121318 7100086557 7100086558
	DP100FR 100FR (Cream)	Flame retardant UL94 V-0 rating	1:1	80,000	6 minutes	20 minutes	2 (4)	1,250 (9)	2,200 (15)	800 (6)	48.5mL 200mL 5 gal. pail A 5 gal. pail B	00-638060-08989-7 00-048011-56744-0 00-048011-57230-7 00-048011-57229-1	7100148760 7000148268 7010366158 7010366123
	DP100NS 100NS (Translucent)	General purpose Non-sag	1:1	95,000	5 minutes	20 minutes	2 (4)	900 (6)	1,500 (10)	300 (2)	48.5mL 200mL 5 gal. pail A 5 gal. pail B	00-638060-08974-3 00-021200-87264-8 00-021200-82257-5 00-021200-82256-8	7100148744 7100014024 7010367412 7010295308
	DP270 270 (Black)	Rigid potting compound Non-corrosive	1:1	12,000	60 minutes	3 hours	2 (4)	1,200 (8)	2,500 (17)	300 (2)	48.5mL 200mL 400mL Gallon kit 5 gal. pail A 5 gal. pail B	00-638060-08975-0 00-021200-87836-7 00-021200-87837-4 00-021200-82263-6 00-021200-82265-0 00-021200-82264-3	7100148745 7000121252 7100082565 7000121253 7000046463 7000046439
	DP270 270 (Clear)	Rigid potting compound Non-corrosive	1:1	12,000	60 minutes	3 hours	2 (4)	1,200 (8)	2,500 (17)	300 (2)	48.5mL 200mL 5 gal. pail A 5 gal. pail B	00-638060-08973-6 00-021200-87834-3 00-021200-82251-3 00-021200-82250-6	7100148730 7100228179 7000028575 7000028567
	1751 B/A (Gray)	Excellent void filler Rigid bonds	3:2	700,000	45 minutes	10 hours	4 (7)	1,400 (10)	2,000 (14)	500 (3)	Gallon kit	00-021200-20105-9	7000046339
	1838 B/A (Green)	Multi-purpose Rigid bonds	4:5	400,000	60 minutes	8 hours	4 (7)	1,500 (10)	3,000 (21)	500 (3)	Quart kit	00-021200-20152-3	7000046340
	1838L B/A (Translucent)	Multi-purpose Rigid bonds	1:1	10,000	60 minutes	8 hours	4 (7)	2,000 (14)	2,500 (17)	300 (2)	Quart kit	00-021200-22646-5	7000036224
	2158 B/A (Gray)	Multi-purpose Rigid bonds	1:1	375,000	2 hours	10 hours	3 (5)	1,500 (10)	2,000 (14)	400 (3)	Gallon kit	00-021200-20262-9	7010330060

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**\* After Key Products, consider these.**

## 3M™ Scotch-Weld™ Flexible Epoxies

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Cure Time at 75°F (24°C)	Approximate Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PU (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
								-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
* DP100 Plus 100 Plus (Clear) 	Very flexible Colorless	1:1	8,500	4 minutes	20 minute	55 (98)	3,000 (21)	3,500 (24)	200 (1)	48.5mL	00-638060-08976-7	7100148750	
										200mL	00-021200-87266-2	7100069498	
										5 gal. pail A	00-021200-87198-6	7100046020	
										5 gal. pail B	00-021200-87197-9	7100084539	
										50 gal drum A	00-068060-00518-2	7100306667	
50 gal drum B	00-068060-00520-5	7100307357											
DP105 105 (Clear) 	Very flexible Colorless	1:1	6,500	5 minutes	20 minute	50 (89)	3,500 (24)	2,000 (14)	150 (1)	48.5mL	00-638060-08981-1	7100148733	
										200mL	00-021200-87270-9	7010309884	
										5 gal. pail A	00-021200-87206-8	7000000856	
										5 gal. pail B	00-021200-87205-1	7000000850	
DP110 110 (Gray)	General purpose Flexible bonds	1:1	55,000	8 minutes	20 minute	40 (71)	2,700 (19)	3,500 (24)	250 (2)	48.5mL	00-638060-08990-3	7100148777	
										200mL	00-021200-87274-7	7000121312	
										5 gal. pail A	00-021200-82472-2	7010299362	
										5 gal. pail B	00-021200-82471-5	7010299357	
DP110 110 (Translucent)	General purpose Flexible bonds	1:1	50,000	8 minutes	20 minute	40 (71)	2,500 (17)	2,500 (17)	200 (1)	48.5mL	00-638060-08993-4	7100148762	
										200mL	00-021200-87846-6	7000148270	
										400mL	00-021200-87847-3	7000148269	
										5 gal. pail A	00-021200-82467-8	7010366163	
										5 gal. pail B	00-021200-82466-1	7010366143	
KEY PRODUCT DP125 125 (Gray) 	High performance Very flexible bonds	1:1	52,500	25 minutes	2.5 hours	90 (160)	3,400 (23)	4,300 (30)	400 (3)	48.5mL	00-638060-08985-9	7100148735	
										200mL	00-021200-87844-2	7000121264	
										400mL	00-021200-87845-9	7100076727	
										5 gal. pail A	00-021200-87218-1	7100084588	
										5 gal. pail B	00-021200-87217-4	7100084538	
DP125 125 (Translucent)	High performance Very flexible bonds	1:1	15,000	25 minutes	2.5 hours	85 (151)	4,000 (28)	2,500 (17)	150 (1)	48.5mL	00-638060-08983-5	7100148734	
										400mL	00-021200-87843-5	7000121262	
DP190 (Translucent)	High performance Flexible bonds	1:1	10,000	80 minutes	6 hours	60 (107)	3,500 (24)	1,200 (8)	150 (1)	48.5mL	00-638060-08980-4	7100148752	
										5 gal. pail A	00-638060-40468-3	7100218836	
										5 gal. pail B	00-638060-40467-6	7100218835	
* DP190 (Gray) 	High performance Slightly flexible bonds	1:1	80,000	90 minutes	10 hours	50 (89)	1,500 (10)	2,500 (17)	400 (3)	48.5mL	00-638060-08992-7	7010410438	
										200mL	00-021200-87840-4	7000121314	
										400mL	00-021200-87841-1	7100076722	
* 2216 B/A (Gray)	High performance Very flexible bonds	2:3	80,000	90 minutes	10 hours	50 (89)	3,000 (21)	3,200 (22)	400 (3)	415mL Duo-Pak	00-068060-00115-3	7000262036	
										2 oz. tube kit	00-021200-20351-0	7000000812	
										Pint kit	00-021200-20354-1	7000046358	
										Quart kit	00-021200-20356-5	7000000815	
										Gallon kit	00-021200-20358-9	7000000816	
										5 gal. pail A	00-021200-20365-7	7000046361	
										5 gal. pail B	00-021200-20360-2	7000046360	
										50 gal drum A	00-021200-20366-4	7100166318	
50 gal drum B	00-021200-20361-9	7100166319											
2216 B/A (Translucent)	General purpose Very flexible bonds	1:1	10,000	2 hours	14 hours	70 (125)	3,000 (21)	1,700 (12)	140 (1)	2 oz. tube kit	00-021200-20851-5	7000046479	
										Quart kit	00-021200-20854-6	7000000861	
										Gallon kit	00-021200-20856-0	7000046480	
										5 gal. pail A	00-021200-64981-3	7000046494	
										5 gal. pail B	00-021200-64980-6	7000121307	
2216NS B/A (Tan)	High performance Non-sag	2:3	350,000	2 hours	10 hours	50 (89)	2,000 (14)	2,500 (17)	400 (3)	5 gal. pail A	00-021200-87180-1	7010367414	
										5 gal. pail B	00-021200-87179-5	7010309882	






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# 3M™ Scotch-Weld™ Toughened Epoxies

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PLI(N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
DP405 405 (Black) 	Tough durable bonds High impact resistance	2:1	70,000	4 minutes	15 minutes	40 (71)	4,500 (31)	4,500 (31)	600 (4)	50mL 5 gal. pail A 5 gal. pail B	00-638060-08971-2 00-051111-07708-5 00-051111-07707-8	7100148728 7010301041 7010329549
* DP420 420 (Black)	Tough durable bonds High impact resistance	2:1	30,000	20 minutes	2 hours	75 (133)	4,500 (31)	4,500 (31)	1,250 (9)	50mL	00-638060-08966-8	7100148731
										200mL	00-021200-41530-2	7100007956
										400mL	00-021200-41529-6	7100077148
										Gallon Kit	00-051115-25796-4	7000046381
										5 gal. pail A	00-021200-41532-6	7000000834
										5 gal. pail B	00-021200-41531-9	7000000827
										43 gal. drum A	00-021200-41534-0	7010365967
										43 gal. drum B	00-021200-41533-3	7010309750
* DP420 420 (Off-White) 	Tough durable bonds High impact resistance	2:1	30,000	20 minutes	2 hours	70 (125)	4,500 (31)	4,500 (31)	450 (3)	50mL 200mL 400mL	00-638060-08978-1 00-021200-87832-9 00-021200-87833-6	7100148736 7100077136 7100002516
										5 gal. pail A	00-021200-82239-1	7100001144
										5 gal. pail B	00-021200-82238-4	7100001145
* DP420NS 420NS (Black) 	Tough durable bonds Non-sag	2:1	180,000	20 minutes	2 hours	60 (107)	4,500 (31)	4,500 (31)	1,250 (9)	50mL 200mL 400mL	00-638060-08987-3 00-021200-39286-3 00-021200-39287-0	7100148758 7100036943 7100010680
										5 gal. pail A	00-021200-31309-7	7000000857
										5 gal. pail B	00-021200-56587-8	7000000853
										50 gal. drum A	00-048011-58133-0	7100160352
										50 gal. drum B	00-048011-58132-3	7100160334
* DP460 460 (Black)	Tough durable bonds	2:1	30,000	60 minutes	4 hours	80 (142)	4,500 (31)	4,500 (31)	700 (5)	5 gal. pail A 5 gal. pail B	00-021200-25319-5 00-021200-25318-8	7000121271 7000121265
* DP460 460 (Off-White) 	Tough durable bonds	2:1	30,000	60 minutes	4 hours	80 (142)	4,500 (31)	4,500 (31)	700 (5)	50mL 200mL 400mL	00-638060-08998-9 00-021200-87830-5 00-021200-87831-2	7100148768 7000121321 7100082563
										Quart kit	00-021200-82226-1	7000000874
										5 gal. pail A	00-021200-82228-5	7000000876
										5 gal. pail B	00-021200-82227-8	7000000875
										53 gal. drum A	00-021200-83757-9	7010366165
										53 gal. drum B	0-00-76308-14623-8	7100153215
* DP460NS 460NS (Off-White)	Tough durable bonds Non-sag	2:1	125,000	60 minutes	4 hours	70 (125)	3,600 (25)	4,900 (34)	4,650 (32)	50mL 200mL 400mL	00-638060-08968-2 00-021200-43671-0 00-021200-43672-7	7100148751 7100069441 7100076677
										5 gal. pail A	00-021200-43674-1	7010329565
										5 gal. pail B	00-021200-43673-4	7010301036
DP490 490 (Black) 	Tough durable bonds	2:1	90,000	90 minutes	4 hours	34 (60)	3,600 (25)	4,500 (31)	2,000 (14)	400mL	04-054596-67913-9	7100200501
7240FR (Black)	Tough durable bonds	2:1	120,000	45 minutes	6 hours	15 (92)	3,400 (18)	4,500 (27)	900 (12)	400mL 14 gal. Kit	04-064035-15229-1 54-046719-95284-2	7100331273 7100042123
LSB60 (Gray)	Tough durable bonds High impact resistance	1:1	30,000	90 minutes	5 hours	15 (27)	3,400 (23)	4,500 (31)	900 (6)	400mL 50 gal. drum A 50 gal. drum B	00-051115-63411-6 00-051115-63418-5 00-051115-63417-8	7000046487 7010366162 7010310202
LSB60NS (Gray)	Tough durable bonds Non-sag High impact resistance	1:1	60,500	90 minutes	5 hours	10 (18)	3,800 (26)	4,500 (31)	800 (6)	5 gal. pail A 5 gal. pail B 50 gal. drum A 50 gal. drum B	00-051115-63428-4 00-051115-63427-7 06-38060-40269-6 06-38060-40270-2	7100079533 7100079534 7100198360 7100198390
LSB360NS (Green)	Tough durable bonds Non-sag Extra long work life Bonds oily metals	1:1	60,500	10 hours	16 hours	30 (53)	4,000 (28)	4,000 (28)	800 (6)	55 gal. drum A 55 gal. drum B	00-051115-64360-6 00-051115-64391-0	7010330243 7010299359

## 3M™ Scotch-Weld™ Heat-Cured Epoxies

Product (Color)	Key Features	Approximate Viscosity at 75°F/24°C (cP)			Cure Conditions			Overlap Shear: psi (MPa)					Size	UPC	Stock #
		Time (min)	Temp. F (°C)	Floating Roller Peel PLI(N/cm) at 75°F (24°C)	-67°F (-55°C)	75°F (24°C)	180°F (82°C)	250°F (121°C)							
6101 (Off White)	Excellent impact resistance, low temp cure	30,000	20	149 (65)	N/A	N/A	N/A	N/A	N/A	N/A	30mL cart.	00-638060-40406-5	7100208553		
1386 (Cream)	High temperature strength Impact resistance	150,000	60	350 (177)	10 (18)	3,000 (21)	5,500 (38)	4,500 (31)	2,500 (17)	1 quart	00-021200-19917-2	7000046326			
1469 (Cream)	High temperature strength Low viscosity	60,000	120	350 (177)	2 (4)	3,150 (22)	3,700 (26)	3,700 (26)	3,600 (25)	1 quart 5 gal. pail	00-021200-19949-3 00-021200-19950-9	7000046328 7100056050			
2214 Hi-Temp New Formula (Gray)	High temperature strength Environmental resistance	Paste	60	250 (121)	2 (4)	2,000 (14)	2,500 (17)	2,000 (14)	2,000 (14)	6 oz. cart. 5 gal. pail	00-021200-20833-1 00-021200-20835-5	7000046474 7101330200			
2214 Non-Metallic Filled (Cream)	High temperature strength Higher insulation value	Paste	40	250 (121)	7 (12)	3,000 (21)	2,200 (15)	2,000 (14)	400 (3)	6 oz. cart.	00-021200-25496-3	7000121273			
* 2214 Regular (Gray)	High temperature strength Low temp curing	Paste	40	250 (121)	5 (9)	3,000 (21)	2,500 (17)	2,000 (14)	800 (6)	6 oz. cart. 1 quart 5 gal. pail	00-021200-20344-2 00-021200-20345-9 00-021200-23047-3	7000000811 7000046356 7100111206			
2290 (Amber)	Low solids liquid coating for metal laminations	60	30-60	350 (177)	5 (9)	5,000 (34)	5,000 (34)	3,500 (24)	1,200 (8)	Gallon cont. 5 gal. pail 54 gal. drum	00-021200-76225-3 00-021200-76227-7 00-021200-76228-4	7000000897 7100144895 7100144896			

## 3M™ Scotch-Weld™ Primer

Product	Key Features	Viscosity	Color	Dry time (24°C/33°C)	Dry time (88°C)	Size	UPC	Stock #
Metal Primer 3901	Improves metal and glass adhesion and increases environmental resistance	5	Red	1 hour	30 minutes	.5 pint	62390135259	7000000907

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### 3M™ Scotch-Weld™ Epoxy Adhesive DP420NS

3M Scotch-Weld Epoxy Adhesive DP420NS is a black, toughened, non-sag, two-part epoxy structural adhesive that provides good strength along with high impact and fatigue resistance. It can replace mechanical fasteners, screws, rivets and spot welds in many applications



### 3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear

3M Scotch-Weld Epoxy Adhesive DP100 Clear is a very flexible, fast-setting, two-part epoxy adhesive that cures clear and colorless. It provides a strong, permanent bond, even under vibration and impact and is flexible when cured, making it a good choice for bonding dissimilar surfaces.





## 3M™ Scotch-Weld™ Standard MMA Acrylics

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PLI (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-20°F (-29°C)	75°F (24°C)	180°F (82°C)			
DP805 (Off-White)	Fast strength build Minimal surface prep	1:1	110,000	3 minutes	10 minutes	35 (62)	2,500 (17)	3,500 (24)	2,200 (15)	48.5mL	00-638060-08982-8	7101401436
										200mL	00-021200-87828-2	7101367390
DP820 (Light Yellow)	Tough durable bonds Minimal surface prep	1:1	55,000	15 minutes	40 minutes	20 (36)	3,100 (21)	3,150 (22)	1,900 (13)	48.5mL 200mL	00-638060-08977-4 00-021200-89348-3	7101421294 7101329704
DP8405NS 8405NS (Green)	High impact Adhesion to most plastics	10:1	70,000	5 minutes	15 minutes	50 (89)	2,600 (18)	4,100 (28)	900 (6)	45mL	00-051115-68963-5	7100009688
										490mL	00-051115-68964-2	7100011056
										1 gal. pail A	00-051115-68981-9	7100102180
										5 gal. pail B	00-051115-68986-4	7100027430
										5 gal. pail A 50 gal. drum B	00-051115-68980-2 00-051115-68987-1	7100101506 7100084534
KEY PRODUCT DP8407NS 8407NS (Gray)	High impact Adhesion to most plastics	10:1	20,000	7 minutes	24 minutes	50 (89)	3,400 (23)	4,500 (31)	1,400 (10)	45mL	00-638060-14631-6	7100179482
										490mL	00-638060-14643-9	7100179480
										1 gal. pail A	00-638060-14658-3	7100179264
										5 gal. pail B	00-076308-86306-7	7100105384
										5 gal. pail A	00-638061-14659-0	7100179442
KEY PRODUCT DP8410NS 8410NS (Green)	High impact Adhesion to most plastics	10:1	70,000	10 minutes	25 minutes	50 (89)	3,600 (25)	4,100 (28)	800 (6)	45mL	00-051115-70994-4	7100024055
										490mL	00-051115-70995-1	7100024045
										1 gal. pail A	00-051115-68981-9	7100102180
										5 gal. pail B	00-051115-70997-5	7100064830
										5 gal. pail A 50 gal. drum B	00-051115-68980-2 00-051115-71101-5	7100101506 7100084532
KEY PRODUCT DP8425NS 8425NS (Green)	High impact Adhesion to most plastics	10:1	70,000	25 minutes	50 minutes	50 (89)	3,800 (26)	3,700 (26)	800 (6)	45mL	00-051115-81303-0	7100078165
										490mL	00-051115-81302-3	7100078166
										1 gal. pail A	00-051115-68981-9	7100102180
										5 gal. pail B	00-68060-00072-9	7100255721
										5 gal. pail A 50 gal. drum B	00-051115-81414-3 00-051115-81031-6	7100101506 7100084535

## 3M™ Scotch-Weld™ Low Odor Acrylics

KEY PRODUCT DP8705NS 8705NS (Black)	Low odor Fast rate of strength build	10:1	80,000	5 minutes	6 minutes	34 (60)	4,350 (30) at -40°C	2,320 (16)	580 (4)	45mL	00-638060-40963-3	7100245036
										490mL	00-638060-40964-0	7100245039
										1 gal. pail A	00-638060-40862-9	7100233358
										5 gal. pail A	00-638060-40863-6	7100234571
										5 gal. drum B 50 gal. drum B	00-638060-40965-7 00-638060-40966-4	7100245037 7100245038
KEY PRODUCT DP8710NS 8710NS (Black)	Low odor Fast rate of strength build	10:1	80,000	10 minutes	13 minutes	34 (60)	4,350 (30) at -40°C	2,320 (16)	580 (4)	45mL	00-638060-40865-0	7100233349
										490mL	00-638060-40866-7	7100233348
										1 gal. pail A	00-638060-40862-9	7100233358
										5 gal. pail A	00-638060-40863-6	7100234571
										5 gal. drum B 50 gal. drum B	00-638060-40867-4 00-638060-40868-1	7100234572 7100233166
KEY PRODUCT DP8725NS 8725NS (Black)	Low odor Fast rate of strength build	10:1	80,000	23 minutes	25 minutes	34 (60)	4,350 (30) at -40°C	2,320 (16)	580 (4)	45mL	00-638060-40967-1	7100244858
										490mL	00-638060-40968-8	7100244480
										1 gal. pail A	00-638060-40862-9	7100233358
										5 gal. pail A	00-638060-40863-6	7100234571
										5 gal. drum B 50 gal. drum B	00-638060-40969-5 00-638060-40971-8	7100244861 7100244862
KEY PRODUCT DP810 810 (Black)	Tough durable bond High impact resistance	1:1	20,000	10 minutes	20 minutes	30 (53)	1,200 (8)	3,600 (25)	500 (3)	48.5mL	00-638060-08967-5	7100148732
										200mL	00-021200-49079-8	7100142848
										1 gallon pail A	00-048011-56712-9	7000046401
										1 gallon pail B	00-048011-56711-2	7000046385
										4.4 gal. pail A 4.4 gal. pail B	00-021200-49081-1 00-021200-49080-4	7010365969 7010329544
KEY PRODUCT DP810 810 (Tan)	Tough durable bonds High impact resistance	1:1	20,000	10 minutes	20 minutes	30 (53)	1,200 (8)	3,600 (25)	500 (3)	48.5mL	00-638060-08986-6	7100148757
										200mL	00-021200-31311-0	7000121267
										400mL	00-021200-31312-7	7000121266
										4.4 gal. pail A	00-021200-45233-8	7100077450
										4.4 gal. pail B	00-021200-45230-7	7100077451
KEY PRODUCT DP810NS 810NS (Tan)	Tough durable bonds Non-sag	1:1	95,000	10 minutes	20 minutes	20 (36)	1,200 (8)	4,000 (28)	500 (3)	48.5mL	00-638060-08969-9	7100148748
										200mL	00-021200-49084-2	7100069365
										400mL	00-021200-49083-5	7100069366
										4.4 gal. pail A	00-638060-14110-6	7100160337
										4.4 gal. pail B	00-021200-49085-9	7000121240

### 3M™ Scotch-Weld™ Low Odor Acrylics (continued)

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C) (cp)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel P/LI (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-20°F (-29°C)	75°F (24°C)	180°F (82°C)			
DP8805NS 8805NS (Green)	Low odor Fast rate of strength build	10:1	80,000	5 minutes	7 minutes	30 (53)	800 (5)	3,600 (25)	900 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 50 gal. drum B	00-076308-98433-5 00-076308-98439-7 00-051115-81415-0 00-076308-98440-3 00-051115-81414-3 00-076308-98441-0	7100098631 7100097636 7100102180 7100097693 7100101506 7100097673
DP8810NS 8810NS (Green)	Low odor Fast rate of strength build	10:1	80,000	10 minutes	18 minutes	30 (53)	900 (6)	3,600 (25)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 50 gal. drum B	00-051128-99432-0 00-051128-99431-3 00-051115-81415-0 00-076308-98442-7 00-051115-81414-3 00-076308-98443-4	7100097574 7100075409 7100102180 7100097704 7100101506 7100097626
DP8810NS (Gray)	Low odor Fast rate of strength build	10:1	80,000	10 minutes	18 minutes	30 (53)	900 (6)	3,600 (25)	800 (6)	45mL 490mL	00-076308-86152-0 00-076308-98485-4	7100097474 7010329557
DP8825NS 8825NS (Green)	Low odor Fast rate of strength build	10:1	80,000	25 minutes	44 minutes	20 (36)	1,000 (7)	3,000 (21)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 50 gal. drum B	00-051115-81288-0 00-051115-81289-7 00-051115-81415-0 00-051115-81290-3 00-051115-81414-3 00-051115-81291-0	7100067297 7100068120 7100102180 7100067291 7100101506 7100084533

### 3M™ Scotch-Weld™ Low Surface Energy and Nylon Bonder Acrylics

KEY PRODUCT

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C) (cp)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel P/LI (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-20°F (-29°C)	75°F (24°C)	180°F (82°C)			
DP8005 (Black)	Bonds polyolefins and low surface energy materials	10:1	25,000	3 minutes	3 hours	N/A	875 (6)	2,000 (14)	475 (3)	45mL 490mL	00-051128-99352-1 00-051128-99298-2	7100089475 7100089476
DP8005 (Off-White)	Bonds polyolefins and low surface energy materials	10:1	25,000	3 minutes	3 hours	N/A	750 (5)	2,200 (15)	500 (3)	45mL 490mL	00-051128-99349-1 00-051128-99297-5	7100088846 7100090196
DP8010 8010 (Blue)	Bonds polyolefins and low surface energy materials	10:1	20,000	10 minutes	1 hour	N/A	2,700 (19)	2,700 (19)	500 (3)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A	00-051115-71600-3 00-051115-71601-0 00-021200-49113-9 00-051115-71669-0 00-021200-49115-3	7100036717 7100036719 7100050479 7100036720 7000046400
DP8910NS 8910NS (Black)	Bonds nylon and metal	10:1	45,000	10 minutes	16 minutes	10 (18)	2,175 (15)	3,190 (22)	1,595 (11)	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-068060-00546-5 00-068060-00547-2 00-638060-40862-9 00-638060-40863-6 00-068060-00548-9 00-068060-00549-6	7100314796 7100314358 7100233358 7100234571 7100314557 7100314788

### 3M™ Scotch-Weld™ Flexible Acrylics

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C) (cp)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel P/LI (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-40°F (-40°C)	75°F (24°C)	180°F (82°C)			
DP8610NS 8610NS (Black)	Very flexible and no read through on thin metals	10:1	130,000	10 minutes	18 minutes	57 (100)	3,480 (24)	1,015 (7)	290 (2)	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40836-0 00-638060-40862-9 00-638060-40862-9 00-638060-40863-6 00-638060-40838-4 00-638060-40839-1	7100233359 7100232802 7100233358 7100234571 7100234673 7100234570
DP8625NS 8625NS (Black)	Very flexible and no read through on thin metals	10:1	130,000	23 minutes	28 minutes	57 (100)	3,480 (24)	1,015 (7)	290 (2)	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40972-5 00-638060-40973-2 00-638060-40862-9 00-638060-40863-6 00-638060-40974-9 00-638060-40975-6	7100244478 7100244477 7100233358 7100234571 7100244476 7100244859
DP8625NS 8625NS (Grey)	Very flexible and no read through on thin metals	10:1	130,000	23 minutes	28 minutes	57 (100)	3,480 (24)	1,015 (7)	290 (2)	490mL 5 gal. pail A 50 gal. drum B	00-068060-00399-7 00-638060-40863-6 00-068060-75678-7	7100292352 7100234571 7100320287

## 3M™ Scotch-Weld™ Semi-Rigid Urethanes

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PLI (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-40°F (-40°C)	75°F (24°C)	180°F (82°C)			
							4000 (28)	2,000 (14)	600 (4)			
DP600 600 (Gray)	Concrete repair Self-leveling	1:1	6,000	1 minute	4 minutes	20 (36)	3,200 (22)	2,300 (16)	700 (5)	48.5mL 8.4 fl. oz. 5 gal. pail A 5 gal. pail B	00-638060-08962-0 00-021200-96596-8 00-021200-96575-3 00-021200-96574-6	7100148740 7000046375 7010130543 7010170293
DP600NS 600NS (Gray)	Concrete repair Non-sag	1:1	Paste	1 minute	4 minutes	8 (14)	2,700 (19)	2,300 (16)	700 (5)	48.5mL 5 gal. pail A 5 gal. pail B	00-638060-08964-4 00-068060-00005-7 00-068060-00004-0	7100148747 7100249024 7100249169
DP605NS 605NS (Off-White)	Semi-rigid Non-sag	1:1	150,000	5 minutes	20 minutes	40 (71)	4,000 (28)	2,000 (14)	600 (4)	48.5mL	00-638060-08997-2	7100148767
DP6301NS (Green)	Delivers strength and performance	1:1	Non-sag paste	1 minute	3 minutes	36 (64)	2,018 (14)	1,653 (11)	224 (1)	400mL 50 gal. drum A 50 gal. drum B	00-068060-00068-2 00-068060-00070-5 00-068060-00069-9	7100255381 7100255361 7100255362
KEY PRODUCT DP6310NS (Green)	Multi-purpose Energy absorbing	1:1	Non-sag paste	10 minutes	45 minutes	20 (36)	3,500 (24)	3,600 (25)	900 (6)	48.5mL	00-076308-86407-1	7100109829
										400mL	00-076308-86398-2	7100109830
										5 gal. pail A	00-076308-86782-9	7100143960
										5 gal. pail B	00-076308-86748-5	7100143915
										50 gal. drum A	00-076308-86783-6	7010415316
										50 gal. drum B	00-076308-86749-2	7010412199
DP6330NS (Green)	Multi-purpose Energy absorbing	1:1	Non-sag paste	30 minutes	2 hours	20 (36)	3,600 (25)	3,600 (25)	1,000 (7)	48.5mL 400mL 5 gal. pail A 5 gal. pail B 50 gal. drum A 50 gal. drum B	00-076308-86431-6 00-076308-86433-0 00-076308-86780-5 00-076308-86701-0 00-076308-86781-2 00-076308-86727-0	7100109828 7100109827 7100143961 7100143701 7010409611 7010366145

## 3M™ Scotch-Weld™ Flexible Urethanes

*	DP604NS 604NS (Black)	Flexible Non-sag	1:1	Paste	4 minutes	20 minutes	30 (53)	1,400 (10)	600 (4)	300 (2)	48.5mL 400mL 5 gal. pail A 5 gal. pail B 50 gal. drum A 50 gal. drum B	00-638060-08961-3 00-051111-98301-0 00-021200-96462-6 00-021200-96461-9 00-076308-14205-6 00-076308-87087-4	7100148738 7100069452 7010365926 7010367265 7010329538 7010412243
	*	DP620NS 620NS (Black)	Semi-flexible Non-sag	1:1	Paste	20 minutes	4 hours	40 (71)	3,000 (21)	2,500 (17)	500 (3)	48.5mL 400mL 5 gal. pail A 5 gal. pail B 50 gal. drum A 50 gal. drum B	00-638060-08960-6 00-048011-57287-1 00-076308-14144-8 00-076308-14135-6 00-076308-14135-5 00-076308-14146-3
	DP640 (Brown)	Tough flexible bonds	1:1	25,000	60 minutes	8 hours	60 (107)	3,000 (21)	2,000 (14)	400 (3)	48.5mL	00-638060-08991-0	7100148761
	3549 (Brown)	Tough flexible bonds	1:1	25,000	60 minutes	8 hours	60 (107)	3,000 (21)	2,000 (14)	400 (3)	Quart kit	00-021200-20802-4	7000046485
	DP5001 5001 (Black)	Flexible Conveyor belt repair	1:1	100,000	1 minute	15 minutes	N/A	N/A	600 (4)	N/A	400mL	00-051111-98296-9	7100028818

### 3M™ Scotch-Weld™ Low Surface Energy (LSE) Plastic Bonding Adhesives

3M's low surface energy structural acrylic adhesives bond to low surface energy plastics such as Polypropylene (PP), Polyethylene (HDPE) and most Thermoplastic Polyolefins (TPOs), providing structural adhesive bond strength that causes the plastic material to fail before the adhesive bond.



### 3M™ Scotch-Weld™ Epoxy Adhesive DP125

3M Scotch-Weld Epoxy Adhesive DP125 is a low odor, two-part epoxy that creates strong structural and flexible bonds on metal, ceramics, wood and many plastics. It provides the reliability and strength you need to maintain productive, cost effective results.



## 3M™ Scotch-Weld™ PUR Adhesives – Wood Bonders

Product (Color)	Key Features	Viscosity @ 250°F (121°C) (cP)	Approximate Open Time at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Shore D	Elongation %	Size	UPC	Stock #
EZ250015 (Off-White)	Fast set time UV tracer	7,000	1.5 minutes	15 seconds	65	750	1/10 gal. 5 gal.	00-051115-23545-0 00-051115-23546-7	7000046529 7010310232
EZ250060 (Off-White)	Medium set time UV tracer	7,000	2 minutes	60 seconds	60	675	1/10 gal. 5 gal.	00-051115-23550-4 00-051115-23551-1	7000046531 7010329734
EZ250120 (Off-White)	Medium set time Low viscosity UV tracer	3,000	4 minutes	120 seconds	60	625	1/10 gal.	00-051115-23554-2	7000046532
TE030 (Off-White)	Fast set time High viscosity No UV tracer	16,000	1 minute	30 seconds	60	725	1/10 gal. 5 gal.	00-051115-25157-3 00-021200-82484-5	7000046536 7010310236
TE100 (Off-White)	Medium set time UV tracer	7,000	2 minutes	60 seconds	61	675	1/10 gal. 5 gal.	00-051115-25161-0 00-021200-87244-0	7000028590 7010295326
TE200 (Off-White)	Medium set time Low viscosity UV tracer	3,000	4 minutes	120 seconds	60	625	1/10 gal. 2 kilo	00-051115-25164-1 00-048011-53272-1	7000000905 7000046540

**3M™ Scotch-Weld™  
PUR Easy 250  
Applicator**

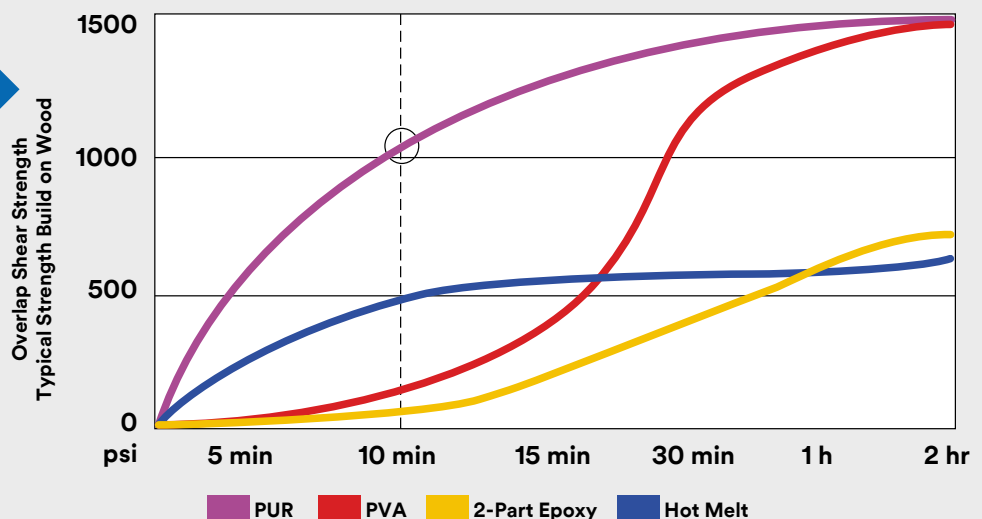


**3M™ Scotch-Weld™  
PUR Easy 250  
Preheater**





### 3M™ Scotch-Weld™ PUR Adhesives

PUR Adhesives enhance productivity with fast green strength. Shorter clamp times and reduced need for third-hand mechanical fasteners help speed up your production process without sacrificing ultimate strength.



## 3M™ Scotch-Weld™ PUR Adhesives – Plastic Bonders

Product (Color)	Key Features	Viscosity @ 230°F (121°C) (cp)	Approximate Open Time at 75°F/24°C	Approximate Time to Handling Strength at 75°F/24°C	Shore D	Elongation %	Size	UPC	Stock #
EZ250030 (Off-White)	Fast set time, bonds a wide variety of plastics, no UV tracer	13,000	2 minutes	30 seconds	50	725	1/10 gal. 5 gal.	00-051115-23541-2 00-051115-23542-9	7000046530 7000121357
EZ250150 (Off-White)	Long open time, bonds plastics to metal, glass, wood, no UV tracer	9,000	4 minutes	150 seconds	45	700	1/10 gal. 2 kilo 5 gal.	00-051115-23559-7 00-051115-23562-7 00-051115-23560-3	7000046533 7010295325 7010367590
EZ250200 (Off-White)	Long open time, low viscosity, bonds plastics, wood, and many other material combinations, no UV tracer	2,750	3 minutes	120 seconds	30	400	1/10 gal. 2 kilo	00-048011-57402-8 00-048011-57401-1	7000046538 7010367604
TE031 (Black)	Fast set time, bonds a wide variety of plastics, no UV tracer	13,000	2 minutes	30 seconds	50	725	1/10 gal. 5 gal.	00-051115-25159-7 00-021200-89573-9	7000000903 7100031123
* TE031 (Off-White)	Fast set time, bonds a wide variety of plastics, no UV tracer	13,000	2 minutes	30 seconds	50	725	1/10 gal. 2 kilo	00-051115-25158-0 00-048011-53355-1	7000000902 7000028589
TE040 (Black)	Fast set time, strong flexible bonds to plastic, wood, aluminum, glass, no UV tracer	7,000	2 minutes	40 seconds	35	860	1/10 gal. 5 gal. 55 gal. drum	00-051115-64536-5 00-638060-14494-7 00-638060-14321-6	7100003450 7100172685 7100160468
TE040 (Off-White)	Fast set time, strong flexible bonds to plastic, wood, aluminum, glass, no UV tracer	7,000	2 minutes	41 seconds	35	860	1/10 gal. 5 gal. 55 gal. drum	00-051115-25160-3 00-021200-25343-0 00-638060-14498-5	7000021292 7000136628 7100170133
TS230 (Black) 	Extrudable/sprayable, long open time, bonds plastics to metal, glass, and wood, no UV tracer	9,000	4 minutes	150 seconds	45	700	1/10 gal. 2 kilo 5 gal. 55 gal. drum	00-051115-25166-5 00-048011-53273-8 00-021200-89583-8 00-638060-14675-0	7000000906 7000046541 7000121361 7100179521
KEY PROD TS230 (Off-White) 	Extrudable/sprayable long open time, bonds plastics to metal, glass, and wood, no UV tracer	9,000	4 minutes	150 seconds	45	700	1/10 gal. 2 kilo 5 gal. 55 gal. drum	00-051115-25165-8 00-048011-53271-4 00-021200-83640-4 00-021200-83639-8	7000000898 7000046534 7100024959 7100104259
TS230 (Gray)	Extrudable/sprayable long open time, bonds plastics to metal, glass, and wood, no UV tracer	9,000	4 minutes	150 seconds	45	700	55 gal. drum	00-638060-40191-0	7100191940
Purge Material 3756	Purge PUR adhesives from bulk dispensing equipment	8250	N/A	N/A	N/A	N/A	5 gal.	00-021200-56522-9	7000121333

## 3M™ Scotch-Weld™ PUR Applicator/Preheater/Hardware

Product	Description	UPC	Stock #
Applicator	PUR Easy 250 Applicator, pneumatically dispenses 1/10 gal. cartridges, US 120V	00-051115-23563-4	7000000958
Preheater	PUR Easy 250 Preheater, preheats up to four 1/10 gal. cartridges, 120V, Dual Temp	00-051115-23564-1	7000121608
System Accessories for hands-free dispensing	Applicator Bench Mount Bracket Assembly (bracket only) Hot Melt Applicator Foot Pedal Assembly 9277	00-021200-30086-8 00-021200-82278-0	7000121614 7000121596
Cartridge Nozzle	High Temperature Nozzles for PUR 1/10 gal. cartridges (Sample, 5/bag)	50-638060-40564-7	7100218849
Repair Kits and Replacement Parts	Adhesive Applicator Housing/Shroud Assembly Kit Applicator Nozzle Shroud Benchmount Quick Exhaust Assembly Replacement Kit Applicator Air Coupler Filter Kit Applicator Air Supply Line Kit Applicator Air Valve Kit Applicator Swivel Connector Applicator End Cap Applicator Heat Tube Assembly (120V) Kit Applicator Heat Tube (240V) Applicator On/Off Switch Kit Applicator Power Cord Kit (120V) Applicator Wire Stand High Temperature (250 Degrees F) PUR Preheater Thermostat/TCO Kit Low Temperature (170 Degrees F) PUR Preheater Thermostat/TCO Kit	00-051115-25783-4 00-048011-58320-4 00-021200-31357-8 00-021200-89475-6 00-021200-89479-4 00-048011-57410-3 00-048011-58298-6 00-021200-89476-3 00-021200-89486-2 00-021200-25303-4 00-021200-89482-4 00-021200-89481-7 00-021200-89483-1 00-051115-23619-8 00-051115-23618-1	7000028623 7000148288 7010366711 7000046655 7000046668 7000046652 7000046653 7000046666 7010329969 7000046673 7100079509 7010366708 7010329970 7010329954 7010366886

For lead times on bulk adhesives, please contact your 3M representative.

**Note:** The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

**KEY PRODUCT** Denotes product to consider first in this category

**\*** After Key Products, consider these.

### 3M™ Scotch-Weld™ PUR Applicator/Preheater/Hardware (cont.)

Product	Description	UPC	Stock #
Alternate Nozzle System (not for use with disposable nozzles)	Applicator Main Nozzle Assembly (includes nozzle, tip, tip cap and valve) Applicator Main Nozzle Applicator Extension Tip, .072 in orifice Applicator Tip, .125 in orifice Applicator Tip, .063 in orifice Applicator Tip Cap Applicator Valve Assembly	00-021200-89514-2 00-021200-89515-9 00-021200-89471-8 00-021200-89473-2 00-021200-89472-5 00-021200-87194-8 00-021200-83730-2	7000027561 7000046672 7000046669 7000046671 7000046670 7100005819 7000046650

### 3M™ Scotch-Weld™ Instant Adhesives – Plastic and Rubber

Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
PR Gel (Clear)	Fast cure, gel viscosity for max gap filling	Gel	-65° to 180°F (-54° to 82°C)	< 25 sec.	24	20 gram tube 300 gram cart	00-051115-25265-5 00-051115-25282-2	7100039255 7100039257
PR40 (Clear)	Low viscosity for close fitting plastic/rubber parts	40	-65° to 180°F (-54° to 82°C)	< 20 sec.	24	20 gram bottle	00-051115-25204-4	7010330469
PR100 (Clear)	General purpose, low viscosity plastic bonder	100	-65° to 180°F (-54° to 82°C)	< 35 sec.	24	20 gram bottle 500 gram bottle	00-051115-25214-3 00-051115-25213-6	7100039259 7100039200
PR600 (Clear)	Medium viscosity with some gap filling for plastic/rubbers	600	-65° to 180°F (-54° to 82°C)	< 45 sec.	24	50 gram bottle 500 gram bottle	00-051115-25241-9 00-051115-25240-2	7100039244 7100039246
PR1500 (Clear)	General purpose, high viscosity for gap filling	1,500	-65° to 180°F (-54° to 82°C)	< 45 sec.	24	20 gram bottle 500 gram bottle	00-051115-25222-8 00-051115-25221-1	7100039201 7100039203

KEY PROD

### 3M™ Scotch-Weld™ Instant Adhesives – Surface Insensitive

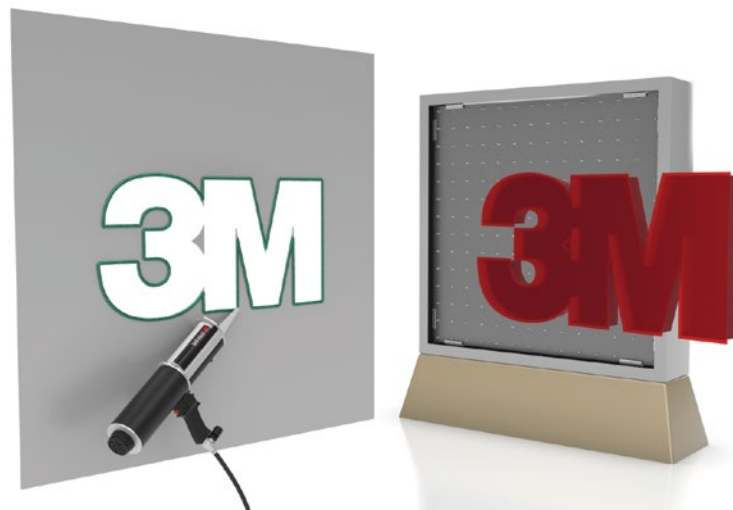
SI Gel (Clear)	Fast cure, gel viscosity for maximum gap filling	Gel	-65° to 180°F (-54° to 82°C)	< 30 sec.	24	20 gram bottle 300 gram cart.	00-051115-25266-2 00-051115-25284-6	7100039258 7101330472
SI1500 (Clear)	High viscosity for gap filling	1,500	-65° to 180°F (-54° to 82°C)	< 30 sec.	24	50 gram bottle 500 gram bottle	00-048011-61662-9 00-051115-25245-7	7010330477 7100039243

### 3M™ Scotch-Weld™ Instant Adhesives – Low Odor

LO1000 (Clear)	General purpose, high viscosity with reduced odor and blooming, suitable for minor gap filling	1,000	-65° to 180°F (-54° to 82°C)	< 30 sec.	24	20 gram bottle	00-051111-91664-3	7100039269
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#### 3M™ Scotch-Weld™ Low Odor and MMA Acrylic Adhesives

3M's Low Odor and MMA Acrylic Adhesives are designed for all of your sign application needs. They provide excellent impact strength, high peel strength and greatly extended shelf life compared to ordinary structural adhesives. With high structural strength, fast cure and environmental resistance, they are the first choice for the sign industry.



### 3M™ Scotch-Weld™ Instant Adhesives – Super Fast

Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
SF20 (Clear)	Fast cure Optimum performance on wide range of rubbers and plastics	20	-65° to 180°F (-54° to 82°C)	< 10 sec.	24	20 gram bottle	00-051111-91667-4	7100049744
SF100 (Clear)	Fast cure, high strength with EPDM and other elastomers	100	-65° to 180°F (-54° to 82°C)	< 10 sec.	24	3 gram tube 20 gram bottle 500 gram bottle	00-048011-62630-7 00-048011-62631-4 00-048011-62629-1	7100039207 7100039206 7100039208

### 3M™ Scotch-Weld™ Instant Adhesives – Rubber Toughened

RT5000B (Black)	Rubber toughened for impact resistance High viscosity for minor gap filling	5,000	-65° to 180°F (-54° to 82°C)	< 40 sec.	24	20 gram bottle 500 gram bottle	00-051111-91665-0 00-051115-25200-6	7100039251 7100039252
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### 3M™ Scotch-Weld™ Instant Adhesives – Engineered Grade

CA4	Fast setting for a variety of plastics and rubbers	150	-65° to 180°F (-54° to 82°C)	5-40 sec.	24	2 gram tube 1 oz. bottle 1 lb. bottle	00-021200-96601-9 00-021200-96600-2 00-021200-96597-5	7010366320 7000028586 7000028587
CA5	Higher viscosity, slower setting version of CA4 for filling gaps Meets CID A-A-3097, Type II, Class 3	2,000	-65° to 180°F (-54° to 82°C)	12-60 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-74289-7 00-021200-74288-0	7000046524 7010367474
CA8	Rapid setting Excellent adhesion to metals, plastics and rubbers Meets CID A-A-3097, Type II, Class 2	70-130	-65° to 180°F (-54° to 82°C)	5-40 sec.	24	2 gram tube 1 oz. bottle 1 lb. bottle	00-021200-21065-5 00-021200-21066-2 00-021200-21067-9	7000121354 7000046526 7000046527
* CA40	Very fast setting Excellent adhesion to many substrates including flexible vinyl and EPDM rubber	20	-65° to 180°F (-54° to 82°C)	3-20 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-74290-3 00-021200-74291-0	7000000893 7000000894
CA40H	Higher viscosity version of CA40 Better void filling capabilities	400-600	-65° to 212°F (-54° to 100°C)	5-40 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-21073-0 00-021200-21074-7	7000000895 7000000896
CA50 Gel	High-viscosity, non-sag gel Less sensitive to acidic surfaces	20,000-50,000	-65° to 212°F (-54° to 100°C)	60-120 sec.	24	20 gram tube	00-021200-82332-9	7100002517
CA100	High peel and impact strength High thermal shock and heat resistance	2,500-4,500	-65° to 212°F (-54° to 100°C)	20-70 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-82334-3 00-021200-82335-0	7000000900 7000000901

For lead times on bulk adhesives, please contact your 3M representative.

**Note:** The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

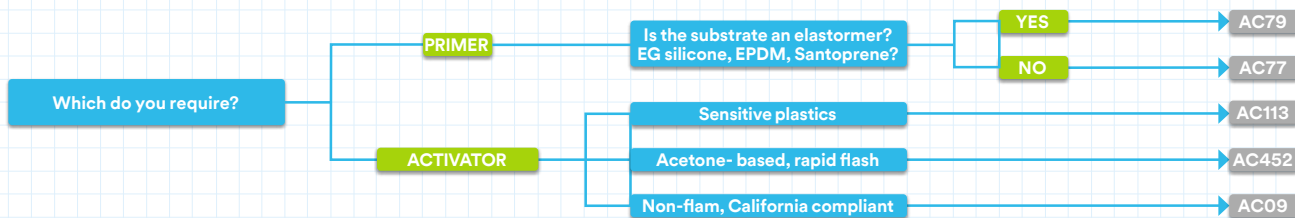
**KEY PRODUCT** Denotes product to consider first in this category

\* After Key Products, consider these.

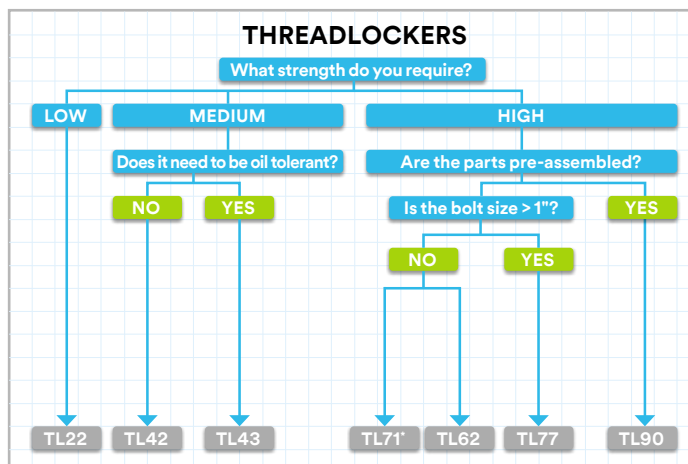
## 3M™ Scotch-Weld™ Instant Adhesive Primers & Activators

Product (Color)	Key Features	Typical Viscosity (cP)	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
AC77	Instant adhesive primer for bonding of difficult-to-bond plastics such as polyethylene, polypropylene and polyacetal	<3	1-5 sec.	24	2 fl. oz. bottle 1 gallon can	00-048011-62728-1 00-638060-40067-8	7100039260 7100190206
AC79	Instant adhesive primer for bonding of difficult-to-bond elastomers such as silicone, fluoroelastomer and EPDM VOC compliant	2	1-5 sec.	24	2 fl. oz. bottle 8 fl. oz. bottle 4 liter can	00-051115-31388-2 00-051115-31389-9 00-051115-31390-5	7100039262 7100039264 7100039265
AC113	Instant adhesive general purpose accelerator Will not attack plastics	<3	1-5 sec.	24	8 fl. oz bottle	00-048011-62682-6	7100079891
Surface Activator	Clear, colorless organic-based liquid helps speed curing and prime surfaces Comes with brush and spray pump	<10	1-5 sec.	24	2 fl. oz. bottle	00-021200-87937-1	7000046525

### SURFACE PREPARATION



### THREADLOCKERS





## 3M™ Scotch-Weld™ Anaerobic Adhesives (cont.)

### 3M™ Scotch-Weld™ Anaerobic Adhesives – Threadlockers

Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
TL22 (Purple)	Screwlock - low removal torque fasteners less than a 1/4" (6mm)	1,200	-65° to 300°F (-54° to 149°C)	< 30 minutes	24	50mL bottle	00-048011-62602-4	7100039159
TL42 (Blue)	Nutlock - medium strength, general purpose	1,200	-65° to 300°F (-54° to 149°C)	< 30 minutes	24	1mL pipette 10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-048011-62604-8 00-048011-62605-5 00-048011-62606-2 00-048011-62607-9 00-051115-25124-5	7100064043 7100039190 7100039193 7100039192 7010310189
TL43 (Blue)	Oil tolerant, medium strength, general purpose	10,000–18,000	-65° to 300°F (-54° to 149°C)	< 30 minutes	24	10mL bottle 50mL bottle 250mL bottle	00-051115-25138-2 00-051115-25139-9 00-051115-25140-5	7100039219 7100039222 7100039221
TL71 (Red)	Permanent studlock for bolts and studs up to 1" (25mm)	500	-65° to 400°F (-54° to 204°C)	< 30 minutes	24	10mL bottle 50mL bottle 250mL bottle	00-048011-62612-3 00-048011-62613-0 00-048011-62614-7	7100039197 7100039231 7100039230
TL90 (Green)	Penetrating adhesive for pre-assembled fasteners and porosity sealing of welds	20	-65° to 300°F (-54° to 149°C)	< 30 minutes	24	10mL bottle 50mL bottle 250mL bottle	00-048011-62615-4 00-048011-62616-1 00-048011-62617-8	7100039234 7100039236 7100039235

### 3M™ Scotch-Weld™ Anaerobic Adhesives – Activators

AC649 (Green)	Acetone-based green primer for inactive or very cold surfaces 30-day part life for pre-application California compliant	<3	N/A	<5 minutes	24	8 fl. oz. bottle	00-048011-62709-0	7010367620
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For lead times on bulk adhesives, please contact your 3M representative.

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**\*** After Key Products, consider these.

#### 3M™ Scotch-Weld™ Multi-Material Composite Urethane Adhesive DP6310NS

3M™ Scotch-Weld™ Multi-Material Composite Urethane Adhesive DP6310NS is a green, non-sag, two-component urethane for bonding a variety of composites, plastics, metals and wood. This flexible adhesive has excellent elongation and stress strain properties for durable bonding of composite parts and multi-material assemblies.



#### 3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesives










The PR (Plastic & Rubber) series of products bonds to most plastics and rubbers with a range of viscosities that will fit all your application needs. Just a single drop per square inch bonds several thousand pounds of holding power. They provide proven, world record strength with a hold of 8 metric tons.





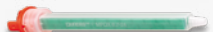








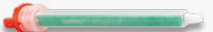

\*For permanent attachment.

# 3M™ Scotch-Weld™ EPX Applicators and Nozzles

## 3M™ EPX Applicators and Nozzles

		Replacement Plunger Orders		43 mL (10:1)	45 mL (10:1)	48.5 mL (1:1)	50 mL (2:1)	200 mL (2:1 & 1:1)	400 mL (2:1 & 1:1)	Nozzle Length (Inches)	Static Mixing Nozzle Options
<b>3M™ Scotch-Weld™ EPX™ Plus II Applicator*</b>  Stock #: 7100148764 UPC: 00-063806-01001-7	<b>1:1/2:1 Shared Plunger</b> Stock #: 7010415317 UPC: 00-063806-01000-0			✓	✓					3.6	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 48.5mL/50mL Stock #: 7100104991 UPC: 0-00-76308-86434-7  Bulk: 7100148765 Bulk: 0-00-63806-01003-1
				✓	✓					6.2	<b>3M™ EPX™ Mixing Nozzle</b> Helical White, 48.5mL/50mL Stock #: 7100148766 UPC: 00-063806-01004-8  Bulk: 7100148756 Bulk: 00-063806-01005-5
	<b>10:1 Plunger</b> Stock #: 7010329933 UPC: 0-00-76308-86391-3	✓	✓								3.6
*Includes 1:1 / 2:1 shared plunger and 10:1 plunger.											
<b>3M™ EPX™ Pneumatic Applicator 48.5/50 mL</b>  Stock #: 7100148769 UPC: 00-063806-01006-2	N/A		✓	✓						3.6	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 43mL/48.5mL Stock #: 7100104991 UPC: 0-00-76308-86434-7  Bulk: 7100148765 Bulk: 0-00-63806-01003-1
					✓	✓					6.2
<b>3M™ Scotch-Weld™ Dual Drive Manual 1:1/2:1 Applicator 200mL</b>  Stock #: 7100244673 UPC: 00-063806-40916-9	<b>1:1/2:1 Shared Plunger</b> Stock #: 7100148764 UPC: 00-063806-01001-7						✓	✓		5.0	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200 mL/400 mL Stock #: 7000028616 UPC: 00-063806-01004-8 
											7.5
<b>3M™ EPX™ 400 mL Manual Applicator</b>  Stock #: 7000046634 UPC: 00-051111-98073-6	N/A						✓	✓		5.0	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200 mL/400 mL Stock #: 7000028616 UPC: 0-00-21200-97331-4 
											7.5

### 3M™ Scotch-Weld™ EPX Applicators and Nozzles (cont.)

3M™ EPX™ Applicators and Nozzles		Replacement Plunger Orders	200 mL (2:1 & 1:1)	400 mL (2:1 & 1:1)	490 mL (10:1)	Nozzle Length (Inches)	Static Mixing Nozzle Options
<b>3M™ Scotch-Weld™ Dual Drive Manual 10:1 Applicator</b>  Stock #: 7100244472 UPC: 00-638060-40914-5	N/A				✓	9.5	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical Orange, 490mL Stock #: 7100304367 UPC: 0-00-51115-69042-6 
						4.4	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 490mL Stock #: 7100066351 UPC: 0-00-51115-81619-2 
<b>3M™ Scotch-Weld™ Dual Drive Pneumatic 1:1/2:1 Applicator 200mL</b>  Stock #: 7100244628 UPC: 00-638060-40917-6	N/A		✓			5.0	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200mL/400mL Stock #: 7000028616 UPC: 0-00-21200-97331-4 
						7.5	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 200mL/400mL Stock #: 7000046633 UPC: 0-00-21200-87972-1 
<b>3M™ Scotch-Weld™ Dual Drive Pneumatic 1:1/2:1 Applicator 400mL</b>  Stock #: 7100244682 UPC: 0-00-638060-40918-3	N/A		✓			5.0	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200mL/400mL Stock #: 7000028616 UPC: 0-00-21200-97331-4 
						7.5	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 200mL/400mL Stock #: 7000046633 UPC: 0-00-21200-87982-1 
<b>3M™ Scotch-Weld™ Dual Drive Pneumatic Applicator 490mL</b>  Stock #: 7100244681 UPC: 00-638060-40919-0	N/A				✓	9.5	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical Orange, 490 mL Stock #: 7100304367 UPC: 0-00-51115-69042-6 
						4.4	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle, Low Waste</b> Square Green, 490 mL Stock #: 7100066351 UPC: 0-00-51115-81619-2 
<b>Standard Caulk Gun</b>	N/A		3M™ Concrete Repair Urethane 8.4 oz cartridges			5.5	<b>3M™ Concrete Repair 8.4 oz Cartridge Nozzles</b> Stock #: 7000046642 UPC: 0-00-48011-53382-7 

For low volume applications and take-it-to-the-job convenience, the 3M™ EPX Plus II and EPX metal manual applicators comfortably dispense any of the 3M™ Scotch-Weld™ Duo-Pak Structural Adhesives. For higher volume applications, select the 200mL manual dispenser, or the 200mL or 400mL pneumatic dispenser. For concrete repair, there are both manual or pneumatic options.

3M™ Scotch-Weld™ One-Part Heat Cured Epoxies require a unique manual or pneumatic dispenser, such as Semco® 250, 350, 850, 950, or equivalent.

# 5 Structural Adhesives Myths Disproved

For more information about some of the most common myths and misconceptions around structural adhesives and how 3M can help disprove these myths, visit [3M.com/bondwithus](https://www.3m.com/bondwithus).

## MYTH #1

### Structural Adhesives Don't Hold **DISPROVED**

Consider the evidence – 3M Structural Adhesives can outperform “traditional” attachment methods like screws, rivets and spot welds.

## MYTH #2

### Holding Pieces Together is All That Matters **DISPROVED**

Proper planning can improve performance. Evaluating your entire process could influence the bonding solution you should choose for maximum benefit.

## MYTH #3

### “I've Tried One So I've Tried Them All” **DISPROVED**

Different adhesives offer different properties. The bonding continuum offers different adhesive options, strengths, viscosities, open times, resistance properties, and flexibility and rigidity levels.

## MYTH #4

### All Structural Adhesives are Epoxies **DISPROVED**

Not all structural adhesives are made the same. Beyond just epoxies, 3M Structural Adhesives offer a variety of product families, chemistries, sizes and configurations.

## MYTH #5

### “I'm On My Own To Figure This Out” **DISPROVED**

3M is Here to Help. Adhesives are core to some of our most iconic brands, so we have the technical expertise and global resources to cost-effectively help you bring your concept to life.

## Surface Preparation Tips

The following surface preparation steps are generally recommended for most substrates and structural adhesives. See Technical Data Sheets for more specific recommendations.

### METALS

1. Safely wipe surface with acetone or methyl ethyl ketone (MEK) using a clean cloth. A heavier degreaser may be needed if the substrate contains a layer of processing oil.
2. Lightly abrade surface with sandblasting, fine grit sandpaper or 3M™ Scotch-Brite™ 7447 maroon pads.
3. Wipe surface with acetone or MEK to remove debris.
4. Allow surface to dry before applying adhesive.

### PLASTICS AND RUBBERS

1. Lightly abrade surface with sandblasting, fine grit sandpaper or 3M™ Scotch-Brite™ 7447 maroon pads.
2. Wipe surface with isopropyl (IPA) alcohol using a clean cloth to remove debris.
3. Allow solvent to evaporate before applying adhesive.

### GLASS

1. Wipe surface using a clean cloth with solvent containing 0.5 wt% silane adhesion promoter or wipe with 3M™ Scotch-Weld™ Metal Primer 3901.
2. Allow solvent to evaporate before applying adhesive.

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