

**3M** Science.  
Applied to Life.™



**Scotch-Weld™**  
Structural Adhesive

## Product Selection Guide

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

January 2019



**Scotch-Weld™**  
Structural Adhesive

# 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.

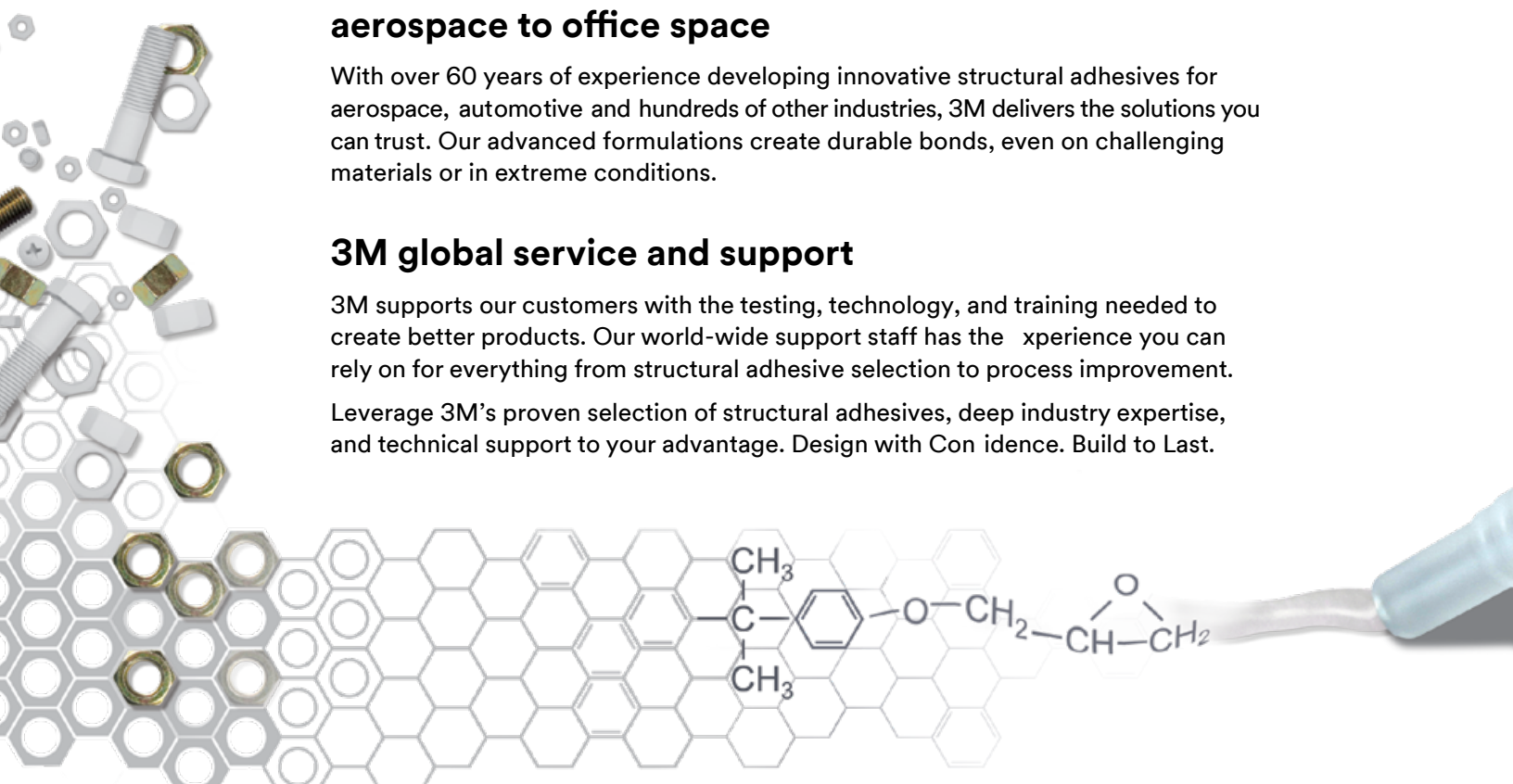
## Trusted innovations from aerospace to office space

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 create better products. Our world-wide support staff has the experience you can rely on for everything from structural adhesive selection to process improvement.

Leverage 3M's proven selection of structural adhesives, deep industry expertise, and technical support to your advantage. Design with Confidence. Build to Last.



**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.



### Design Solutions

**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.



### Process Efficiencies

**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.



### Performance Optimization

**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.

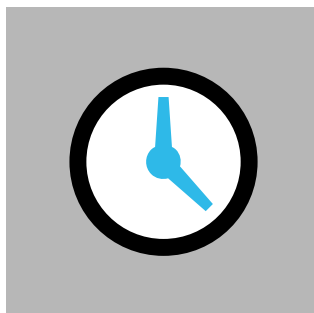
## **Q: What materials will be bonded?**

**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.



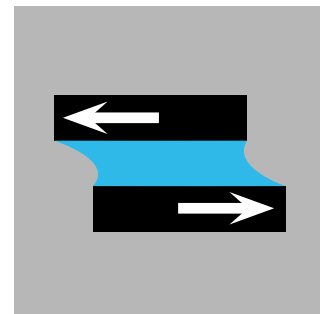
## **Q: What surface preparation will be required?**

**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.



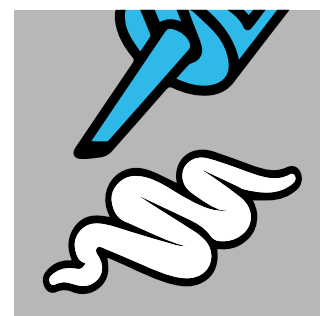
## **Q: What types of joints are best for structural adhesives?**

**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.



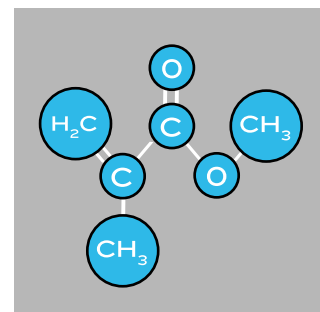
## **Q: How are structural adhesives used and applied?**

**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.

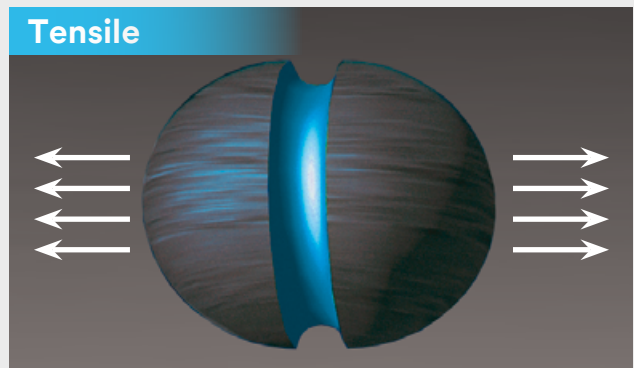
- **Acrylic adhesives** are two-part adhesives that provide excellent bond strength and durability, although slightly lower than epoxy adhesives. However, they have several features that make them easier to use in many applications and manufacturing processes. These benefits include a much faster cure 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.

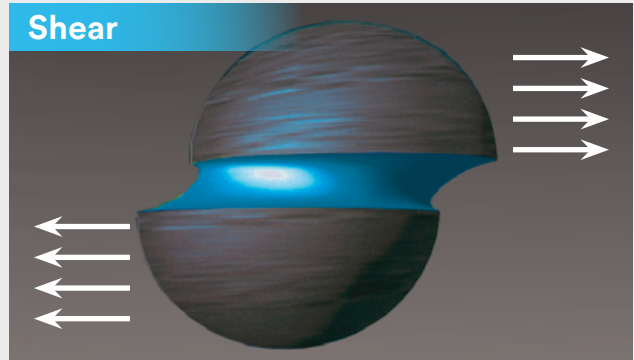
- **Cyanoacrylate adhesives** (instant adhesives) are one-component, lower viscosity liquids that cure extremely quickly with just contact pressure and surface moisture. They adhere well, with thin bond lines, to plastics, metals and rubbers. With the use of primers, they can also adhere to low surface 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.

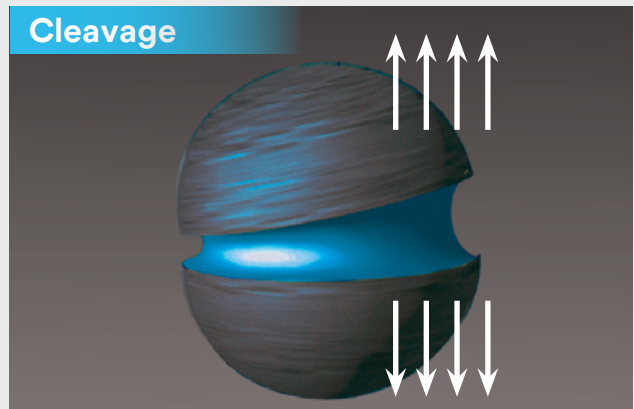
- **PUR adhesives** (Polyurethane-reactive adhesives) are one-part adhesives that apply like a hot melt, but cure with ambient moisture for near structural strength bonds. Fast set times and build strength over the next 24-48 hours can reach as much as 1,000 psi in overlap shear strength. They are flexible 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).



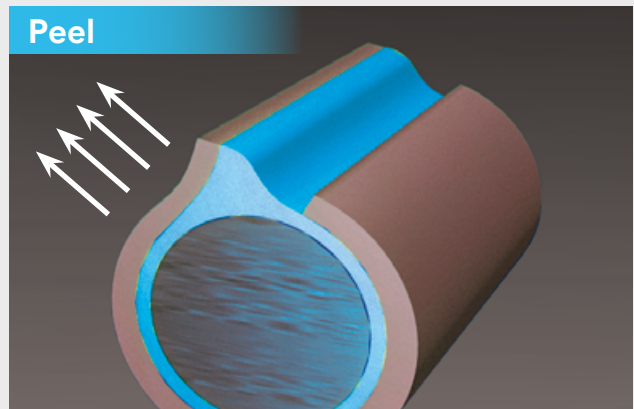
**Tensile** is pull exerted equally over the entire joint. Pull direction is straight and away from the adhesive bond.



**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 Black, DP8810NS, PR100, TS230

### Specialty Vehicle

#### Key Features & Benefits:

- Weight reduction
- High strength
- Vibration & fatigue resistance

#### Key Products:

DP6330NS, DP8410NS, 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:

DP8805NS, DP8405NS, DP100 Plus

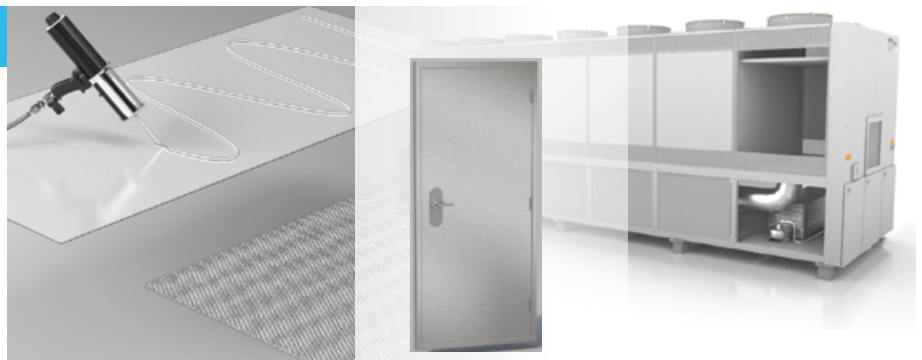
### Metalworking

#### 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 Black, 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:**

DP420LH, DP8805NS, TS230, PR100



## 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 Gray, DP6310NS, DP8810NS, TS230, TL42

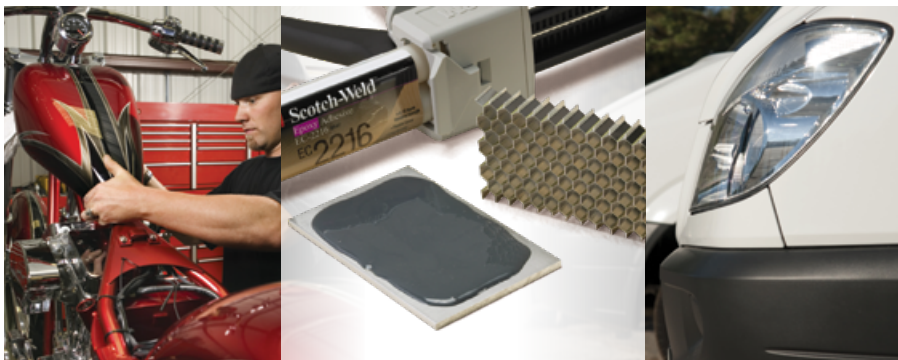
## Aerospace

### **Key Features & Benefits:**

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

### **Key Products:**

2216 Gray, DP100FR, DP640, TL71



## Plastic, Composite & Rubber

### **Key Features & Benefits:**

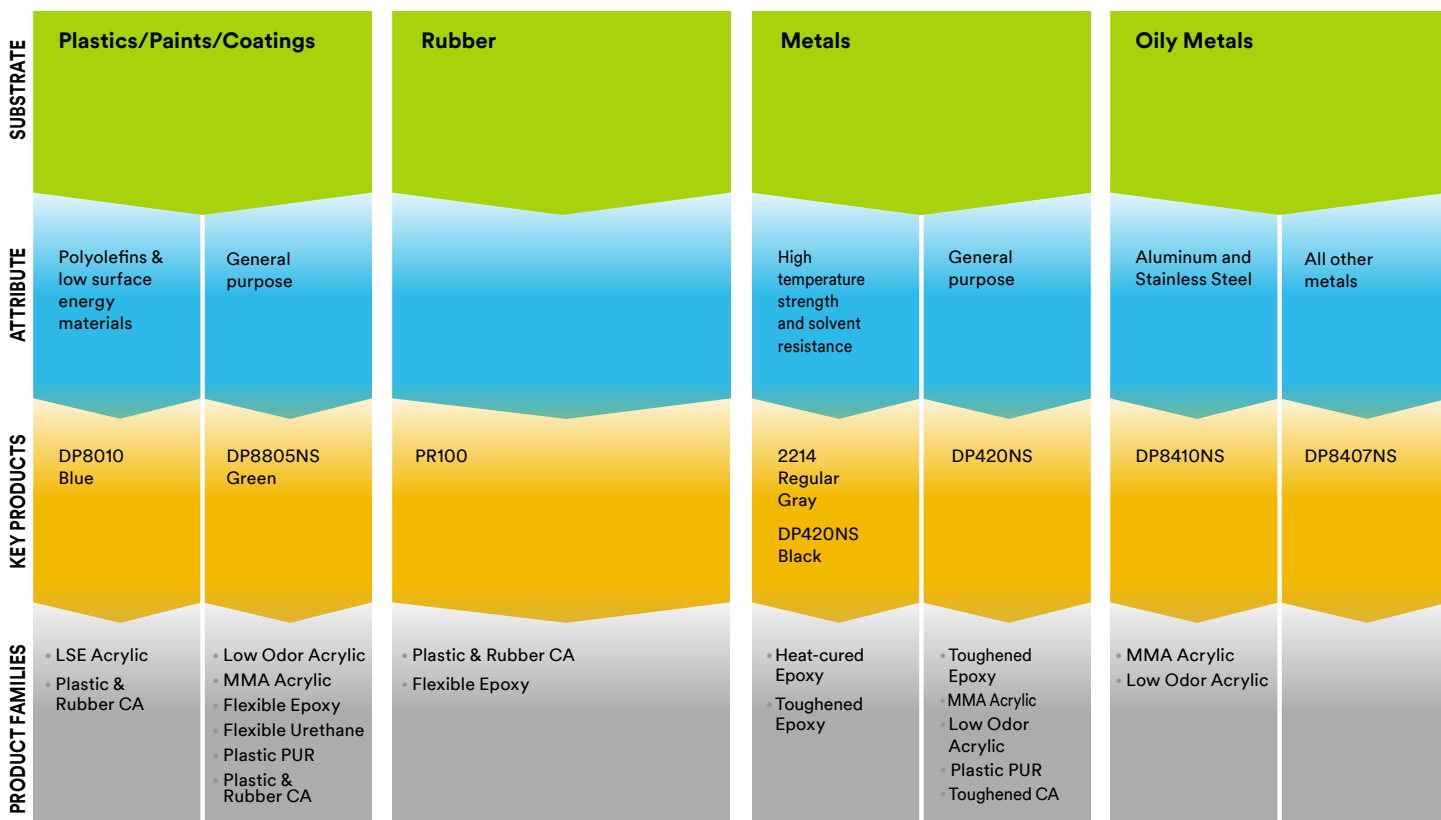
- Bonding of low surface energy plastics without priming
- Impact resistant composite bonding

### **Key Products:**

DP8010 Blue, DP420NS, DP6310NS, 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 Acrylic Adhesives** — Outstanding adhesion to polyolefin materials such as polypropylene, polyethylene and TPO without surface treatment.

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

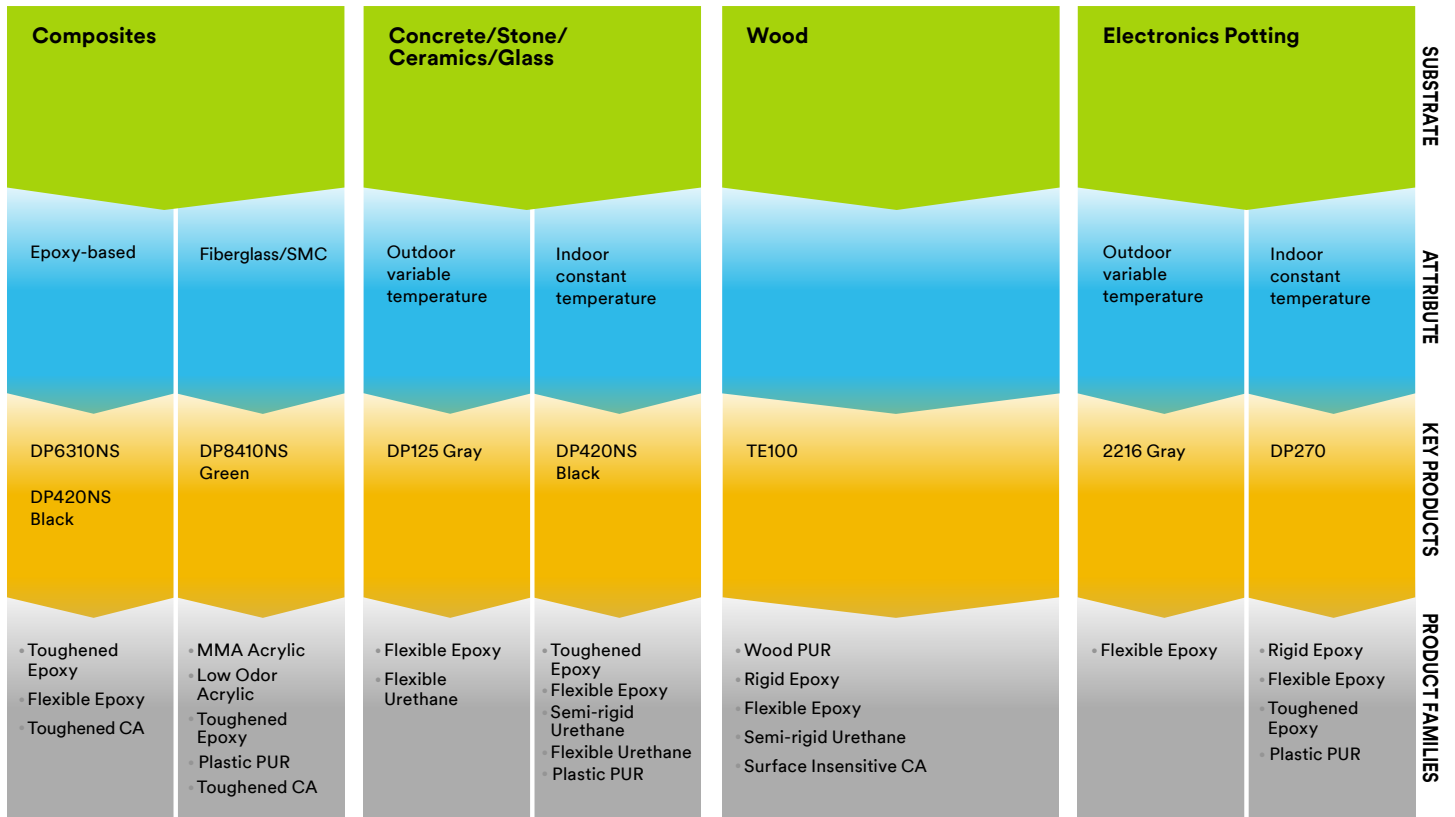
**Flexible Urethane Adhesives** — Lower tensile modulus and higher elongation capability. Excellent adhesion to most plastics.

## 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.

**Retaining Compounds (RT)** bond and seal non-threaded cylindrical metal assemblies, such as press-fit or slip-fit parts; these adhesives replace keys, splines, and set screws.

**Pipe Sealants (PS)** provide a pressure seal on threaded tubes and pipes; these adhesives replace various tapes and pastes.

**Gasket Makers (GM)** fill voids between metal parts to create a form-in-place gasket; these adhesives replace o-rings and pre-formed gaskets.

### 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             |                                                                                         | Rubber                              | Metals                                     |                                                                                     |                                                                         | Oily Metals                             |                           | Composites                                                                                         |                                                                                         | Concrete/Stone/Ceramics/Glass                                   |                                                                  | Wood                                                                          |
|-------------------------------|-----------------------------------|-------------------------------------|-----------------------------------------------------------------------------------------|-------------------------------------|--------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------|-----------------------------------------|---------------------------|----------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------|-----------------------------------------------------------------|------------------------------------------------------------------|-------------------------------------------------------------------------------|
|                               |                                   | Low Surface Energy                  | General Purpose                                                                         |                                     | Temperature and Solvent Resistant          | Stainless Steel & Aluminum                                                          | Other Metals                                                            | Stainless Steel & Aluminum              | Other Metals              | Fiberglass/ SMC                                                                                    | Epoxy                                                                                   | Indoor                                                          | Outdoor                                                          |                                                                               |
| 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 Flexible 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 Urethane 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 Urethane Plastic PUR Toughened CA   | Plastic & Rubber CA* Plastic PUR    | Toughened Epoxy Flexible Epoxy Plastic PUR | Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened 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 Flexible 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                           | Plastic PUR Surface Insensitive CA* | Toughened Epoxy Plastic PUR Flexible Epoxy | Plastic PUR Toughened Epoxy Rigid Epoxy Surface Insensitive CA                      | Plastic 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    |

 BEST IN CLASS PRODUCT    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.

**NOTE:** The technical information and data provided here should be considered representative or typical only and should not be used for specification purposes.

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

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

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

# 3M™ Scotch-Weld™ Rigid 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 PL (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 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<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                              | 00-638060-08994-1<br>00-021200-87260-0<br>00-021200-87261-7<br>00-021200-82345-9<br>00-021200-82344-2                       | 7100148763<br>7100075490<br>7000121318<br>7100086557<br>7100086558               |
| DP100FR 100FR (Off White)   | 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<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                              | 00-638060-08989-7<br>00-048011-56744-0<br>00-048011-56743-3<br>00-048011-57230-7<br>00-048011-57229-1                       | 7100148760<br>7000148268<br>7000028577<br>7010366158<br>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<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                              | 00-638060-08974-3<br>00-021200-87264-8<br>00-021200-87265-5<br>00-021200-82257-5<br>00-021200-82256-8                       | 7100148744<br>7100014024<br>7100082554<br>7010367412<br>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<br>200mL<br>400mL<br>Gallon kit<br>5 gal. pail A<br>5 gal. pail B                | 00-638060-08975-0<br>00-021200-87836-7<br>00-021200-87837-4<br>00-021200-82263-6<br>00-021200-82265-0<br>00-021200-82264-3  | 7100148745<br>7000121252<br>7100082565<br>7000121253<br>7000046463<br>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<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                              | 00-638060-08973-6<br>00-021200-87834-3<br>00-021200-87835-0<br>00-021200-82251-3<br>00-021200-82250-6                       | 7100148730<br>4000009361<br>7100077143<br>7000028575<br>7000028567               |
| 1751 B/A (Gray)             | Excellent void fille Rigid bonds     | 3:2                    | 700,000                              | 45 minutes                                 | 10 hours                                             | 4 (7)                                         | 1,400 (10)               | 2,000 (14)  | 500 (3)      | 2 oz. tube kit<br>Pint kit<br>Quart kit<br>Gallon kit<br>5 gal. pail A<br>5 gal. pail B | 00-021200-20100-4<br>00-021200-20101-1<br>00-021200-20103-5<br>00-021200-20105-9<br>00-021200-20108-0<br>00-021200-20120-2  | 7000121211<br>7000046336<br>7000046337<br>7000046339<br>7010309727<br>7010367210 |
| 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)      | 2 oz. tube kit<br>Pint kit<br>Quart kit<br>Gallon kit<br>5 gal. pail A<br>5 gal. pail B | 00-021200-20148-6<br>00-021200-20150-9<br>00-021200-20152-3<br>00-021200-20154-7<br>00-021200-20160-8<br>00-021200-20155-4  | 7000000810<br>7010295295<br>7000046340<br>7000121212<br>7010309728<br>7010367213 |
| 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)      | 2 oz. tube kit<br>Quart kit<br>5 gal. pail A<br>5 gal. pail B                           | 00-021200-22645-8<br>00-021200-22646-5<br>00-021200-82635-1<br>00-021200-82634-4                                            | 7010367467<br>7000036224<br>7010366157<br>7010330215                             |
| 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)      | Pint kit<br>Quart kit<br>Gallon kit<br>5 gal. pail A<br>5 gal. pail B                   | 00-021200-20258-2<br>00-021200-20260-5<br>00-021200-20262-9<br>00-021200-20269-8<br>00-021200-20264-3                       | 7010309731<br>7000046348<br>7010330060<br>7000046350<br>7000046349               |
| 3501 B/A (Gray)             | Multi-purpose Rigid bonds            | 1:1                    | 500,000                              | 7 minutes                                  | 25 minutes                                           | 4 (7)                                         | 1,500 (10)               | 2,400 (16)  | 300 (2)      | 2 oz. tube kit<br>400mL<br>Pint kit<br>Gallon kit<br>55 gal. drum A<br>55 gal. drum B   | 00-021200-20842-3<br>00-021200-45184-3<br>00-021200-20843-0<br>00-021200-20846-1<br>00-051111-091640-7<br>00-051111-91639-1 | 7000046476<br>7010367460<br>7100010271<br>7010367461<br>7010292710<br>7010367462 |

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

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

\* After Key Products, consider these.

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

# 3M™ Scotch-Weld™ Flexible Epoxies

|             | Product (Color)                   | Key Features                                   | Mix Ratio<br>(Volume) B:A | Approximate<br>Viscosity at<br>75°F (24°C) (cP) | Approximate<br>Mixed Work Life<br>at 75°F (24°C) | Approximate Time<br>to Handling Strength<br>at 75°F (24°C) | Floating Roller Peel<br>PL(N/cm) at 75°F (24°C) | Overlap Shear: psi (MPa) |                |                 | Size           | UPC               | Stock #    |
|-------------|-----------------------------------|------------------------------------------------|---------------------------|-------------------------------------------------|--------------------------------------------------|------------------------------------------------------------|-------------------------------------------------|--------------------------|----------------|-----------------|----------------|-------------------|------------|
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 | -67°F<br>(-55°C)         | 75°F<br>(24°C) | 180°F<br>(82°C) |                |                   |            |
| KEY PRODUCT | DP100 Plus<br>100 Plus<br>(Clear) | Very flexible<br>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 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 400mL          | 00-021200-87267-9 | 7000121255 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 5 gal. pail A  | 00-021200-87198-6 | 7100046020 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 5 gal. pail B  | 00-021200-87197-9 | 7100084539 |
|             | DP105<br>105<br>(Clear)           | Very flexible<br>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 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 400mL          | 00-021200-87271-6 | 7100076786 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 5 gal. pail A  | 00-021200-87206-8 | 7000000856 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 5 gal. pail B  | 00-021200-87205-1 | 7000000850 |
|             | DP110<br>110<br>(Gray)            | General purpose<br>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 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 400mL          | 00-021200-87275-4 | 7100009581 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 5 gal. pail A  | 00-021200-82472-2 | 7010299362 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 5 gal. pail B  | 00-021200-82471-5 | 7010299357 |
|             | DP110<br>110<br>(Translucent)     | General purpose<br>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<br>125<br>(Gray)            | High performance<br>Very flexible<br>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<br>125<br>(Translucent)     | High performance<br>Very flexible<br>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 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 200mL          | 00-021200-87842-8 | 7100025419 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 400mL          | 00-021200-87843-5 | 7000121262 |
|             | DP190<br>(Translucent)            | High performance<br>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 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 200mL          | 00-021200-87838-1 | 7000121260 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 400mL          | 00-021200-87839-8 | 7010329707 |
| *           | DP190<br>(Gray)                   | High performance<br>Slightly flexible<br>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<br>(Gray)                | High performance<br>Very flexible<br>bonds     | 2:3                       | 80,000                                          | 90 minutes                                       | 10 hours                                                   | 50 (89)                                         | 3,000 (21)               | 3,200 (22)     | 400 (3)         | 43mL Duo-Pak   | 00-021200-56659-2 | 7000046357 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 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 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 55 gal. drum A | 00-021200-20366-4 | 7100166318 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 55 gal. drum B | 00-021200-20361-9 | 7100166319 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 2 oz. tube kit | 00-021200-20851-5 | 7000046479 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | Pint kit       | 00-021200-20852-2 | 7010310194 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 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 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 55 gal. drum A | 00-021200-20927-7 | 7010330240 |
|             |                                   |                                                |                           |                                                 |                                                  |                                                            |                                                 |                          |                |                 | 55 gal. drum B | 00-021200-20859-1 | 7010367466 |
|             | 2216NS<br>B/A (Tan)               | High performance<br>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 |

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

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

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

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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 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 #                                                                                                      |
|---------------------------|-----------------------------------------------|-----------------------------------------------------------------------------|--------------------------------------|---------------------------------|--------------------------------------------|------------------------------------------------------|------------------------------------------------|--------------------------|-------------|--------------|------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------|
|                           |                                               |                                                                             |                                      |                                 |                                            |                                                      |                                                | -67°F (-55°C)            | 75°F (24°C) | 180°F (82°C) |                                                                                                            |                                                                                                                                                                       |                                                                                                              |
| DP405 405 (Black)         | Tough durable bonds<br>High impact resistance | 2:1                                                                         | 40,000                               | 4 minutes                       | 15 minutes                                 | 40 (71)                                              | 4,500 (31)                                     | 4,500 (31)               | 600 (4)     |              | 50mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                                                            | 00-638060-08971-2<br>00-051111-07699-6<br>00-051111-07708-5<br>00-051111-07707-8                                                                                      | 7100148728<br>7010365943<br>7010301041<br>7010329549                                                         |
| DP420 420 (Black)         | Tough durable bonds<br>High impact resistance | 2:1                                                                         | 30,000                               | 20 minutes                      | 2 hours                                    | 75 (133)                                             | 4,500 (31)                                     | 4,500 (31)               | 1,250 (9)   |              | 50mL<br>200mL<br>400mL<br>Gallon Kit<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B | 00-638060-08966-8<br>00-021200-41530-2<br>00-021200-41529-6<br>00-051115-25796-4<br>00-021200-41532-6<br>00-021200-41531-9<br>00-021200-41534-0<br>00-021200-41533-3  | 7100148731<br>7100007956<br>7100077148<br>7000046381<br>7000000834<br>7000000827<br>7010365967<br>7010309750 |
| DP420 420 (Off White)     | Tough durable bonds<br>High impact resistance | 2:1                                                                         | 30,000                               | 20 minutes                      | 2 hours                                    | 70 (125)                                             | 4,500 (31)                                     | 4,500 (31)               | 450 (3)     |              | 50mL<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                                                   | 00-638060-08978-1<br>00-021200-87832-9<br>00-021200-87833-6<br>00-021200-82239-1<br>00-021200-82238-4                                                                 | 7100148736<br>7100077136<br>7100002516<br>7100001144<br>7100001145                                           |
| DP420LH 420LH (Off White) | Tough durable bonds<br>Low halogen            | 2:1                                                                         | 30,000                               | 20 minutes                      | 2 hours                                    | 70 (125)                                             | 4,500 (31)                                     | 4,500 (31)               | 1,250 (9)   |              | 200mL<br>400mL                                                                                             | 00-051111-07697-2<br>00-051111-07696-5                                                                                                                                | 7010329550<br>7100075336                                                                                     |
| KEY PRODUCT               | DP420NS 420NS (Black)                         | Tough durable bonds<br>Non-sag                                              | 2:1                                  | 180,000                         | 20 minutes                                 | 2 hours                                              | 60 (107)                                       | 4,500 (31)               | 4,500 (31)  | 1,250 (9)    | 50mL<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B               | 00-638060-08987-3<br>00-021200-39286-3<br>00-021200-39287-0<br>00-021200-31309-7<br>00-021200-56587-8<br>00-048011-58133-0<br>00-048011-58132-3                       | 7100148758<br>7100036943<br>7100010680<br>7000000857<br>7000000853<br>7100160352<br>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<br>5 gal. pail B                                                                             | 00-021200-25319-5<br>00-021200-25318-8                                                                                                                                | 7000121271<br>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<br>200mL<br>400mL<br>Quart kit<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B  | 00-638060-08998-9<br>00-021200-87830-5<br>00-021200-87831-2<br>00-021200-82226-1<br>00-021200-82228-5<br>00-021200-82227-8<br>00-021200-83757-9<br>0-00-76308-14623-8 | 7100148768<br>7000121321<br>7100082563<br>7000000874<br>7000000876<br>7000000875<br>7010366165<br>7100153215 |
|                           | DP460NS 460NS (Off White)                     | Tough durable bonds<br>Non-sag                                              | 2:1                                  | 125,000                         | 60 minutes                                 | 4 hours                                              | 70 (125)                                       | 4,900 (34)               | 4,650 (32)  | 1,350 (9)    | 50mL<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                                                   | 00-638060-08968-2<br>00-021200-43671-0<br>00-021200-43672-7<br>00-021200-43674-1<br>00-021200-43673-4                                                                 | 7100148751<br>7100069441<br>7100076677<br>7010329565<br>7010301036                                           |
|                           | LSB60 (Gray)                                  | Tough durable bonds<br>High impact resistance                               | 1:1                                  | 30,000                          | 90 minutes                                 | 10 hours                                             | 15 (27)                                        | 3,400 (23)               | 4,500 (31)  | 900 (6)      | 400mL<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B                                | 00-051115-63411-6<br>00-051115-63416-1<br>00-051115-63414-7<br>00-051115-63418-5<br>00-051115-63417-8                                                                 | 7000046487<br>7010310209<br>7010366138<br>7010366162<br>7010310202                                           |
|                           | LSB60NS (Gray)                                | Tough durable bonds<br>Non-sag<br>High impact resistance                    | 1:1                                  | 180,000                         | 90 minutes                                 | 10 hours                                             | 30 (53)                                        | 3,800 (26)               | 4,500 (31)  | 800 (6)      | 400mL<br>5 gal. pail A<br>5 gal. pail B<br>50 gal. drum A<br>50 gal. drum B                                | 00-051115-63426-0<br>00-051115-63428-4<br>00-051115-63427-7<br>06-38060-40269-6<br>06-38060-40270-2                                                                   | 7000046491<br>7100079533<br>7100079534<br>7100198360<br>7100198390                                           |
|                           | LSB360NS (Green)                              | Tough durable bonds<br>Non-sag<br>Extra long work life<br>Bonds oily metals | 1:1                                  | Paste                           | 10 hours                                   | 16 hours                                             | 30 (53)                                        | 4,000 (28)               | 3,900 (27)  | 800 (6)      | 400mL<br>55 gal. drum A<br>55 gal. drum B                                                                  | 00-051111-64291-3<br>00-051115-64360-6<br>00-051115-64391-0                                                                                                           | 7010366139<br>7010330243<br>7010299359                                                                       |

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

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

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

| Product (Color)                  | Key Features                                          | Approximate Viscosity at 75°F/24° C (cP) | Time (min.) | Cure Conditions |                                              |               | Overlap Shear: psi (MPa) |              |               |                                             |                                                             | Size                                   | UPC | Stock # |
|----------------------------------|-------------------------------------------------------|------------------------------------------|-------------|-----------------|----------------------------------------------|---------------|--------------------------|--------------|---------------|---------------------------------------------|-------------------------------------------------------------|----------------------------------------|-----|---------|
|                                  |                                                       |                                          |             | Temp: F (°C)    | Floating Roller Peel PU(N/cm) at 75°F (24°C) |               |                          |              |               |                                             |                                                             |                                        |     |         |
|                                  |                                                       |                                          |             |                 |                                              | -67°F (-55°C) | 75°F (24°C)              | 180°F (82°C) | 250°F (121°C) |                                             |                                                             |                                        |     |         |
| 1386 (Cream)                     | High temperature strength<br>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<br>Low viscosity            | 60,000                                   | 120         | 350 (177)       | 2 (4)                                        | 3,150 (22)    | 3,700 (26)               | 3,700 (26)   | 3,600 (25)    | 1 quart<br>5 gal. pail                      | 00-021200-19949-3<br>00-021200-19950-9                      | 7000046328<br>7100056050               |     |         |
| 2214 Hi-Den-sity (Gray)          | High temperature strength<br>Low temp curing          | Paste                                    | 40          | 250 (121)       | 5 (9)                                        | 3,000 (21)    | 4,500 (31)               | 4,500 (31)   | 1,700 (12)    | 6 oz. cart.<br>5 gal. pail                  | 00-021200-20813-3<br>00-021200-20814-0                      | 7000021289<br>7010367423               |     |         |
| 2214 Hi-Temp New Formula (Gray)  | High temperature strength<br>Environmental resistance | Paste                                    | 60          | 250 (121)       | 2 (4)                                        | 2,800 (19)    | 2,800 (19)               | 2,800 (19)   | 2,500 (17)    | 6 oz. cart.<br>5 gal. pail                  | 00-021200-20833-1<br>00-021200-20835-5                      | 7000046474<br>7010330200               |     |         |
| 2214 Hi-Temp Original (Gray)     | High temperature strength<br>Environmental resistance | Paste                                    | 40          | 250 (121)       | 2 (4)                                        | 2,000 (14)    | 2,000 (14)               | 3,000 (21)   | 2,500 (17)    | 6 oz. cart.                                 | 00-021200-20806-5                                           | 7000121274                             |     |         |
| 2214 Non-Metallic Filled (Cream) | High temperature strength<br>Higher insulation value  | Paste                                    | 40          | 250 (121)       | 7 (12)                                       | 3,000 (21)    | 4,000 (28)               | 4,500 (31)   | 1,500 (10)    | 2 oz. tube<br>6 oz. cart.                   | 00-021200-20802-7<br>00-021200-25496-3                      | 7100034990<br>7000121273               |     |         |
| * 2214 Regular (Gray)            | High temperature strength<br>Low temp curing          | Paste                                    | 40          | 250 (121)       | 5 (9)                                        | 3,000 (21)    | 4,500 (31)               | 4,500 (31)   | 1,500 (10)    | 6 oz. cart.<br>1 quart<br>5 gal. pail       | 00-021200-20344-2<br>00-021200-20345-9<br>00-021200-23047-3 | 7000000811<br>7000046356<br>7100111206 |     |         |
| 2290 (Amber)                     | Low solids liquid coating for metal laminations       | 60                                       | 30          | 350 (177)       | 5 (9)                                        | 5,000 (34)    | 5,000 (34)               | 3,500 (24)   | 1,200 (8)     | Gallon cont.<br>5 gal. pail<br>55 gal. drum | 00-021200-76225-3<br>00-021200-76227-7<br>00-021200-76228-4 | 7000000897<br>7100144895<br>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™ Threadlockers

3M's Threadlocker Adhesives offer a range of products including temporary, permanent and high temperature resistance. These adhesives conform to most industry recognized standards for torque and strength. TL42, TL62, TL71, TL90



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

3M™ Scotch-Weld Epoxy Adhesive DP100 Plus 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) | Approximate Mixed Work Life at 75°F (24°C) | Approximate Time to Handling Strength at 75°F (24°C) | Floating Roller Peel PL(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<br>Minimal surface prep | 1:1                    | 110,000                              | 3 minutes                                  | 10 minutes                                           | 35 (62)                                      | 2,500 (17)               | 3,500 (24)  | 2,200 (15)   | 48.5mL<br>200mL                                                                    | 00-638060-08982-8<br>00-021200-87828-2                                                                                     | 7101410436<br>7101367390                                                         |
| DP820 (Light Yellow)       | Tough durable bonds<br>Minimal surface prep | 1:1                    | 55,000                               | 15 minutes                                 | 40 minutes                                           | 20 (36)                                      | 3,100 (21)               | 3,150 (22)  | 1,900 (13)   | 48.5mL<br>200mL<br>400mL                                                           | 00-638060-08977-4<br>00-021200-89348-3<br>00-021200-89349-0                                                                | 7101412194<br>7101329704<br>7100121258                                           |
| DP8405NS<br>8405NS (Green) | High impact<br>Adhesion to most plastics    | 10:1                   | 70,000                               | 5 minutes                                  | 15 minutes                                           | 50 (89)                                      | 2,600 (18)               | 4,100 (28)  | 900 (6)      | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B | 00-051115-68963-5<br>00-051115-68964-2<br>00-051115-68981-9<br>00-051115-68986-4<br>00-051115-68980-2<br>00-051115-68987-1 | 7100009688<br>7100011056<br>7100102180<br>7100027430<br>7100101506<br>7100084534 |
| DP8407NS<br>8407NS (Gray)  | High impact<br>Adhesion to most plastics    | 10:1                   | 20,000                               | 7 minutes                                  | 24 minutes                                           | 50 (89)                                      | 3,400 (23)               | 4,500 (31)  | 1,400 (10)   | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B | 00-638060-14631-6<br>00-638060-14643-9<br>00-638060-14658-3<br>00-076308-86306-7<br>00-638061-14659-0<br>00-076308-98878-4 | 7100179482<br>7100179480<br>7100179264<br>7100105384<br>7100179442<br>7100104987 |
| DP8410NS<br>8410NS (Green) | High impact<br>Adhesion to most plastics    | 10:1                   | 70,000                               | 10 minutes                                 | 25 minutes                                           | 50 (89)                                      | 3,600 (25)               | 4,100 (28)  | 800 (6)      | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B | 00-051115-70994-4<br>00-051115-70995-1<br>00-051115-68981-9<br>00-051115-70997-5<br>00-051115-68980-2<br>00-051115-71101-5 | 7100024055<br>7100024045<br>7100102180<br>7100084532<br>7100101506<br>7100084535 |
| DP8425NS<br>8425NS (Green) | High impact<br>Adhesion to most plastics    | 10:1                   | 70,000                               | 25 minutes                                 | 50 minutes                                           | 50 (89)                                      | 3,800 (26)               | 3,700 (26)  | 800 (6)      | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B | 00-051115-81303-0<br>00-051115-81302-3<br>00-051115-68981-9<br>00-051115-81298-9<br>00-051115-81414-3<br>00-051115-81031-6 | 7100078165<br>7100078166<br>7100102180<br>7101415048<br>7100101506<br>7100084535 |

## 3M™ Scotch-Weld™ Low Odor Acrylics

|                            |                                               |      |        |            |            |         |           |            |         |                                                                                             |                                                                                                                            |                                                                                    |
|----------------------------|-----------------------------------------------|------|--------|------------|------------|---------|-----------|------------|---------|---------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|
| DP810<br>810 (Black)       | Tough durable bond<br>High impact resistance  | 1:1  | 20,000 | 10 minutes | 20 minutes | 30 (53) | 1,200 (8) | 3,600 (25) | 500 (3) | 48.5mL<br>200mL<br>1 gallon pail A<br>1 gallon pail B<br>4.4 gal. pail A<br>4.4 gal. pail B | 00-638060-08967-5<br>00-021200-49079-8<br>00-048011-56712-9<br>00-048011-56711-2<br>00-021200-49081-1<br>00-021200-49080-4 | 7100148732<br>7100142848<br>71000046401<br>71000046385<br>7101365969<br>7101329544 |
| DP810<br>810 (Tan)         | Tough durable bonds<br>High impact resistance | 1:1  | 20,000 | 10 minutes | 20 minutes | 30 (53) | 1,200 (8) | 3,600 (25) | 500 (3) | 48.5mL<br>200mL<br>400mL<br>4.4 gal. pail A<br>4.4 gal. pail B                              | 00-638060-08986-6<br>00-021200-31311-0<br>00-021200-31312-7<br>00-021200-45233-8<br>00-021200-45230-7                      | 7100148757<br>7100121267<br>7100121266<br>7100077450<br>7100077451                 |
| DP810NS<br>810NS (Tan)     | Tough durable bonds<br>Non-sag                | 1:1  | 95,000 | 10 minutes | 20 minutes | 20 (36) | 1,200 (8) | 4,000 (28) | 500 (3) | 48.5mL<br>200mL<br>400mL                                                                    | 00-638060-08969-9<br>00-021200-49084-2<br>00-021200-49083-5                                                                | 7100148748<br>7100069365<br>7100069366                                             |
| DP8805NS<br>8805NS (Green) | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 5 minutes  | 10 minutes | 30 (53) | 800 (5)   | 3,600 (25) | 900 (6) | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B          | 00-076308-98433-5<br>00-076308-98439-7<br>00-051115-81415-0<br>00-076308-98440-3<br>00-051115-81414-3<br>00-076308-98441-0 | 7100098631<br>7100097636<br>7100102180<br>7100097693<br>7100101506<br>7100097673   |
| DP8810NS<br>8810NS (Green) | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 10 minutes | 20 minutes | 30 (53) | 900 (6)   | 3,600 (25) | 800 (6) | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B          | 00-051128-99432-0<br>00-051128-99431-3<br>00-051115-81415-0<br>00-076308-98442-7<br>00-051115-81414-3<br>00-076308-98443-4 | 7100097574<br>7100075409<br>7100102180<br>7100097704<br>7100101506<br>7100097626   |
| DP8810NS<br>(Gray)         | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 10 minutes | 20 minutes | 30 (53) | 900 (6)   | 3,600 (25) | 800 (6) | 45mL<br>490mL                                                                               | 00-076308-86152-0<br>00-076308-98485-4                                                                                     | 7100097474<br>7101329557                                                           |
| DP8825NS<br>8825NS (Green) | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 25 minutes | 50 minutes | 20 (36) | 1,000 (7) | 3,000 (21) | 800 (6) | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B          | 00-051115-81288-0<br>00-051115-81289-7<br>00-051115-81415-0<br>00-051115-81290-3<br>00-051115-81414-3<br>00-051115-81291-0 | 7100067297<br>7100068120<br>7100102180<br>7100067291<br>7100101506<br>7100084533   |

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## 3M™ Scotch-Weld™ Low Surface Energy (LSE) Acrylics

| 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 PL (N/cm) at 75°F (24°C) | Overlap Shear: psi (MPa) |             |              |                                                                                    | UPC                                                                                                                        | Stock #                                                                          |
|-------------|------------------------|---------------------------------------------------------------|------------------------|-------------------------------------------|--------------------------------------------|------------------------------------------------------|-----------------------------------------------|--------------------------|-------------|--------------|------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------|
|             |                        |                                                               |                        |                                           |                                            |                                                      |                                               | -20°F (-29°C)            | 75°F (24°C) | 150°F (66°C) | Size                                                                               |                                                                                                                            |                                                                                  |
|             |                        |                                                               |                        |                                           |                                            |                                                      |                                               |                          |             |              |                                                                                    |                                                                                                                            |                                                                                  |
|             | DP8005 (Black)         | Bonds polyolefins and l w surface energy materials            | 10:1                   | 25,000                                    | 3 minutes                                  | 3 hours                                              | N/A                                           | 875 (6)                  | 2,000 (14)  | 475 (3)      | 45mL<br>490mL                                                                      | 00-051128-99352-1<br>00-051128-99298-2                                                                                     | 7100089475<br>7100089476                                                         |
|             | DP8005 (Off White)     | Bonds polyolefins and l w surface energy materials            | 10:1                   | 25,000                                    | 3 minutes                                  | 3 hours                                              | N/A                                           | 750 (5)                  | 2,200 (15)  | 500 (3)      | 45mL<br>490mL                                                                      | 00-051128-99349-1<br>00-051128-99297-5                                                                                     | 7100088846<br>7100090196                                                         |
|             | DP8010 8010 (Blue)     | Bonds polyolefins and l w surface energy materials            | 10:1                   | 20,000                                    | 10 minutes                                 | 1 hour                                               | N/A                                           | 2,700 (19)               | 2,700 (19)  | 500 (3)      | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B | 00-051115-71600-3<br>00-051115-71601-0<br>00-021200-49113-9<br>00-051115-71669-0<br>00-021200-49115-3<br>00-076308-14203-2 | 7100036717<br>7100036719<br>7100050479<br>7100036720<br>7000046400<br>7100153259 |
|             | DP8010NS 8010NS (Blue) | Bonds polyolefins and l w surface energy materials<br>Non-sag | 10:1                   | 65,000                                    | 10 minutes                                 | 1 hour                                               | N/A                                           | 2,700 (19)               | 2,700 (19)  | 500 (3)      | 45mL<br>490mL<br>1 gal. pail A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B | 00-051115-81451-8<br>00-051115-81453-2<br>00-021200-49113-9<br>00-051115-81454-9<br>00-021200-49115-3<br>00-051115-81461-7 | 7100036721<br>7100036723<br>7100050479<br>7010329562<br>7000046400<br>7100113670 |

## 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 PL(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) |                                                                                       |                                                                                                                            |                                                                                  |         |
|   |                           |                                |                        |                                           |                                            |                                                      |                                              |                          |             |              |                                                                                       |                                                                                                                            |                                                                                  |         |
| * | 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<br>400mL<br>8.4 fl. oz.<br>5 gal. pail A<br>5 gal. pail B                      | 00-638060-08962-0<br>00-051111-98303-4<br>00-021200-96596-8<br>00-021200-96575-3<br>00-021200-96574-6                      | 7100148740<br>7000021287<br>7000046375<br>7010130543<br>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<br>400mL                                                                       | 00-638060-08964-4<br>00-051111-98312-6                                                                                     | 7100148747<br>7000046376                                                         |         |
|   | 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                                                                       |         |
|   | DP6310NS (Green)          | Multi-purpose Energy absorbing | 1:1                    | Non-sag paste                             | 9 minutes                                  | 45 minutes                                           | 20 (36)                                      | 3,500 (24)               | 3,600 (25)  | 900 (6)      | 48.5mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>50 gal. drum A<br>50 gal. drum B | 00-076308-86407-1<br>00-076308-86398-2<br>00-076308-86782-9<br>00-076308-86748-5<br>00-076308-86783-6<br>00-076308-86749-2 | 7100109829<br>7100109830<br>7100143960<br>7100143915<br>7010415316<br>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<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>50 gal. drum A<br>50 gal. drum B | 00-076308-86431-6<br>00-076308-86433-0<br>00-076308-86780-5<br>00-076308-86701-0<br>00-076308-86781-2<br>00-076308-86727-0 | 7100109828<br>7100109827<br>7100143961<br>7100143701<br>7010409611<br>7010366145 |         |
|   | 3532 B/A (Brown)          | Multi-purpose Semi-rigid bonds | 1:1                    | 30,000                                    | 10 minutes                                 | 90 minutes                                           | 25 (44)                                      | 2,500 (17)               | 2,000 (14)  | 300 (2)      | 2 oz. kit<br>Quart kit<br>5 gal. pail A<br>5 gal. pail B                              | 00-021200-20878-2<br>00-021200-20879-9<br>00-021200-20935-2<br>00-021200-20881-2                                           | 7000000863<br>7000046481<br>7010130544<br>7010170296                             |         |
|   | 3535 B/A (Off White)      | Multi-purpose Semi-rigid bonds | 1:1                    | 30,000                                    | 3 minutes                                  | 30 minutes                                           | 25 (44)                                      | 2,500 (17)               | 2,000 (14)  | 300 (2)      | 2 oz. kit<br>Quart kit<br>5 gal. pail A<br>5 gal. pail B                              | 00-021200-20887-4<br>00-021200-20888-1<br>00-051111-07486-2<br>00-051111-07485-5                                           | 7000046483<br>7010310199<br>7010366160<br>7010330223                             |         |

# 3M™ Scotch-Weld™ Flexible Urethanes

| 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 PU (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) |                                                                                       |                                                                                                                            |                                                                                  |
| * DP604NS 604NS (Black) | Flexible Non-sag              | 1:1                    | Paste                                | 4 minutes                                  | 20 minutes                                           | 30 (53)                                       | 1,400 (10)               | 600 (4)     | 300 (2)      | 48.5mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B | 00-638060-08961-3<br>00-051111-98301-0<br>00-021200-96462-6<br>00-021200-96461-9<br>00-076308-14205-6<br>00-076308-87087-4 | 7100148738<br>7100069452<br>7010365926<br>7010367265<br>7010329538<br>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<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B | 00-638060-08960-6<br>00-048011-57287-1<br>00-076308-14144-8<br>00-076308-14135-6<br>00-076308-14135-5<br>00-076308-14146-3 | 7100148737<br>7000046372<br>7010329537<br>7010367262<br>7010301034<br>7010309744 |
| 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<br>400mL                                                                       | 00-638060-08991-0<br>00-021200-89544-9                                                                                     | 7100148761<br>7010330225                                                         |
| 3549 (Brown)            | Tough flexible bonds          | 1:1                    | 25,000                               | 60 minutes                                 | 8 hours                                              | 60 (107)                                      | 3,000 (21)               | 2,000 (14)  | 400 (3)      | 2 oz. kit<br>Quart kit<br>5 gal. pail A<br>5 gal. pail B                              | 00-021200-20901-7<br>00-021200-20902-4<br>00-021200-20942-0<br>00-021200-20904-8                                           | 7000046484<br>7000046485<br>7100041738<br>7100041737                             |
| 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                                                                       |

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

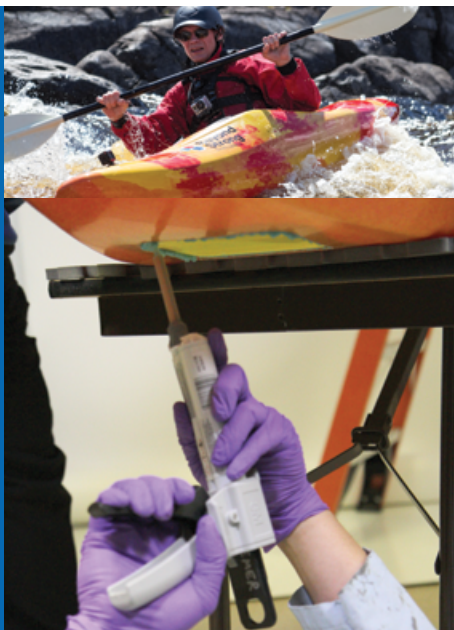
**KEY PRODUCT** Denotes product to consider first in this category

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## 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. **DP8010 Blue**



## 3M™ Scotch-Weld™ Concrete Repair Adhesives

3M's Concrete Repair Urethane Adhesives repair cracks and patch holes in minutes, providing minimal disruption to your operations. Products are available for both horizontal and vertical surfaces. **DP600**



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

| Product (Color)         | Key Features                                        | Viscosity@<br>250°F (121°C) (cp) | Approximate Open<br>Time at 75°F (24°C) | Approximate Time<br>to Handling Strength<br>at 75°F (24°C) | Shore D | Elongation % | Size                                | UPC                                                         | Stock #                                |
|-------------------------|-----------------------------------------------------|----------------------------------|-----------------------------------------|------------------------------------------------------------|---------|--------------|-------------------------------------|-------------------------------------------------------------|----------------------------------------|
| EZ250015<br>(Off-White) | Fast set time                                       | 7,000                            | 1.5 minutes                             | 15 seconds                                                 | 65      | 750          | 1/10 gal.<br>5 gal.                 | 00-051115-23545-0<br>00-051115-23546-7                      | 7000046529<br>7010310232               |
| EZ250060<br>(Off-White) | Medium set time                                     | 7,000                            | 2 minutes                               | 60 seconds                                                 | 60      | 675          | 1/10 gal.<br>5 gal.                 | 00-051115-23550-4<br>00-051115-23551-1                      | 7000046531<br>7010329734               |
| EZ250120<br>(Off-White) | Medium set time<br>Low viscosity<br>Thin bond lines | 3,000                            | 4 minutes                               | 120 seconds                                                | 60      | 625          | 1/10 gal.                           | 00-051115-23554-2                                           | 7000046532                             |
| TE015<br>(Off-White)    | Fast set time                                       | 7,000                            | 1.5 minutes                             | 15 seconds                                                 | 65      | 750          | 1/10 gal.<br>5 gal.                 | 00-051115-25156-6<br>00-021200-39211-5                      | 7000046472<br>7010367438               |
| TE030<br>(Off-White)    | Fast set time<br>High viscosity                     | 16,000                           | 1 minute                                | 30 seconds                                                 | 60      | 725          | 1/10 gal.<br>5 gal.<br>55 gal. drum | 00-051115-25157-3<br>00-021200-82484-5<br>00-021200-82483-8 | 7000046536<br>7010310236<br>7010367598 |
| * TE100<br>(Off-White)  | Medium set time<br>Thin bond lines                  | 7,000                            | 2 minutes                               | 60 seconds                                                 | 61      | 675          | 1/10 gal.<br>5 gal.                 | 00-051115-25161-0<br>00-021200-87244-0                      | 7000028590<br>7010295326               |
| TE200<br>(Off-White)    | Medium set time<br>Low viscosity<br>Thin bond lines | 3,000                            | 4 minutes                               | 120 seconds                                                | 60      | 625          | 1/10 gal.<br>2 kilo                 | 00-051115-25164-1<br>00-048011-53272-1                      | 7000000905<br>7000046540               |

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3M™ Scotch-Weld™  
PUR Easy 250  
Applicator

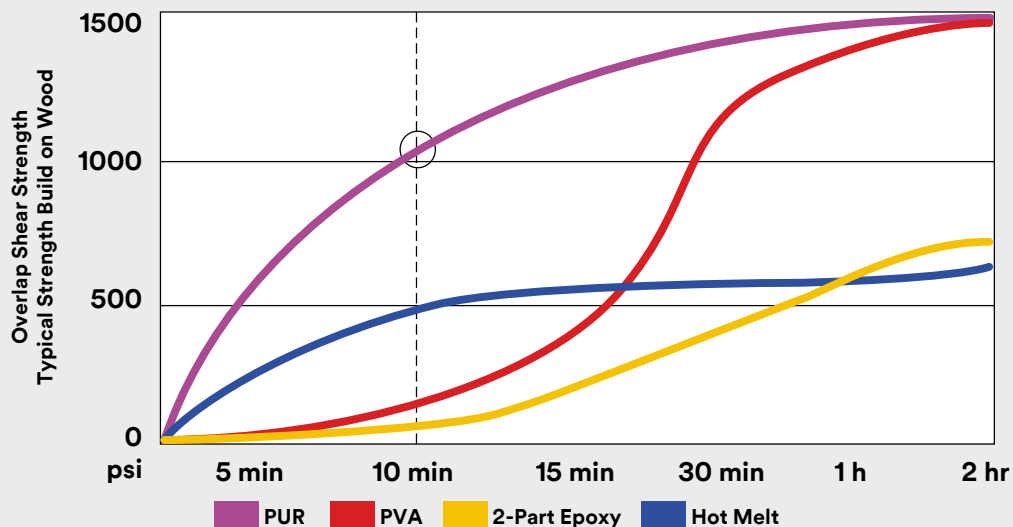


3M™ Scotch-Weld™  
PUR Easy 250  
Preheater



### 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 @ 250°F (12°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                                                          | 13,000                        | 2 minutes                          | 30 seconds                                         | 50      | 725          | 1/10 gal. 5 gal.                     | 00-051115-23541-2<br>00-051115-23542-9                                           | 7000046530<br>7000121357                             |
| EZ250150 (Off White)          | Long open time, bonds plastics to metal, glass, wood                                                     | 9,000                         | 4 minutes                          | 150 seconds                                        | 45      | 700          | 1/10 gal. 2 kilo 5 gal.              | 00-051115-23559-7<br>00-051115-23562-7<br>00-051115-23560-3                      | 7000046533<br>7010295325<br>7010367590               |
| EZ250200 (Off White)          | Long open time, low viscosity, bonds plastics, wood, and many other material combinations                | 2,750                         | 3 minutes                          | 120 seconds                                        | 30      | 400          | 1/10 gal. 2 kilo                     | 00-048011-57402-8<br>00-048011-57401-1                                           | 7000046538<br>7010367604                             |
| TE031 (Black)                 | Fast set time, bonds a wide variety of plastics                                                          | 13,000                        | 2 minutes                          | 30 seconds                                         | 50      | 725          | 1/10 gal. 5 gal.                     | 00-051115-25159-7<br>00-021200-89573-9                                           | 7000000903<br>7100031123                             |
| * TE031 (Off White)           | Fast set time, bonds a wide variety of plastics                                                          | 13,000                        | 2 minutes                          | 30 seconds                                         | 50      | 725          | 1/10 gal. 2 kilo 5 gal.              | 00-051115-25158-0<br>00-048011-53355-1<br>00-021200-83695-4                      | 7000000902<br>7000028589<br>7100096731               |
| TE040 (Black)                 | Fast set time, strong flexible bonds to plastic, wood, aluminum, glass                                   | 7,000                         | 2 minutes                          | 40 seconds                                         | 35      | 860          | 1/10 gal. 2 kilo 5 gal. 55 gal. drum | 00-051115-64536-5<br>00-051115-64430-6<br>00-638060-14494-7<br>00-638060-14321-6 | 7100003450<br>7000136669<br>7100172685<br>7100160468 |
| TE040 (Off White)             | Fast set time, strong flexible bonds to plastic, wood, aluminum, glass                                   | 7,000                         | 2 minutes                          | 41 seconds                                         | 35      | 860          | 1/10 gal. 5 gal. 55 gal. drum        | 00-051115-25160-3<br>00-021200-25343-0<br>00-638060-14498-5                      | 7000021292<br>7000136628<br>7100170133               |
| TS115 HGS (Off White)         | UV indicator Extrudable/sprayable/roll coatable with fast set time, bonds plastics to metal, glass, wood | 16,000                        | 10 minutes                         | 60 seconds                                         | 47      | 600          | 5 gal.                               | 00-051115-64535-8                                                                | 7010310234                                           |
| TS115 HGS (Off White)         | Extrudable/sprayable/roll coatable with fast set time, bonds plastics to metal, glass, wood              | 16,000                        | 10 minutes                         | 60 seconds                                         | 47      | 600          | 1/10 gal. 5 gal. 55 gal. drum        | 00-051115-25163-4<br>00-021200-89451-0<br>00-021200-89452-7                      | 7000000904<br>7010299377<br>7010367606               |
| TS230 (Black)                 | Extrudable/sprayable, long open time, bonds plastics to metal, glass, wood                               | 9,000                         | 4 minutes                          | 150 seconds                                        | 45      | 700          | 1/10 gal. 2 kilo 5 gal. 55 gal. drum | 00-051115-25166-5<br>00-048011-53273-8<br>00-021200-89583-8<br>00-638060-14675-0 | 7000000906<br>7000046541<br>7000121361<br>7100179521 |
| KEY PRODUCT TS230 (Off White) | Extrudable/sprayable long open time, bonds plastics to metal, glass, wood                                | 9,000                         | 4 minutes                          | 150 seconds                                        | 45      | 700          | 1/10 gal. 2 kilo 5 gal. 55 gal. drum | 00-051115-25165-8<br>00-048011-53271-4<br>00-021200-83640-4<br>00-021200-83639-8 | 7000000898<br>7000046534<br>7100024959<br>7100104259 |
| TS230 (Gray)                  | Extrudable/sprayable long open time, bonds plastics to metal, glass, wood                                | 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)<br>Hot Melt Applicator Foot Pedal Assembly 9277                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 00-021200-30086-8<br>00-021200-82278-0                                                                                                                                                                                                                                                                                  | 7000121614<br>7000121596                                                                                                                                                                                       |
| Cartridge Nozzle                             | High Temperature Nozzles for PUR 1/10 gal. cartridges (Sample, 5/bag)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                         | 7000031234                                                                                                                                                                                                     |
| Repair Kits and Replacement Parts            | Adhesive Applicator Housing/Shroud Assembly Kit<br>Applicator Nozzle Shroud<br>Benchmount Quick Exhaust Assembly Replacement Kit<br>Applicator Air Coupler Filter Kit<br>Applicator Air Supply Line Kit<br>Applicator Air Valve Kit<br>Applicator Swivel Connector<br>Applicator End Cap<br>Applicator Heat Tube Assembly (120V) Kit<br>Applicator Heat Tube (240V)<br>Applicator On/Off Switch Kit<br>Applicator Power Cord Kit (120V)<br>Applicator Wire Stand<br>High Temperature (250 Degrees F) PUR Preheater Thermostat/TCO Kit<br>Low Temperature (170 Degrees F) PUR Preheater Thermostat/TCO Kit | 00-051115-25783-4<br>00-048011-58320-4<br>00-021200-31357-8<br>00-021200-89475-6<br>00-021200-89479-4<br>00-048011-57410-3<br>00-048011-58298-6<br>00-021200-89476-3<br>00-021200-89486-2<br>00-021200-25303-4<br>00-021200-89482-4<br>00-021200-89481-7<br>00-021200-89483-1<br>00-051115-23619-8<br>00-051115-23618-1 | 7000028623<br>7000148288<br>7010366711<br>7000046665<br>7000046668<br>7000046652<br>7000046653<br>7000046666<br>7010329969<br>7000046673<br>7100079509<br>7010366708<br>7010329970<br>7010329954<br>7010366686 |

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

| Product                                                        | Description                                                                                                                                                                                                                                                            | UPC                                                                                                                                             | Stock #                                                                                        |
|----------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------|
| Alternate Nozzle System<br>not for use with disposable nozzles | Applicator Main Nozzle Assembly (includes nozzle, tip, tip cap and valve)<br>Applicator Main Nozzle<br>Applicator Extension Tip, .072 in orific<br>Applicator Tip, .125 in orific<br>Applicator Tip, .063 in orific<br>Applicator Tip Cap<br>Applicator Valve Assembly | 00-021200-89514-2<br>00-021200-89515-9<br>00-021200-89471-8<br>00-021200-89473-2<br>00-021200-89472-5<br>00-021200-87194-8<br>00-021200-83730-2 | 7000027561<br>7000046672<br>7000046669<br>7000046671<br>7000046670<br>7100005819<br>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 fillin                | Gel                    | -65° to 180°F (-54° to 82°C) | 20-60 sec.       | 24                | 20 gram tube<br>300 gram cart                                                | 00-051115-25265-5<br>00-051115-25282-2                                           | 7100039255<br>7100039257                             |
| PR40 (Clear)    | Low viscosity for close fittin plastic/rubber parts        | 40                     | -65° to 180°F (-54° to 82°C) | 3-20 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) | 10-20 sec.       | 24                | 20 gram bottle<br>500 gram bottle<br>500 gram bottle, 25/CV<br>2 kilo bottle | 00-051115-25214-3<br>00-051115-25213-6<br>00-051115-25939-5<br>00-051111-07176-2 | 7100039259<br>7100039200<br>7010330473<br>7100135507 |
| PR600 (Clear)   | Medium viscosity with some gap filling for plastic/rubbers | 600                    | -65° to 180°F (-54° to 82°C) | 4-40 sec.        | 24                | 50 gram bottle<br>500 gram bottle                                            | 00-051115-25241-9<br>00-051115-25240-2                                           | 7100039244<br>7100039246                             |
| PR1500 (Clear)  | General purpose, high viscosity for gap fillin             | 1,500                  | -65° to 180°F (-54° to 82°C) | 20-60 sec.       | 24                | 20 gram bottle<br>500 gram bottle<br>500 gram bottle, 25/CV                  | 00-051115-25222-8<br>00-051115-25221-1<br>00-076308-14147-9                      | 7100039201<br>7100039203<br>7010366528               |

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

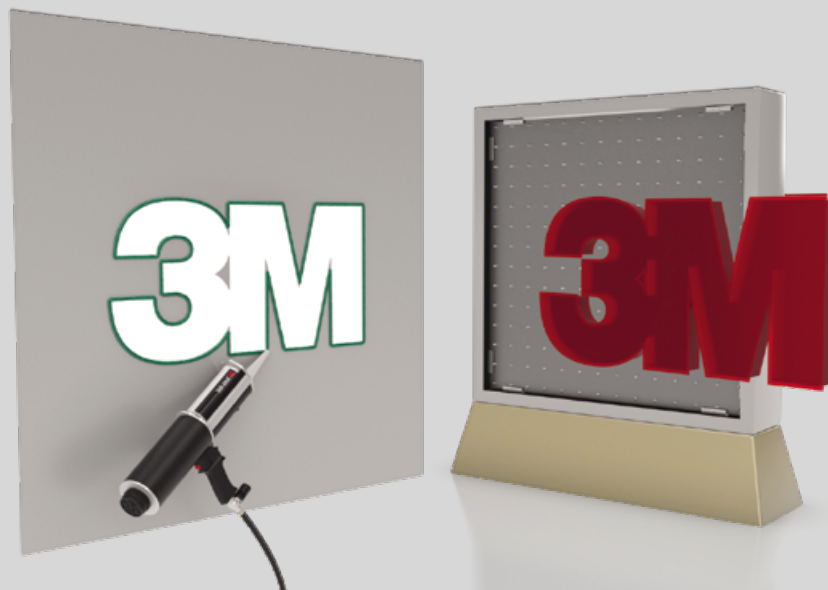
|                |                                             |       |                              |            |    |                                   |                                        |                          |
|----------------|---------------------------------------------|-------|------------------------------|------------|----|-----------------------------------|----------------------------------------|--------------------------|
| SI Gel (Clear) | Fast cure, gel viscosity for max gap fillin | Gel   | -65° to 180°F (-54° to 82°C) | 20-60 sec. | 24 | 20 gram tube<br>300 gram cart.    | 00-051115-25266-2<br>00-051115-25284-6 | 7100039258<br>7010330472 |
| SI100 (Clear)  | Low viscosity for medium gaps               | 100   | -65° to 180°F (-54° to 82°C) | 3-20 sec.  | 24 | 3 gram tube<br>20 gram bottle     | 00-051115-25290-7<br>00-051115-25268-6 | 7100039241<br>7100039240 |
| SI1500 (Clear) | High viscosity for gap fillin               | 1,500 | -65° to 180°F (-54° to 82°C) | 5-60 sec.  | 24 | 50 gram bottle<br>500 gram bottle | 00-048011-61662-9<br>00-051115-25245-7 | 7010330477<br>7100039243 |

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

|                |                                                                                               |       |                              |           |    |                                   |                                        |                          |
|----------------|-----------------------------------------------------------------------------------------------|-------|------------------------------|-----------|----|-----------------------------------|----------------------------------------|--------------------------|
| LO1000 (Clear) | General purpose, high viscosity with reduced odor and blooming, suitable for minor gap fillin | 1,000 | -65° to 180°F (-54° to 82°C) | 20-25 sec | 24 | 20 gram bottle<br>500 gram bottle | 00-051111-91664-3<br>00-048011-62738-0 | 7100039269<br>7100039250 |
|----------------|-----------------------------------------------------------------------------------------------|-------|------------------------------|-----------|----|-----------------------------------|----------------------------------------|--------------------------|

### 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. DP8805NS, DP8810NS, DP8825NS, DP8405NS, DP8407NS, DP8410NS and DP8425NS



## 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<br>Optimum performance on wide range of rubbers and plastics | 20                     | -65° to 180°F (-54° to 82°C) | 4-30 sec.        | 24                | 20 gram bottle<br>500 gram bottle                | 00-051111-91667-4<br>00-051115-25790-2                      | 7100049744<br>7100039254               |
| SF100 (Clear)   | Fast cure, high strength with EPDM and other elastomers                | 100                    | -65° to 180°F (-54° to 82°C) | 4-30 sec.        | 24                | 3 gram tube<br>20 gram bottle<br>500 gram bottle | 00-048011-62630-7<br>00-048011-62631-4<br>00-048011-62629-1 | 7100039207<br>7100039206<br>7100039208 |

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

|                 |                                                                               |       |                              |        |    |                                   |                                        |                          |
|-----------------|-------------------------------------------------------------------------------|-------|------------------------------|--------|----|-----------------------------------|----------------------------------------|--------------------------|
| RT5000B (Black) | Rubber toughened for impact resistance<br>High viscosity for minor gap fillin | 5,000 | -65° to 180°F (-54° to 82°C) | 30 sec | 24 | 20 gram bottle<br>500 gram bottle | 00-051111-91665-0<br>00-051115-25200-6 | 7100039251<br>7100039252 |
|-----------------|-------------------------------------------------------------------------------|-------|------------------------------|--------|----|-----------------------------------|----------------------------------------|--------------------------|

## 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<br>1 oz. bottle<br>1 lb. bottle | 00-021200-96601-9<br>00-021200-96600-2<br>00-021200-96597-5 | 7010366320<br>7000028586<br>7000028587 |
| CA5      | Higher viscosity, slower setting version of CA4 for filling gap<br>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<br>1 lb. bottle                | 00-021200-74289-7<br>00-021200-74288-0                      | 7000046524<br>7010367474               |
| CA7      | Very fast setting<br>Excellent metal bonder<br>Better shock and impact resistance                                          | 15-40         | -65° to 212°F (-54° to 100°C) | 1-30 sec.   | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-21061-7<br>00-021200-21062-4                      | 7000121352<br>7000121353               |
| CA8      | Rapid setting<br>Excellent adhesion to metals, plastics and rubbers<br>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<br>1 oz. bottle<br>1 lb. bottle | 00-021200-21065-5<br>00-021200-21066-2<br>00-021200-21067-9 | 7000121354<br>7000046526<br>7000046527 |
| CA9      | Slower setting for parts alignment<br>Useful for wire tracking and coil terminating<br>Meets CID A-A3097, Type II, Class 3 | 1,000-1,700   | -65° to 180°F (-54° to 82°C)  | 20-70 sec.  | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-21068-6<br>00-021200-21069-3                      | 7000046528<br>7010299373               |
| CA40     | Very fast setting<br>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<br>1 lb. bottle                | 00-021200-74290-3<br>00-021200-74291-0                      | 7000000893<br>7000000894               |
| CA40H    | Higher viscosity version of CA40<br>Better void filling capabilities                                                       | 400-600       | -65° to 212°F (-54° to 100°C) | 5-40 sec.   | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-21073-0<br>00-021200-21074-7                      | 7000000895<br>7000000896               |
| CA50 Gel | High-viscosity, non-sag gel<br>Less sensitive to acidic surfaces                                                           | 45,000-85,000 | -65° to 212°F (-54° to 100°C) | 60-120 sec. | 24 | 20 gram tube<br>200 gram cart.              | 00-021200-82332-9<br>00-021200-83737-1                      | 7100002517<br>7000000899               |
| CA100    | High peel and impact strength<br>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<br>1 lb. bottle                | 00-021200-82334-3<br>00-021200-82335-0                      | 7000000900<br>7000000901               |

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

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

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

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

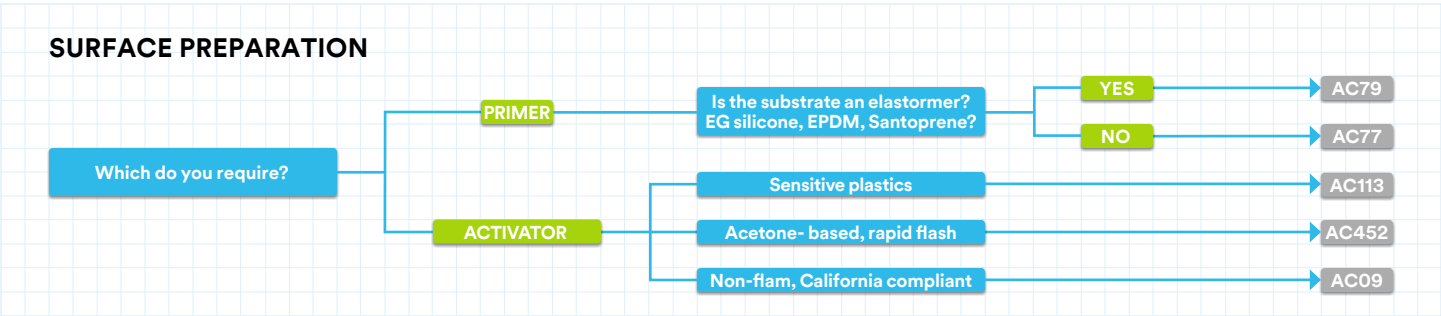
# 3M™ Scotch-Weld™ Instant Adhesive Primers & Activators

| Product (Color)   | Key Features                                                                                                                    | Typical Viscosity (cP) | Time to Handling | Full Cure (Hours) | Size                                                | UPC                                                         | Stock #                                |
|-------------------|---------------------------------------------------------------------------------------------------------------------------------|------------------------|------------------|-------------------|-----------------------------------------------------|-------------------------------------------------------------|----------------------------------------|
| AC09              | Instant adhesive activator<br>Non-flammable, solvent-based<br>California compliant                                              | 1                      | 1-5 sec.         | 24                | 2 fl. oz. bottle                                    | 00-051111-07795-5                                           | 7010366543                             |
| 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<br>1 gallon can                    | 00-048011-62728-1<br>00-638060-40067-8                      | 7100039260<br>7100190206               |
| AC79              | Instant adhesive primer for bonding of difficult-to-bond elastomers such as silicone, fluoroelastomer and EPDM<br>VOC compliant | 2                      | 1-5 sec.         | 24                | 2 fl. oz. bottle<br>8 fl. oz. bottle<br>4 liter can | 00-051115-31388-2<br>00-051115-31389-9<br>00-051115-31390-5 | 7100039262<br>7100039264<br>7100039265 |
| AC113             | Instant adhesive general purpose accelerator<br>Will not attack plastics                                                        | <3                     | 1-5 sec.         | 24                | 8 fl. oz. bottle                                    | 00-048011-62682-6                                           | 7100079891                             |
| AC452             | Instant adhesive acetone-based accelerator<br>flashes off rapidly<br>Excellent adhesion<br>Overspray may attack some plastics   | <2                     | 1-5 sec.         | 24                | 8 fl. oz. bottle<br>4 liter can                     | 00-048011-62686-4<br>00-048011-62689-5                      | 7010295349<br>7010366542               |
| Surface Activator | Clear, colorless organic-based liquid helps speed curing and prime surfaces<br>Comes with brush and spray pump                  | <10                    | 1-5 sec.         | 24                | 2 fl. oz. bottle                                    | 00-021200-87937-1                                           | 7000046525                             |

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**KEY PRODUCT** Denotes product to consider first in this category      \* After Key Products, consider these.

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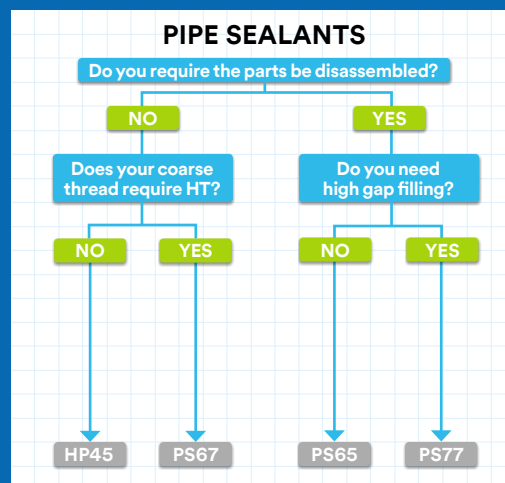
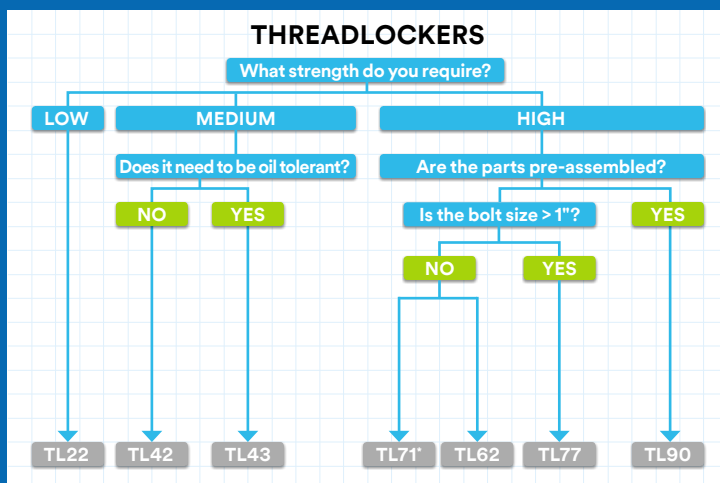


## 3M™ Scotch-Weld™ Anaerobic Adhesives – Threadlockers

| 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                | 10mL bottle<br>50mL bottle<br>250mL bottle                                  | 00-048011-62601-7<br>00-048011-62602-4<br>00-048011-62603-1                                           | 7100039217<br>7100039159<br>7010367446                             |
| TL42 (Blue)     | Nutlock - medium strength, general purpose                                           | 1,200                  | -65° to 300°F (-54° to 149°C) | < 30 minutes     | 24                | 1mL pipette<br>10mL bottle<br>50mL bottle<br>250mL bottle<br>1 liter bottle | 00-048011-62604-8<br>00-048011-62605-5<br>00-048011-62606-2<br>00-048011-62607-9<br>00-051115-25124-5 | 7100064043<br>7100039190<br>7100039193<br>7100039192<br>7010310189 |
| TL43 (Blue)     | Oil tolerant, medium strength, general purpose                                       | 3,300                  | -65° to 300°F (-54° to 149°C) | < 30 minutes     | 24                | 10mL bottle<br>50mL bottle<br>250mL bottle                                  | 00-051115-25138-2<br>00-051115-25139-9<br>00-051115-25140-5                                           | 7100039219<br>7100039222<br>7100039221                             |
| TL62 (Red)      | Studlock - high strength with controlled torque tension                              | 1,600                  | -65° to 300°F (-54° to 149°C) | < 30 minutes     | 24                | 10mL bottle<br>50mL bottle<br>250mL bottle                                  | 00-048011-62609-3<br>00-048011-62610-9<br>00-048011-62611-6                                           | 7100039194<br>7100039196<br>7100039195                             |
| TL71 (Red)      | Permanent studlock for bolts and studs up to 1" (25mm)                               | 500                    | -65° to 300°F (-54° to 149°C) | < 30 minutes     | 24                | 1mL pipette<br>10mL bottle<br>50mL bottle<br>250mL bottle                   | 00-051115-25125-2<br>00-048011-62612-3<br>00-048011-62613-0<br>00-048011-62614-7                      | 7010330204<br>7100039197<br>7100039231<br>7100039230               |
| TL72 (Red)      | High temperature studlock with gap filling for larger diameter coarse threaded parts | 7,000                  | -65° to 450°F (-54° to 232°C) | < 30 minutes     | 24                | 50mL bottle                                                                 | 00-051115-25137-5                                                                                     | 7100101211                                                         |
| TL77 (Red)      | Heavy duty permanent for fasteners up to 1.5" (38mm) with coarse threads             | 7,000                  | -65° to 300°F (-54° to 149°C) | < 30 minutes     | 24                | 50mL bottle<br>250mL bottle                                                 | 00-051115-25143-6<br>00-051115-25144-3                                                                | 7100039225<br>7100039224                                           |
| 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<br>50mL bottle<br>250mL bottle                                  | 00-048011-62615-4<br>00-048011-62616-1<br>00-048011-62617-8                                           | 7100039234<br>7100039236<br>7100039235                             |

## 3M™ Scotch-Weld™ Anaerobic Adhesives – Pipe Sealants

|               |                                                                        |        |                               |              |    |                             |                                        |                          |
|---------------|------------------------------------------------------------------------|--------|-------------------------------|--------------|----|-----------------------------|----------------------------------------|--------------------------|
| HP45 (Purple) | High pressure sealant for all hydraulic and pneumatic fitting          | 14,000 | -65° to 300°F (-54° to 149°C) | < 30 minutes | 24 | 50mL bottle<br>250mL bottle | 00-048011-62721-2<br>00-048011-62722-9 | 7100039213<br>7100039212 |
| PS65 (White)  | General purpose for applications requiring easy disassembly            | Paste  | -65° to 300°F (-54° to 149°C) | 2-5 hours    | 24 | 50mL tube<br>250mL tube     | 00-048011-62711-3<br>00-048011-62712-0 | 7100039238<br>7100039237 |
| PS67 (White)  | Fast curing pipe sealant for inactive surfaces such as stainless steel | Paste  | -65° to 400°F (-54° to 204°C) | 15-30 mins   | 24 | 50mL tube<br>250mL tube     | 00-048011-62714-4<br>00-048011-62715-1 | 7100039216<br>7100039215 |
| PS77 (Yellow) | Fast curing pipe sealant with medium-high viscosity                    | 18,000 | -65° to 400°F (-54° to 204°C) | 15-30 mins   | 24 | 50mL tube                   | 00-054007-99635-4                      | 7010366168               |



\*For permanent attachment.

## 3M™ Scotch-Weld™ Anaerobic Adhesives – Retaining Compounds

| Product (Color) | Key Features                                                                           | Typical Viscosity (cP) | Temperature Range             | Time to Handling | Full Cure (Hours) | Size                                       | UPC                                                         | Stock #                                |
|-----------------|----------------------------------------------------------------------------------------|------------------------|-------------------------------|------------------|-------------------|--------------------------------------------|-------------------------------------------------------------|----------------------------------------|
| RT09 (Green)    | For tight tolerances and press fit augmentation                                        | 125                    | -65° to 300°F (-54° to 149°C) | 10-30 mins       | 24                | 10mL bottle<br>50mL bottle<br>250mL bottle | 00-048011-62661-1<br>00-048011-62662-8<br>00-048011-62663-5 | 7100039228<br>7100039209<br>7010367430 |
| RT38 (Green)    | Fast setting, high strength for bearings, bushings or sleeves on shafts or in housings | 2,500                  | -65° to 300°F (-54° to 149°C) | 10-15 mins       | 24                | 250mL bottle                               | 00-051115-81284-2                                           | 7010367436                             |
| RT48            | Medium viscosity, high strength, fast curing formulation                               | 600                    | -65° to 300°F (-54° to 149°C) | 15-20 mins       | 24                | 50mL bottle<br>250mL bottle                | 00-054007-99632-3<br>00-054007-99633-0                      | 7010367443<br>7100170130               |

## 3M™ Scotch-Weld™ Anaerobic Adhesives – Gasket Makers

|               |                                                                                                            |       |                               |              |    |                             |                                        |                          |
|---------------|------------------------------------------------------------------------------------------------------------|-------|-------------------------------|--------------|----|-----------------------------|----------------------------------------|--------------------------|
| GM10 (Red)    | Masking or dressing gaskets in rigid assemblies<br>Can be screen printed<br>High temperature resistance    | Paste | -65° to 400°F (-54° to 204°C) | < 30 minutes | 24 | 50mL tube                   | 00-048011-62652-9                      | 7100039210               |
| GM18 (Red)    | Instant flexible seal without a primer on mating aluminum flange                                           | Paste | -65° to 300°F (-54° to 149°C) | < 30 minutes | 24 | 300 gram cart.<br>50mL tube | 00-048011-62660-4<br>00-048011-62658-1 | 7010367433<br>7100039211 |
| GM74 (Orange) | Form-in-place gasketing product designed for multi-purpose applications on rigid metal flanges and surface | Paste | -65° to 300°F (-54° to 149°C) | < 30 minutes | 24 | 50mL bottle,<br>10/CV       | 00-054007-99634-7                      | 7010330193               |

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

|               |                                                                                                                               |    |     |            |    |                                      |                                        |                          |
|---------------|-------------------------------------------------------------------------------------------------------------------------------|----|-----|------------|----|--------------------------------------|----------------------------------------|--------------------------|
| AC649 (Green) | Acetone-based green primer for inactive or very cold surfaces<br>30-day part life for pre-application<br>California compliant | <3 | N/A | <5 minutes | 24 | 2 fl. oz. bottle<br>8 fl. oz. bottle | 00-048011-62708-3<br>00-048011-62709-0 | 7100075275<br>7010367620 |
|---------------|-------------------------------------------------------------------------------------------------------------------------------|----|-----|------------|----|--------------------------------------|----------------------------------------|--------------------------|

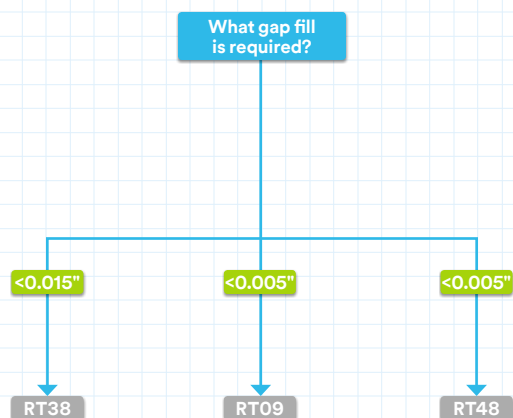
For lead times on bulk adhesives, please contact your 3M representative.

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

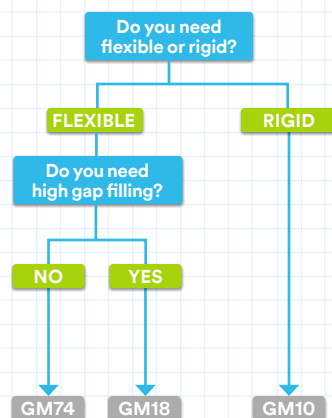
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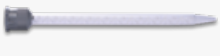
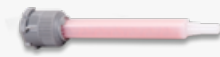
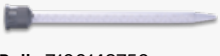
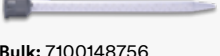
### RETAINING COMPOUNDS



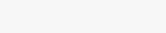
### GASKET MAKERS



# 3M™ EPX™ Applicators and Nozzles

|                                                                                                                                                                                                                                     |                                                                                                                                          | Replacement<br>Plunger Orders |              |               |             |                    |                    |     | Nozzle Length (Inches)                                                                                                                                       |                                                                                                                                                                | Static Mixing<br>Nozzle Options                                                       |                                                                |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|--------------|---------------|-------------|--------------------|--------------------|-----|--------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------------------------------------------|
|                                                                                                                                                                                                                                     |                                                                                                                                          | 43 mL (2:3)                   | 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) |     |                                                                                                                                                              |                                                                                                                                                                |                                                                                       |                                                                |
| <div>3M™<br/>Scotch-Weld™<br/>EPX™ Plus II<br/>Applicator*</div> <div>Stock #:<br/>7100148764</div> <div>UPC:<br/>00-063806-01001-7</div>          | <div>1:1/2:1<br/>Shared Plunger</div> <div>Stock #:<br/>7010415317</div> <div>UPC:<br/>00-063806-01000-0</div>                           |                               | ✓            | ✓             |             |                    |                    | 3.6 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Square Green, 48.5mL/50mL</div> <div>Stock #: 7100104991</div> <div>UPC: 0-00-76308-86434-7</div>    |                                                                             | <div>Bulk: 7100148765</div> <div>Bulk: 0-00-63806-01003-1</div>                       |                                                                |
|                                                                                                                                                                                                                                     |                                                                                                                                          |                               | ✓            | ✓             |             |                    |                    | 6.2 | <div>3M™ EPX™ Mixing Nozzle</div> <div>Helical White, 48.5mL/50mL</div> <div>Stock #: 7100148766</div> <div>UPC: 00-063806-01004-8</div>                     |                                                                             | <div>Bulk: 7100148756</div> <div>Bulk: 00-063806-01005-5</div>                        |                                                                |
|                                                                                                                                                                                                                                     | <div>2:1 Plunger</div> <div>Used only for<br/>2216 epoxy</div> <div>Stock #:<br/>7010309947</div> <div>UPC:<br/>0-00-76308-86390-6</div> | ✓                             |              |               |             |                    |                    | 3.3 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Square Gold, 43mL</div> <div>Stock #: 7000000952</div> <div>UPC: 0-00-21200-50008-4</div>            |                                                                             | <div>Bulk: 7000121587</div> <div>Bulk: 0-00-21200-50009-1</div>                       |                                                                |
|                                                                                                                                                                                                                                     |                                                                                                                                          |                               |              |               |             |                    |                    | 5.8 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Helical White, 43mL</div> <div>Stock #: 7100034271</div> <div>UPC: 0-00-51115-81449-0</div>          |                                                                             | <div>Bulk: 7100034272</div> <div>Bulk: 0-00-51115-81467-9</div>                       |                                                                |
|                                                                                                                                                                                                                                     | <div>10:1 Plunger</div> <div>Stock #:<br/>7010329933</div> <div>UPC:<br/>0-00-76308-86391-3</div>                                        |                               | ✓            |               |             |                    |                    | 3.6 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Square Orange, 45mL</div> <div>Stock #: 7100007806</div> <div>UPC: 0-00-51115-69043-3</div>          |                                                                             |                                                                                       |                                                                |
| *Includes 1:1, 2:1 and 10:1 plunger.                                                                                                                                                                                                |                                                                                                                                          |                               |              |               |             |                    |                    |     |                                                                                                                                                              |                                                                                                                                                                |                                                                                       |                                                                |
| <div>3M™ EPX™<br/>Metal<br/>Applicator</div> <div>Stock #:<br/>7000000954</div> <div>UPC:<br/>0-00-21200-21789-0</div>                           | <div>2:1 Plunger</div> <div>Stock #:<br/>7000000956</div> <div>UPC:<br/>0-00-21200-82314-5</div>                                         | ✓                             |              |               |             |                    |                    | 3.3 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Square Gold, 43mL</div> <div>Stock #: 7000000952</div> <div>UPC: 0-00-21200-50008-4</div>            |                                                                            | <div>Bulk: 7000121587</div> <div>Bulk: 0-00-21200-50009-1</div>                       |                                                                |
|                                                                                                                                                                                                                                     |                                                                                                                                          |                               |              |               |             |                    |                    | 5.8 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Helical White, 43mL</div> <div>Stock #: 7100034271</div> <div>UPC: 0-00-51115-81449-5</div>          |                                                                           | <div>Bulk: 7100034272</div> <div>Bulk: 0-00-51115-81467-9</div>                       |                                                                |
|                                                                                                                                                                                                                                     |                                                                                                                                          |                               |              | ✓             |             |                    |                    | 3.6 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Square Green, 43mL/48.5mL</div> <div>Stock #: 7100104991</div> <div>UPC: 0-00-76308-86434-7</div>    |                                                                           | <div>Bulk: 7100148765</div> <div>Bulk: 0-00-63806-01003-1</div>                       |                                                                |
|                                                                                                                                                                                                                                     |                                                                                                                                          |                               |              | ✓             |             |                    |                    | 6.2 | <div>3M™ EPX™ Mixing Nozzle</div> <div>Helical White, 48.5mL/50mL</div> <div>Stock #: 7100148766</div> <div>UPC: 00-063806-01004-8</div>                     |                                                                           | <div>Bulk: 7100148756</div> <div>Bulk: 00-063806-01005-5</div>                        |                                                                |
| <div>3M™ EPX™<br/>Pneumatic<br/>Applicator<br/>48.5/50 mL</div> <div>Stock #:<br/>7100148769</div> <div>UPC:<br/>00-063806-01006-2</div>         | N/A                                                                                                                                      |                               |              | ✓             | ✓           |                    |                    | 3.6 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Square Green, 43mL/48.5mL</div> <div>Stock #: 7100104991</div> <div>UPC: 0-00-76308-86434-7</div>    |                                                                           | <div>Bulk: 7100148765</div> <div>Bulk: 0-00-63806-01003-1</div>                       |                                                                |
|                                                                                                                                                                                                                                     |                                                                                                                                          |                               |              |               | ✓           | ✓                  |                    |     | 6.2                                                                                                                                                          | <div>3M™ EPX™ Mixing Nozzle</div> <div>Helical White, 48.5mL/50mL</div> <div>Stock #: 7100148766</div> <div>UPC: 00-063806-01004-8</div>                       |  | <div>Bulk: 7100148756</div> <div>Bulk: 00-063806-01005-5</div> |
| <div>3M™ Scotch-Weld™ EPX™<br/>Manual<br/>Applicator<br/>200 mL</div> <div>Stock #:<br/>7000046632</div> <div>UPC:<br/>0-00-21200-87977-7</div>  | <div>1:1/2:1 Shared<br/>Plunger</div> <div>Stock #:<br/>7000121583</div> <div>UPC:<br/>0-00-21200-87981-4</div>                          |                               |              |               |             | ✓                  | ✓                  | 5.0 | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Square Gold, 200mL and 400mL</div> <div>Stock #: 7000028616</div> <div>UPC: 0-00-21200-97331-4</div> |                                                                           |                                                                                       |                                                                |
|                                                                                                                                                                                                                                     |                                                                                                                                          |                               |              |               |             |                    |                    |     | 7.5                                                                                                                                                          | <div>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</div> <div>Helical White, 200mL and 400mL</div> <div>Stock #: 7000046633</div> <div>UPC: 0-00-21200-87982-1</div> |  |                                                                |

## 3M™ EPX™ Applicators and Nozzles

|                                                                                                                                      |                                                                                     | Replacement<br>Plunger Orders | 37 mL (2:1) & 43 mL (2:3) |                                                      | 45 mL (10:1) | 50 mL (1:1) | 200 mL (2:1 & 1:1) | 400 mL (2:1 & 1:1) | Nozzle Length (Inches) | Static Mixing<br>Nozzle Options |                                                                                                                                     |                                                                                       |
|--------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------|---------------------------|------------------------------------------------------|--------------|-------------|--------------------|--------------------|------------------------|---------------------------------|-------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| <b>3M™ EPX™<br/>200, 400 mL<br/>Manual<br/>Applicator</b><br><br>Stock #:<br>7000046634<br><br>UPC:<br>0-00-51111-98073-6            |    | N/A                           |                           |                                                      |              |             |                    |                    |                        | 5.0                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Square Gold, 200mL and 400mL<br>Stock #: 7000028616<br>UPC: 0-00-21200-97331-4    |    |
|                                                                                                                                      |                                                                                     |                               |                           |                                                      |              |             |                    |                    |                        | 7.5                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Helical White, 200mL and 400mL<br>Stock #: 7000046633<br>UPC: 0-00-21200-87982-1  |    |
| <b>3M™ EPX™<br/>490 mL<br/>Manual<br/>Applicator</b><br><br>Stock #:<br>7100015958<br><br>UPC:<br>0-00-51115-71115-2                 |    | N/A                           |                           |                                                      |              |             |                    |                    |                        | 9.5                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Helical Orange, 490mL<br>Stock #: 7100015959<br>UPC: 0-00-51115-69042-6           |    |
|                                                                                                                                      |                                                                                     |                               |                           |                                                      |              |             |                    |                    |                        | 4.4                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle, Low Waste</b><br>Square Green, 490mL<br>Stock #: 7100066351<br>UPC: 0-00-51115-81619-2  |    |
| <b>3M™ Scotch-Weld™ EPX™<br/>Pneumatic<br/>Applicator<br/>200 mL</b><br><br>Stock #:<br>7000121584<br><br>UPC:<br>0-00-21200-87978-4 |   | N/A                           |                           |                                                      |              |             |                    |                    |                        | 5.0                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Square Gold, 200mL and 400mL<br>Stock #: 7000028616<br>UPC: 0-00-21200-97331-4    |    |
|                                                                                                                                      |                                                                                     |                               |                           |                                                      |              |             |                    |                    |                        | 7.5                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Helical White, 200mL and 400mL<br>Stock #: 7000046633<br>UPC: 0-00-21200-87982-1  |  |
| <b>3M™ EPX™<br/>400 mL<br/>Pneumatic<br/>Applicator</b><br><br>Stock #:<br>7000148285<br><br>UPC:<br>0-00-21200-87979-1              |  | N/A                           |                           |                                                      |              |             |                    |                    |                        | 5.0                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Square Gold, 200mL and 400mL<br>Stock #: 7000028616<br>UPC: 0-00-21200-97331-4    |  |
|                                                                                                                                      |                                                                                     |                               |                           |                                                      |              |             |                    |                    |                        | 7.5                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Helical White, 200mL and 400mL<br>Stock #: 7000046633<br>UPC: 0-00-21200-87982-1  |  |
| <b>3M™ EPX™<br/>490 mL<br/>Pneumatic<br/>Applicator</b><br><br>Stock #:<br>7100011053<br><br>UPC:<br>0-00-51115-69041-9              |  | N/A                           |                           |                                                      |              |             |                    |                    |                        | 9.5                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle</b><br>Helical Orange, 490 mL<br>Stock #: 7100015959<br>UPC: 0-00-51115-69042-6          |  |
|                                                                                                                                      |                                                                                     |                               |                           |                                                      |              |             |                    |                    |                        | 4.4                             | <b>3M™ Scotch-Weld™ EPX™<br/>Mixing Nozzle, Low Waste</b><br>Square Green, 490 mL<br>Stock #: 7100066351<br>UPC: 0-00-51115-81619-2 |  |
| <b>Standard<br/>Caulk Gun</b>                                                                                                        |                                                                                     | N/A                           |                           | 3M™ Concrete<br>Repair Urethane<br>8.4 oz cartridges |              |             |                    |                    |                        | 5.5                             | <b>3M™ Concrete Repair 8.4 oz<br/>Cartridge Nozzles</b><br>Stock #: 7000046642<br>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.

Click these links to see how 3M™ Scotch-Weld™ Structural Adhesives show unbelievable feats of strength and how our customers solved their challenges. We Help You Make It. Better.

## 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.



#### Industrial Adhesives & Tapes Division

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