

# 3M™ Scotch-Weld™ Structural Adhesives

**3M** Scotch-Weld™  
Acrylic Low Odor  
Adhesive  
DP 8805 NS Green



## Product Selection Guide

Matching 3M Structural Adhesives  
to your performance requirements



## Improving Product and Process

In today's world, successful new products demand advancements in both design and manufacturing processes. 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 50 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.

### Advanced Product Designs and Process Innovations

The benefits of designing and building products with 3M Scotch-Weld Structural Adhesives help drive product success.

- **Freedom of Design:** Improve aesthetics, reduce weight and noise, enhance corrosion and fatigue resistance, and more.
- **Process Efficiencies:** Speed production with quiet, fast and easy manufacturing processes.
- **Low Odor Advantages:** Improve your environment with 3M's low odor structural adhesives.
- **Dispensing Options:** Dispense by hand or with automated equipment.

### 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.



## Simplifying adhesive decisions for your application

The following questions will help you narrow adhesive choices to two or three 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.

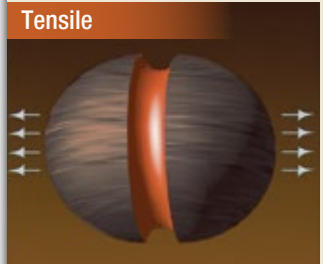
### Q: How are structural adhesives used and applied?

**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 dispense 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.



**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 Benefits:*

- Excellent impact resistance
- High strength for small joints
- Bonds rubber, composites and metals

*Lead Products:*

DP420NS Black, DP8810NS, PR100

## Specialty Vehicle

*Key Benefits:*

- Reduces weight
- High strength
- Vibration & fatigue resistant

*Lead Products:*

DP8810NS, LSB60NS, TL42



## Signage

*Key Benefits:*

- Bonds a variety of materials
- Weather resistant
- UL recognized

*Lead Products:*

DP8805NS, DP8405NS, DP100 Plus



## Metalworking

*Key Benefits:*

- High strength
- Reduces surface preparation
- Replaces mechanical fasteners

*Lead Products:*

DP420NS Black, DP8410NS, LSB60NS



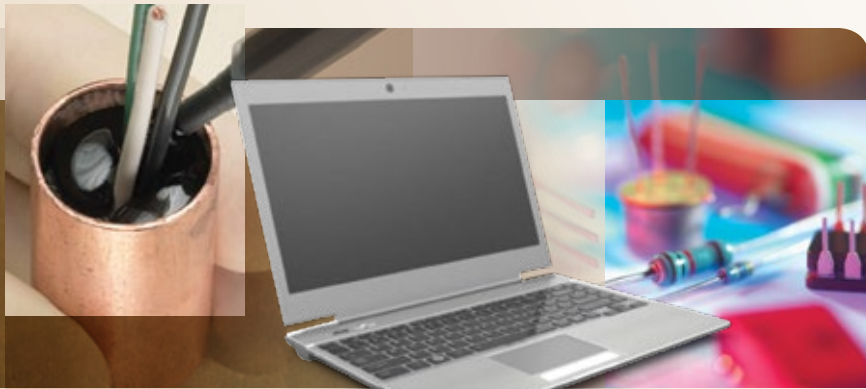
## Electronics

### Key Benefits:

- Low halogen
- Fast curing
- Potting

### Lead Products:

DP420LH, DP270, DP8805NS, PR100



## Appliance

### Key Benefits:

- Bonds powder coated materials
- Noise dampening
- Joins plastic and glass to metals

### Lead Products:

DP125 Gray, DP8810NS, TL42



## Aerospace

### Key Benefits:

- Flame, smoke and toxicity compliance
- UL94 V-0 rated formulation
- Strong, yet flexible formulations

### Lead Products:

2216 Gray, DP100FR, DP640



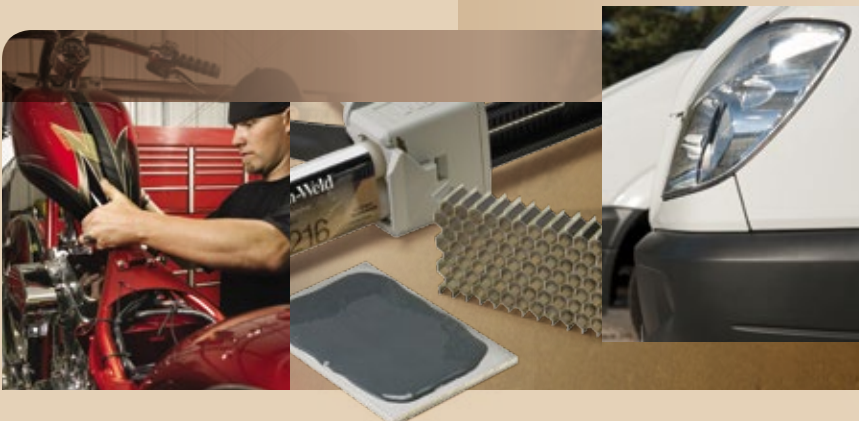
## Plastic, Composite & Rubber

### Key Benefits:

- Bonds low surface energy plastics without priming
- Impact resistant composite bonding

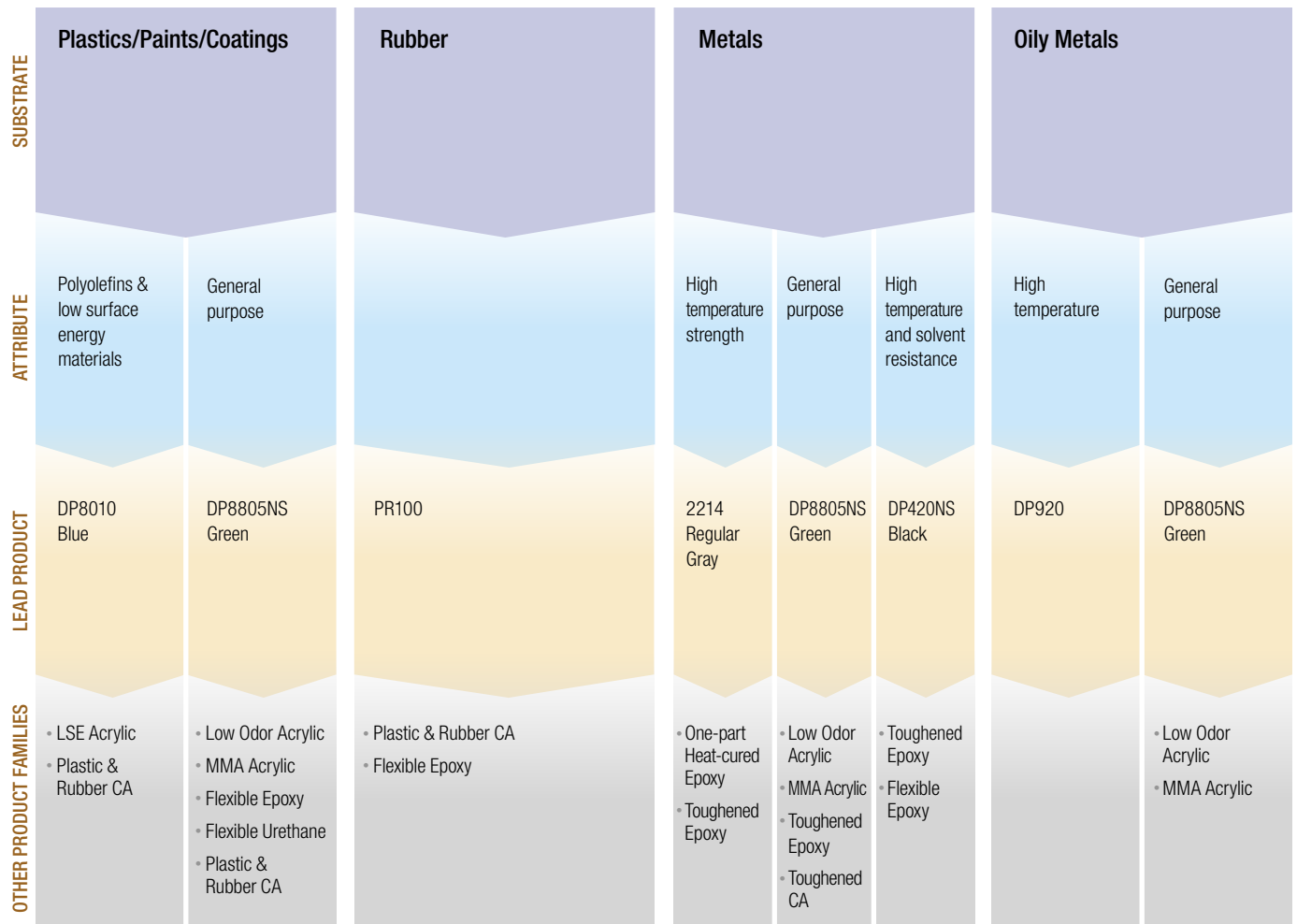
### Lead Products:

DP8010 Blue, DP420NS, PR100



# 3M™ Scotch-Weld™ Structural Adhesives Selector Guide

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



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

■ SUBSTRATE   ■ ATTRIBUTE   ■ LEAD PRODUCT   ■ OTHER PRODUCT FAMILIES

## STRUCTURAL ADHESIVE FAMILIES

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

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

**Toughened Epoxy Adhesives** have higher tensile strength at given elongations for greater fatigue resistance, best suited for dynamic stresses. Because of the toughness it imparts greater long-term holding power; higher peel strength; lower adhesion to most plastics; and significantly higher resistance against shock, vibration, and impact loads.

**One-part Heat-cured Epoxy Adhesives** are rigid adhesives that have outstanding strength when measured at elevated temperatures; these adhesives require a thermal cure, typically around 250-350°F (120-180°C) for 40-60 minutes, to achieve full strength.

**MMA Acrylic Adhesives** are based on methyl methacrylate (MMA) monomer, which provides greater adhesion to a wide variety of materials including most plastics and paint systems, and are tolerant of many surface contaminations. High impact resistance for metal bonds.

**Low Odor Acrylic Adhesives** are designed to improve the odor of typical MMA adhesives, featuring a much faster rate of strength build than most 2K structural adhesives. They provide excellent adhesion to a wide variety of materials, including many plastics and paint systems. They also provide high impact resistance for plastic bonds and are tolerant of many surface contaminations.

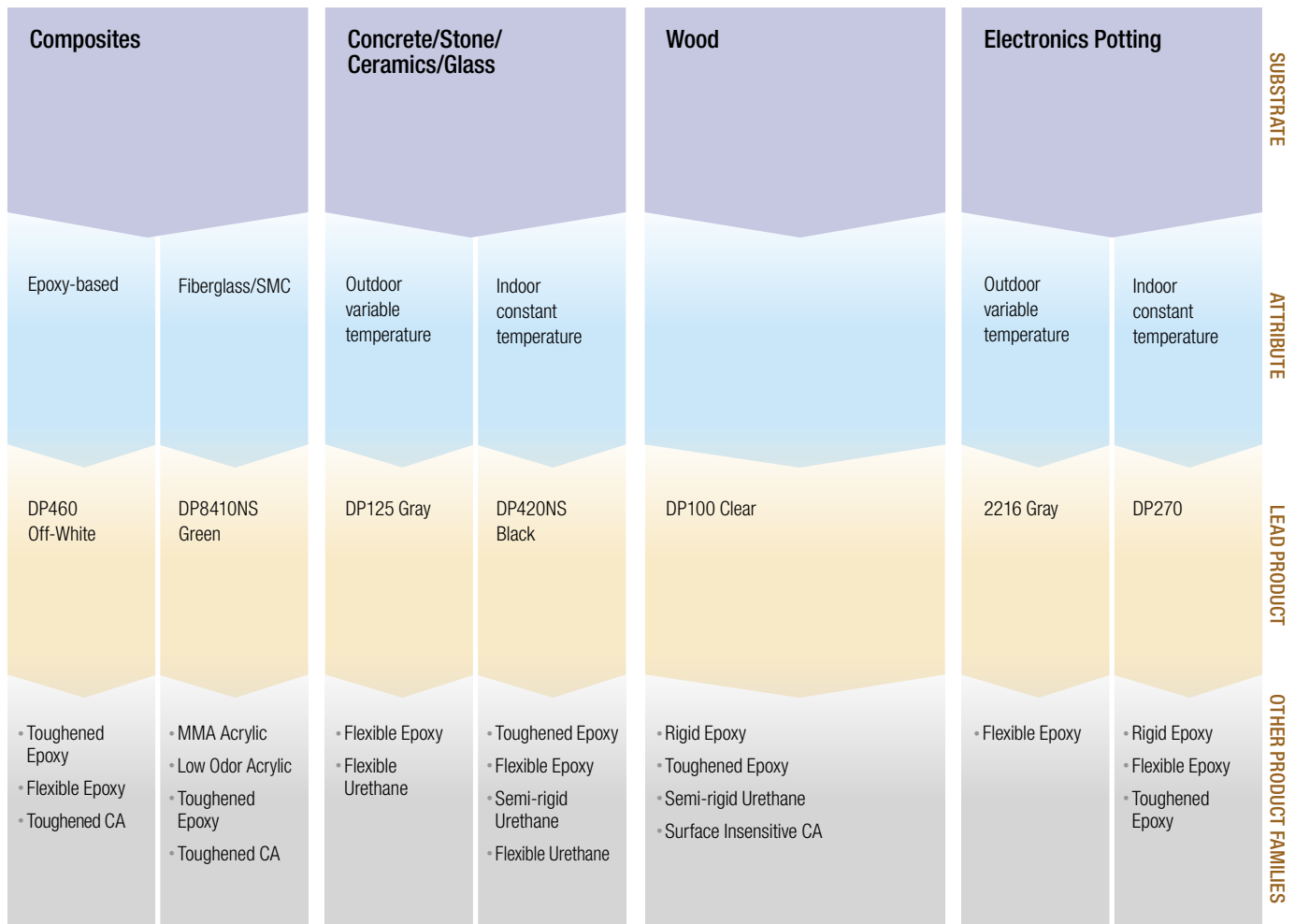
**LSE Acrylic Adhesives** are based on special monomers that provide outstanding adhesion to most TPOs (Thermoplastic Olefins) and "low surface energy" plastics, such as polypropylene and polyethylene, without surface treatment.

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

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

# 3M™ Scotch-Weld™ Structural Adhesives Selector Guide

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



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

■ SUBSTRATE   ■ ATTRIBUTE   ■ LEAD PRODUCT   ■ OTHER PRODUCT FAMILIES

## 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.

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

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

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

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

## 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.

# Substrate Selector

**Step 1: Select Both Substrates**

**Step 2: Determine Key Attribute**

**Step 3: Select Product Family**

(see charts in back of guide for lead product)

Plastic/Paints/Coatings		Rubber	Metals			Oily Metals		Composites		Concrete/Stone/Ceramics/Glass		Wood		
Low Surface Energy	General Purpose		Temperature and Solvent Resistant	General Purpose	High Temperature Strength	General Purpose	High Temperature Strength	Fiberglass/SMC	Epoxy	Indoor	Outdoor			
LSE Acrylic Plastic & Rubber CA	LSE Acrylic Plastic & Rubber CA	Plastic & Rubber CA*	N/A	LSE Acrylic	N/A	LSE Acrylic	N/A	LSE Acrylic	LSE Acrylic	LSE Acrylic Plastic & Rubber CA*	LSE Acrylic	LSE Acrylic Surface Insensitive CA*	Low Surface Energy	Plastic/Paints/Coatings
	LO Acrylic MMA Acrylic Flexible Epoxy Plastic & Rubber CA	Plastic & Rubber CA*	Toughened Epoxy Flexible Epoxy	LO Acrylic MMA Acrylic Flexible Epoxy Plastic & Rubber CA	Toughened Epoxy	LO Acrylic MMA Acrylic DP920	DP920	MMA Acrylic LO Acrylic Flexible Urethane Toughened CA	MMA Acrylic Flexible Epoxy Toughened Epoxy Toughened CA	Flexible Epoxy Semi-rigid Urethane Flexible Urethane	Flexible Epoxy Flexible Urethane	Flexible Epoxy Semi-rigid Urethane Surface Insensitive CA	General Purpose	
		Plastic & Rubber CA*	N/A	Plastic & Rubber CA*	N/A	N/A	N/A	Plastic & Rubber CA*	N/A	N/A	N/A	Surface Insensitive CA*		Rubber
			Toughened Epoxy Flexible Epoxy	Toughened Epoxy Flexible Epoxy	One-part Heat-cured Epoxy Toughened Epoxy	DP920 One-part Heat-cured Epoxy	DP920 One-part Heat-cured Epoxy	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Flexible Epoxy	Flexible Epoxy	Toughened Epoxy Flexible Epoxy	Temperature and Solvent Resistant	Metals
				LO Acrylic MMA Acrylic Toughened Epoxy Flexible Epoxy Rigid Epoxy Toughened CA	One-part Heat-cured Epoxy Toughened Epoxy	LO Acrylic MMA Acrylic DP920	DP920 One-part Heat-cured Epoxy	MMA Acrylic LO Acrylic Toughened Epoxy Toughened CA	Toughened Epoxy MMA Acrylic LO Acrylic Toughened CA	Toughened Epoxy Flexible Epoxy	Flexible Epoxy	Toughened Epoxy Rigid Epoxy Surface Insensitive CA	General Purpose	
					One-part Heat-cured Epoxy Toughened Epoxy	One-part Heat-cured Epoxy DP920	One-part Heat-cured Epoxy	Toughened Epoxy	Toughened Epoxy One-part Heat-cured Epoxy	Toughened Epoxy One-part Heat-cured Epoxy	Flexible Epoxy	Toughened Epoxy	High Temperature Strength	Oily Metals
						LO Acrylic MMA Acrylic DP920	DP920	MMA Acrylic LO Acrylic DP920	DP920 One-part Heat-cured Epoxy	DP920	DP920	DP920	General Purpose	
							DP920	DP920	DP920 One-part Heat-cured Epoxy	DP920	DP920	DP920	High Temperature Strength	Composites
								MMA Acrylic LO Acrylic Toughened Epoxy Toughened CA Flexible Epoxy	Toughened Epoxy Flexible Epoxy Toughened CA	Toughened Epoxy Flexible Epoxy	Flexible Epoxy Flexible Urethane	Toughened Epoxy Semi-rigid Urethane Flexible Epoxy	Fiberglass/SMC	
									Toughened Epoxy Flexible Epoxy Toughened CA	Toughened Epoxy Flexible Epoxy	Flexible Epoxy	Toughened Epoxy Flexible Epoxy	Epoxy	Concrete/Stone/Ceramics/Glass
										Toughened Epoxy Flexible Epoxy Semi-rigid Urethane Flexible Urethane	Flexible Epoxy Flexible Urethane	Flexible Epoxy Flexible Urethane	Indoor	
											Flexible Epoxy Flexible Urethane	Flexible Epoxy Flexible Urethane	Outdoor	Wood
												Rigid Epoxy Toughened Epoxy Semi-rigid Urethane Surface Insensitive CA		

= Best in Class Product  
 = Suggested Alternate Product

\*with primer



# Work Life vs Viscosity Chart

The chart below compares the viscosity and work life of 3M's lead structural adhesive products. This quick reference can help you to select the right product based on viscosity, work life and chemistry of the adhesive.



## 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 structural strength, fast cure and environmental resistance – making them the first choice for the sign industry. **DP8805NS, DP8810NS, DP8405NS & DP8410NS**



# 3M™ Scotch-Weld™ Rigid Epoxies

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 at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							900	1,500	300			
* DP100 100 (Clear)	General purpose Rigid bonds	1:1	13,000	5 minutes	20 minute	2	900	1,500	300	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-22648-9 00-021200-87260-0 00-021200-87261-7 00-021200-82344-2 00-021200-82345-9	62-3575-1435-5 62-3575-3830-5 62-3575-3530-1 62-3575-8531-4 62-3675-8531-2
DP100FR 100FR (Cream)	Flame retardant UL94 V-0 rating	1:1	80,000	6 minutes	20 minutes	2	1,250	2,200	800	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-048011-56742-6 00-048011-56744-0 00-048011-56743-3 00-048011-57229-1 00-048011-57230-7	62-3531-1435-8 62-3531-3830-8 62-3531-3530-4 62-3531-8530-9 62-3631-8530-7
DP100NS 100NS (Translucent)	General purpose Non-sag	1:1	95,000	5 minutes	20 minutes	2	900	1,500	300	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-82255-1 00-021200-87264-8 00-021200-87265-5 00-021200-82256-8 00-021200-82257-5	62-3265-1435-3 62-3265-3830-3 62-3265-3530-9 62-3265-8530-4 62-3365-8530-2
* DP190 (Gray)	High performance Slightly flexible bonds	1:1	80,000	90 minutes	10 hours	50	1,500	2,500	400	50ml 200ml 400ml	00-021200-22647-2 00-021200-87840-4 00-021200-87841-1	62-3553-1435-2 62-3553-3830-2 62-3553-3530-8
DP270 270 (Black)	Rigid potting compound Non-corrosive	1:1	12,000	60 minutes	3 hours	2	1,200	2,500	300	50ml 200ml 400ml Gallon kit 5 gal. pail B 5 gal. pail A	00-021200-82262-9 00-021200-87836-7 00-021200-87837-4 00-021200-82263-6 00-021200-82264-3 00-021200-82265-0	62-3266-1435-1 62-3266-3830-1 62-3266-3530-7 62-3266-7430-6 62-3266-8530-2 62-3366-8530-0
DP270 270 (Clear)	Rigid potting compound Non-corrosive	1:1	12,000	60 minutes	3 hours	2	1,200	2,500	300	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-82248-3 00-021200-87834-3 00-021200-87835-0 00-021200-82250-6 00-021200-82251-3	62-3262-1435-0 62-3262-3830-0 62-3262-3530-6 62-3262-8530-1 62-3362-8530-9
1751 B/A (Gray)	Excellent void filler Rigid bonds	3:2	700,000	45 minutes	10 hours	4	1,400	2,000	500	2 oz. tube kit Pint kit Quart kit Gallon kit 5 gal. pail B 5 gal. pail A	00-021200-20100-4 00-021200-20101-1 00-021200-20103-5 00-021200-20105-9 00-021200-20108-0 00-021200-20120-2	62-1751-0530-3 62-1751-5430-1 62-1751-6430-0 62-1751-7430-9 62-1751-8530-5 62-1752-8530-3
1838 B/A (Green)	Multi-purpose Rigid bonds	4:5	400,000	60 minutes	8 hours	4	1,500	3,000	500	2 oz. tube kit Pint kit Quart kit Gallon kit 5 gal. pail B 5 gal. pail A	00-021200-20148-6 00-021200-20150-9 00-021200-20152-3 00-021200-20154-7 00-021200-20155-4 00-021200-20160-8	62-1838-0530-8 62-1838-5430-6 62-1838-6430-5 62-1838-7430-4 62-1838-8530-0 62-1839-8530-8
1838 B/A (Tan)	Multi-purpose Rigid bonds	5:6	250,000	60 minutes	8 hours	4	1,500	2,000	500	Quart kit 5 gal. pail B 5 gal. pail A	00-021200-22599-4 00-021200-22600-7 00-021200-22603-8	62-1614-6435-9 62-1614-8535-4 62-1752-8535-2
1838L B/A (Translucent)	Multi-purpose Rigid bonds	1:1	10,000	60 minutes	8 hours	4	2,000	2,500	300	2 oz. tube kit Quart kit 5 gal. pail B 5 gal. pail A	00-021200-22645-8 00-021200-22646-5 00-021200-82634-4 00-021200-82635-1	62-3520-0535-9 62-3520-6435-6 62-3520-8531-0 62-3620-8531-8
2158 B/A (Gray)	Multi-purpose Rigid bonds	1:1	375,000	2 hours	10 hours	3	1,500	2,000	400	Pint kit Quart kit Gallon kit 5 gal. pail B 5 gal. pail A	00-021200-20258-2 00-021200-20260-5 00-021200-20262-9 00-021200-20264-3 00-021200-20269-8	62-2158-5430-8 62-2158-6430-7 62-2158-7430-6 62-2158-8530-2 62-2159-8530-0
3501 B/A (Gray)	Multi-purpose Rigid bonds	1:1	500,000	7 minutes	25 minutes	4	1,500	2,400	300	2 oz. tube kit 400ml Pint kit Gallon kit 55 gal. drum	00-021200-20842-3 00-021200-45184-3 00-021200-20843-0 00-021200-20846-1 00-051111-91639-1	62-3501-0530-0 62-3501-3530-7 62-3501-5430-8 62-3501-7430-6 62-3501-9530-1

**LEAD** Denotes a Lead Product    \* Consider these products first when evaluating adhesives for your application.

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 (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 at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
								-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
<b>LEAD</b>	<b>DP100 Plus</b> 100 Plus (Clear)	Very flexible Colorless	1:1	8,500	4 minutes	20 minutes	55	3,000	3,500	200	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-87195-5 00-021200-87266-2 00-021200-87267-9 00-021200-87197-9 00-021200-87198-6	62-3272-1435-9 62-3272-3830-9 62-3272-3530-5 62-3272-8530-0 62-3372-8530-8
	DP105 105 (Clear)	Very flexible Colorless	1:1	6,500	5 minutes	20 minutes	50	3,500	2,000	150	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-87203-7 00-021200-87270-9 00-021200-87271-6 00-021200-87205-1 00-021200-87206-8	62-3287-1435-7 62-3287-3830-7 62-3287-3530-3 62-3287-8530-8 62-3387-8530-6
	DP110 110 (Gray)	General purpose Flexible bonds	1:1	55,000	8 minutes	20 minutes	40	2,700	3,500	250	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-82470-8 00-021200-87274-7 00-021200-87275-4 00-021200-82471-5 00-021200-82472-2	62-3533-1434-7 62-3533-3830-4 62-3533-3530-0 62-3533-8531-3 62-3633-8531-1
	DP110 110 (Translucent)	General purpose Flexible bonds	1:1	50,000	8 minutes	20 minutes	40	2,500	2,500	200	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-82465-4 00-021200-87846-6 00-021200-87847-3 00-021200-82466-1 00-021200-82467-8	62-3563-1434-4 62-3563-3830-1 62-3563-3530-7 62-3563-8531-0 62-3663-8531-8
<b>LEAD</b>	<b>DP125</b> 125 (Gray)	High performance Very flexible bonds	1:1	52,500	25 minutes	2.5 hours	90	3,400	4,300	400	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-002100-87211-2 00-002100-87842-8 00-002100-87843-5 00-002100-87217-4 00-002100-87218-1	63-3291-1435-9 62-3291-3830-9 62-3291-3530-5 62-3293-8530-6 62-3393-8530-4
	DP125 125 (Translucent)	High performance Very flexible bonds	1:1	15,000	25 minutes	2.5 hours	85	4,000	2,500	150	50ml 200ml 400ml	00-021200-87211-2 00-021200-87842-8 00-021200-87843-5	62-3291-1435-9 62-3291-3830-9 62-3291-3530-5
	DP190 (Translucent)	High performance Flexible bonds	1:1	10,000	80 minutes	6 hours	60	3,500	1,200	150	50ml 200ml 400ml	00-021200-87219-8 00-021200-87838-1 00-021200-87839-8	62-3286-1435-9 62-3286-3830-9 62-3286-3530-5
<b>LEAD</b>	<b>2216 B/A</b> (Gray)	High performance Very flexible bonds	2:3	80,000	90 minutes	10 hours	50	3,000	3,200	400	2 oz. tube kit Pint kit Quart kit Gallon kit 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-021200-20351-0 00-021200-20354-1 00-021200-20356-5 00-021200-20358-9 00-021200-20360-2 00-021200-20365-7 00-021200-20361-9 00-021200-20366-4	62-2216-0530-6 62-2216-5430-4 62-2216-6430-3 62-2216-7430-2 62-2216-8530-8 62-2217-8530-6 62-2216-9530-7 62-2217-9530-5
	2216 B/A (Translucent)	General purpose Very flexible bonds	1:1	10,000	2 hours	14 hours	70	3,000	1,700	140	2 oz. tube kit Pint kit Quart kit Gallon kit 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-021200-20851-5 00-021200-20852-2 00-021200-20854-6 00-021200-20856-0 00-021200-64980-6 00-021200-64981-3 00-021200-20859-1 00-021200-20927-7	62-3508-0530-5 62-3508-5430-3 62-3508-6430-2 62-3508-7430-1 62-3508-8535-6 62-3608-8535-4 62-3508-9530-6 62-3608-9530-4
	2216NS B/A (Tan)	High performance Non-sag	2:3	350,000	2 hours	10 hours	50	2,000	2,500	400	5 gal. pail B 5 gal. pail A	00-021200-87179-5 00-021200-87180-1	62-3278-8530-7 62-3378-8530-5
	LSB90 (Off-White)	General purpose Very flexible bonds	1:1	25,000	90 minutes	10 hours	40	3,500	2,500	400	400 ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-051115-63419-2 00-051115-63420-8 00-051115-63421-5 00-051115-63423-9 00-051115-63425-3	62-3556-3532-7 62-3556-8532-2 62-3656-8532-0 62-3556-9532-1 62-3656-9532-9

**LEAD** Denotes a Lead Product \* Consider these products first when evaluating adhesives for your application.

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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) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							75°F (24°C)	180°F (82°C)	67°F (-55°C)			
DP405 405 (Black)	Tough durable bonds High impact resistance	2:1	40,000	4 minutes	15 minutes	40	4,500	4,500	600	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-051111-07698-9 00-051111-07700-9 00-051111-07699-6 00-051111-07707-8 00-051111-07708-5	62-2814-1435-9 62-2814-3830-9 62-2814-3530-5 62-2814-8530-0 62-2914-8530-8
DP420 420 (Black)	Tough durable bonds High impact resistance	2:1	30,000	20 minutes	2 hours	75	4,500	4,500	1,250	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-021200-41528-9 00-021200-41530-2 00-021200-41529-6 00-021200-41531-9 00-021200-41532-6 00-021200-41533-3 00-021200-41534-0	62-2778-1435-6 62-2778-3830-6 62-2778-3530-2 62-2778-8530-7 62-2878-8530-5 62-2778-9530-6 62-2878-9530-4
DP420 420 (Off-White)	Tough durable bonds High impact resistance	2:1	30,000	20 minutes	2 hours	70	4,500	4,500	450	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A 1 gal. kit B/A	00-021200-82236-0 00-021200-87832-9 00-021200-87833-6 00-021200-82238-4 00-021200-82239-1 00-021200-97347-5	62-3280-1435-2 62-3280-3830-2 62-3280-3530-8 62-3280-8530-3 62-3380-8530-1 62-3280-7530-4
DP420LH 420LH (Off-White)	Tough durable bonds Low halogen	2:1	30,000	20 minutes	2 hours	70	4,500	4,500	1,250	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-051111-07244-8 00-051111-07697-2 00-051111-07696-5 00-051111-07275-2 00-051111-07276-9	62-2818-1435-0 62-2818-3830-0 62-2818-3530-6 62-2818-8530-1 62-2918-8530-9
<b>LEAD</b> DP420NS 420NS (Black)	Tough durable bonds Non-sag	2:1	180,000	20 minutes	2 hours	60	4,500	4,500	1,250	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-021200-39285-6 00-021200-39286-3 00-021200-39287-0 00-021200-56587-8 00-021200-31309-7 00-048011-58132-3 00-048011-58133-0	62-3299-1435-2 62-3299-3832-8 62-3299-3532-4 62-3299-8535-2 62-3399-8530-1 62-3299-9530-2 62-3399-9530-0
DP460 460 (Off-White)	Tough durable bonds	2:1	30,000	60 minutes	4 hours	80	4,500	4,500	700	37ml 200ml 400ml Quart kit 5 gal. pail B 5 gal. pail A	00-021200-82225-4 00-021200-87830-5 00-021200-87831-2 00-021200-82226-1 00-021200-82227-8 00-021200-82228-5	62-3593-1435-8 62-3593-3830-8 62-3593-3530-4 62-3593-6430-4 62-3593-8530-9 62-3693-8530-7
DP460NS 460NS (Off-White)	Tough durable bonds Non-sag	2:1	125,000	60 minutes	4 hours	70	4,900	4,650	1,350	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-43670-3 00-021200-43671-0 00-021200-43672-7 00-021200-43673-4 00-021200-43674-1	62-2792-1435-7 62-2792-3830-7 62-2792-3530-3 62-2792-8530-8 62-2892-8530-6
DP920 920 (Off-White)	Tough durable bonds Bonds to oily metal	2:1	80,000	20 minutes	4 hours	37	3,800	4,000	800	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-051111-07709-2 00-051111-07711-5 00-051111-07710-8 00-051111-07724-5 00-051111-07726-9	62-2820-1435-6 62-2820-3830-6 62-2820-3530-2 62-2820-8530-7 62-2920-8530-5
LSB60 (Gray)	Tough durable bonds High impact resistance	1:1	30,000	90 minutes	10 hours	15	3,400	4,500	900	400ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-051115-63411-6 00-051115-63414-7 00-051115-63416-1 00-051115-63417-8 00-051115-63418-5	62-3554-3532-2 62-3554-8532-7 62-3654-8532-5 62-3554-9532-6 62-3654-9532-4
LSB60NS (Gray)	Tough durable bonds Non-sag High impact resistance	1:1	180,000	90 minutes	10 hours	30	3,800	4,500	800	400ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-051115-63426-0 00-051115-63427-7 00-051115-63428-4 00-051115-63429-1 00-051115-63430-7	62-3562-3532-5 62-3562-8532-0 62-3662-8532-8 62-3562-9532-9 62-3662-9532-7
LSB360NS (Green)	Tough durable bonds Non-sag Extra long work life Bonds oily metals	1:1	paste	10 hours	16 hours	30	4,000	3,900	800	400ml	00-051111-64291-3	62-3560-3530-3

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# 3M™ Scotch-Weld™ Standard MMA Acrylics

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cp)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							75°F (24°C)	180°F (82°C)	-67°F (-55°C)			
DP805 805 (Light Yellow)	Fast strength build Minimal surface prep	1:1	110,000	3 minutes	10 minutes	35	2,500	3,500	2,200	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-83758-6 00-021200-87828-2 00-021200-87829-9 00-021200-87233-4 00-021200-87234-1	62-3288-1435-5 62-3288-3830-5 62-3288-3530-1 62-3288-8530-6 62-3388-8530-4
DP807 807 (Light Yellow)	Short work life Two-part toughened acrylic adhesive	1:1	50,000	5 minutes	20 minutes	20	2,000	4,300	800	47ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-051115-31635-7 00-051115-31636-4 00-051115-31637-1 00-051115-31638-8 00-051115-31639-5	62-3290-1435-1 62-3290-3830-1 62-3290-3530-7 62-3290-8530-2 62-3390-8530-0
DP812 812 (Yellow)	Medium work life Two-part toughened acrylic adhesive	1:1	50,000	10 minutes	20 minutes	20	2,100	4,500	1,000	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-051115-31641-8 00-051115-31646-3 00-051115-31643-2 00-051115-31644-9 00-051115-31645-6	62-3292-1435-7 62-3292-3830-7 62-3292-3530-3 62-3292-8530-8 62-3392-8530-6
DP820 (Light Yellow)	Tough durable bonds Minimal surface prep	1:1	55,000	15 minutes	40 minutes	20	3,100	3,150	1,900	50ml 200ml 400ml	00-021200-89347-6 00-021200-89348-3 00-021200-89349-0	62-3277-1435-8 62-3277-3830-8 62-3277-3530-4
DP825 825 (White)	Long work life Two-part toughened acrylic adhesive	1:1	50,000	25 minutes	40 minutes	20	2,700	4,500	1,000	47ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-051115-31667-8 00-051115-31668-5 00-051115-31669-2 00-051115-31670-8 00-051115-31671-5	62-3285-1435-1 62-3285-3830-1 62-3285-3530-7 62-3285-8530-2 62-3385-8530-0
DP8405NS 8405NS (Green)	High impact Adhesion to most plastics	10:1	70,000	5 minutes	15 minutes	50	N/A	4,100	900	45ml 490ml 5 gallon pail 55 gallon drum	00-051115-68963-5 00-051115-68964-2 00-051115-68986-4 00-051115-68987-1	62-2856-1445-9 62-2856-3630-4 62-2856-8530-1 62-2856-9530-0
<b>LEAD</b> DP8410NS 8410NS (Green)	High impact Adhesion to most plastics	10:1	70,000	10 minutes	25 minutes	50	N/A	4,100	800	45ml 490ml 5 gallon pail 55 gallon drum	00-051115-70994-4 00-051115-70995-1 00-051115-70997-5 00-051115-71101-5	62-2860-1445-1 62-2860-3630-6 62-2860-8530-3 62-2860-9530-2
DP8425NS 8425NS (Green)	High impact Adhesion to most plastics	10:1	70,000	25 minutes	50 minutes	50	N/A	3,700	800	45ml 490ml 5 gallon pail 55 gallon drum B	00-051115-81303-0 00-051115-81302-3 00-051115-81298-9 00-051115-81031-6	62-2862-1445-7 62-2862-3630-2 62-2862-8530-9 62-2862-9530-8

# 3M™ Scotch-Weld™ Low Odor Acrylics

DP810 (Black)	Tough durable bond High impact resistance	1:1	20,000	10 minutes	20 minutes	30	1,200	3,600	500	50ml 200ml 1 gallon pail 5 gallon pail 20 liter pail B 20 liter pail A	00-021200-49077-4 00-021200-49079-8 00-048011-56711-2 00-048011-56712-9 00-021200-49080-4 00-021200-49081-1	62-2788-1435-5 62-2788-3830-5 62-2788-7530-7 62-2888-7530-5 62-2788-8730-2 62-2888-8730-0
DP810 810 (Tan)	Tough durable bonds High impact resistance	1:1	20,000	10 minutes	20 minutes	30	1,200	3,600	500	50ml 200ml 400ml 20 liter pail B 20 liter pail A	00-021200-31310-3 00-021200-31311-0 00-021200-31312-7 00-021200-45230-7 00-021200-45233-8	62-3298-1435-4 62-3298-3830-4 62-3298-3530-0 62-3298-8730-1 62-3398-8730-9
DP810NS 810NS (Tan)	Tough durable bonds Non-sag	1:1	95,000	10 minutes	20 minutes	20	1,200	4,000	500	50ml 200ml 400ml 20 liter pail B 20 liter pail A	00-021200-49082-8 00-021200-49084-2 00-021200-49083-5 00-021200-49085-9 00-021200-49086-6	62-2799-1435-2 62-2799-3830-2 62-2799-3530-8 62-2799-8730-9 62-2899-8730-7
<b>LEAD</b> DP8805NS 8805NS (Green)	Low odor Fast rate of strength build	10:1	80,000	5 minutes	10 minutes	30	N/A	3,600	900	45ml 400ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-051115-68958-1 00-051115-68959-8 00-051115-68979-6 00-051115-68984-0 00-051115-68981-9 00-051115-68980-2	62-2852-1445-8 62-2852-3630-3 62-2852-8530-0 62-2852-9530-9 62-2952-7530-9 62-2952-8530-8
DP8810NS 8810NS (Green)	Low odor Fast rate of strength build	10:1	80,000	10 minutes	20 minutes	30	N/A	3,600	800	45ml 400ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-051115-68960-4 00-051115-68962-8 00-051115-68982-6 00-051115-68985-7 00-051115-68981-9 00-051115-68980-2	62-2854-1445-4 62-2854-3630-9 62-2854-8530-6 62-2854-9530-5 62-2952-7530-9 62-2952-8530-8
DP8825NS 8825NS (Green)	Low odor Fast rate of strength build	10:1	80,000	25 minutes	50 minutes	20	N/A	3,000	800	45ml 490ml 5 gallon pail 55 gallon drum 1 gallon can 5 gallon pail	00-051115-81288-0 00-051115-81289-7 00-051115-81290-3 00-051115-81291-0 00-051115-81415-0 00-051115-81414-3	62-2866-1445-8 62-2866-3630-3 62-2866-8530-0 62-2866-9530-9 62-2962-7530-8 62-2962-8530-2

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

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-20°F (-29°C)	75°F (24°C)	150°F (66°C)			
							75°F (24°C)	150°F (66°C)	150°F (66°C)			
DP8005 8005 (Black)	Bonds polyolefins and low surface energy materials	10:1	25,000	3 minutes	3 hours	9	875	2,000	475	35ml 250ml 1 gal. pail A 5 gal. pail B 5 gal. pail A 50 gal. drum B	00-051111-92166-1 00-051111-92167-8 00-021200-45171-3 00-051111-92168-5 00-021200-45172-0 00-051111-92171-5	62-2779-0437-1 62-2779-3936-9 62-2879-7530-4 62-2779-8536-2 62-2879-8530-3 62-2779-9536-1
DP8005 8005 (Off-White)	Bonds polyolefins and low surface energy materials	10:1	25,000	3 minutes	3 hours	17	750	2,200	500	35ml 250ml 1 gal. pail A 5 gal. pail B	00-051111-92130-2 00-051111-92131-9 00-021200-41552-4 00-051111-92143-2	62-2786-0437-6 62-2786-3936-4 62-2886-7530-9 62-2786-8536-7
<b>LEAD</b> DP8010 8010 Blue	Bonds polyolefins and low surface energy materials	10:1	20,000	10 minutes	1 hour	N/A	2,700	2,700	500	45ml 490ml 1 gal. cont. A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-71600-3 00-051115-71601-0 00-021200-49113-9 00-051115-71669-0 00-021200-49115-3 00-051115-81460-0	62-2863-1445-5 62-2863-3630-0 62-2883-7530-6 62-2863-8530-7 62-2883-8530-5 62-2863-9530-6
DP8010NS 8010NS Blue	Bonds polyolefins and low surface energy materials	10:1	65,000	10 minutes	1 hour	N/A	2,700	2,700	500	45ml 490ml 1 gal. cont. A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-81451-8 00-051115-81453-2 00-021200-49113-9 00-051115-81454-9 00-021200-49115-3 00-051115-81461-7	62-2865-1445-0 62-2865-3630-5 62-2883-7530-6 62-2865-8530-2 62-2883-8530-5 62-2865-9530-1

# 3M™ Scotch-Weld™ Flexible 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 at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-40°F (-40°C)	75°F (24°C)	180°F (82°C)			
							75°F (24°C)	180°F (82°C)	180°F (82°C)			
<b>LEAD</b> DP604NS 604NS (Black)	Flexible Non-sag	1:1	Paste	4 minutes	20 minutes	30	1,400	600	300	50ml 5 gal. pail B 5 gal. pail A 50 gal. drum B 50 gal. drum A	00-021200-96412-1 00-021200-96461-9 00-021200-96462-6 00-021200-96531-9 00-021200-96532-6	62-2648-5030-6 62-2648-8530-2 62-2748-8530-0 62-2648-9530-1 62-2748-9530-9
DP640 (Brown)	Tough flexible bonds	1:1	25,000	60 minutes	8 hours	60	3,000	2,000	400	50ml 200ml 400ml	00-021200-89543-2 00-021200-89545-6 00-021200-89544-9	62-3549-1435-0 62-3549-3830-0 62-3549-3530-6
3549 (Brown)	Tough flexible bonds Non-sag	1:1	30,000	60 minutes	8 hours	60	3,000	2,000	400	2 oz. kit Quart kit 5 gal. pail B 5 gal. pail A	00-021200-20901-7 00-021200-20902-4 00-021200-20904-8 00-021200-20942-0	62-3549-0501-0 62-3549-6401-7 62-3549-8501-2 62-3649-8501-0
DP5001 5001 (Black)	Flexible Conveyor belt repair	1:1	100,000	1 minute	15 minutes	N/A	N/A	600	N/A	50ml 400ml	00-021200-96414-5 00-051111-98296-9	62-3528-5032-5 62-3528-3530-0
DP5106 5106 (Gray)	High strength Control joint seals	1:1	34,000	4 minutes	40 minutes	N/A	N/A	1,100	N/A	5 gal. pail B 5 gal. pail A	00-021200-96583-8 00-021200-96584-5	62-3627-8535-6 62-3527-9535-4

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# 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 at 75°F (24°C)	Overlap Shear (psi)			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	3,200	2,300	700	50ml 400ml 8.4 fl. oz. 5 gal. pail B 5 gal. pail A	00-021200-56602-8 00-051111-98303-4 00-021200-96596-8 00-021200-96574-6 00-021200-96575-3	62-2649-5030-4 62-2649-3530-5 62-2649-1233-8 62-2649-8535-9 62-2749-8535-7
DP600NS 600NS (Gray)	Concrete repair Non-sag	1:1	Paste	1 minute	4 minutes	8	2,700	2,300	700	50ml 400ml	00-021200-56606-6 00-051111-98312-6	62-2652-5030-8 62-2652-3530-9
DP601 601 (Gray)	Rigid Self-leveling	1:1	6,000	1 minute	4 minutes	20	3,200	2,300	700	50ml 5 gal. pail B 5 gal. pail A 50 gal. drum B 50 gal. drum A	00-021200-96410-7 00-021200-96451-0 00-021200-96452-7 00-021200-96507-4 00-021200-96508-1	62-2649-5031-2 62-2649-8530-0 62-2749-8530-8 62-2649-9530-9 62-2749-9530-7
DP601NS 601NS (Gray)	Rigid Non-sag	1:1	Paste	1 minute	4 minutes	8	2,700	2,300	700	50ml	00-021200-96407-7	62-2652-5031-6
DP605NS 605NS (Off-White)	Semi-rigid Non-sag	1:1	150,000	5 minutes	20 minutes	40	4,000	2,000	600	50ml 200ml 5 gal. pail B 5 gal. pail A	00-021200-82252-0 00-021200-87853-4 00-021200-82253-7 00-021200-82254-4	62-3592-1435-0 62-3592-3830-0 62-3592-8530-1 62-3692-8530-9
DP608 608 (Black)	Flexible Non-sag	1:1	Paste	10 minutes	90 minutes	16	3,000	2,500	500	50ml 5 gal. pail B 5 gal. pail A 50 gal. drum B 50 gal. drum A	00-021200-96418-3 00-021200-96513-5 00-021200-96514-2 00-021200-96515-9 00-021200-96516-6	62-3268-5030-2 62-3268-8530-8 62-3368-8530-6 62-3268-9530-7 62-3368-9530-5
DP620NS 620NS (Black)	Flexible Non-sag	1:1	Paste	20 minutes	4 hours	40	3,000	2,500	500	50ml 5 gal. Pail B 5 gal. Pail A 50 gal. Drum B 50 gal. Drum A	00-021200-96416-9 00-021200-96449-7 00-021200-96450-3 00-021200-96505-0 00-021200-96506-7	62-2645-5030-2 62-2645-8530-8 62-2745-8530-6 62-2645-9530-7 62-2745-9530-5
3532 B/A (Brown)	Multi-purpose Semi-rigid bonds	1:1	30,000	10 minutes	90 minutes	25	2,500	2,000	300	2 oz. kit Quart kit 5 gal. pail B 5 gal. pail A	00-021200-20878-2 00-021200-20879-9 00-021200-20881-2 00-021200-20935-2	62-3532-0515-6 62-3532-6430-2 62-3532-8515-8 62-3632-8516-4
3535 B/A (Off-White)	Multi-purpose Semi-rigid bonds	1:1	30,000	3 minutes	30 minutes	25	2,500	2,000	300	2 oz. kit Quart kit	00-021200-20887-4 00-021200-20888-1	62-3535-0515-9 62-3535-6430-5

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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™ One-Part Heat Cured Epoxies

Product (Color)	Key Features	Approximate Viscosity at 75°F (24°C) (CP)					Cure Conditions			Overlap Shear (psi)			UPC	Stock #
		Time (min.)	Temp. (F/C)	Floating Roller Peel at 75°F (24°C)	-67°F (-55°C)	75°F (24°C)	180°F (82°C)	250°F (121°C)	Size					
										Temp. (F/C)	Temp. (F/C)	Temp. (F/C)		
1386 (Cream)	High temperature strength Impact resistance	150,000	60	350/177	10	3,000	5,500	4,500	2,500	1 quart 5 gal. pail	00-021200-19917-2 00-021200-19919-6	62-1386-6525-2 62-1386-8525-0		
1469 (Cream)	High temperature strength Low viscosity	60,000	120	350/177	2	3,150	3,700	3,700	3,600	1 quart 5 gal. pail	00-021200-19949-3 00-021200-19950-9	62-1469-6525-6 62-1469-8525-4		
2086 (Gray)	High temperature strength High viscosity	Paste	60	350/177	5	3,000	5,000	5,000	2,200	5 gal. pail	00-021200-20235-3	62-2086-8525-5		
2214 Hi-Density (Gray)	High temperature strength Low temp curing	Paste	40	250/121	5	3,000	4,500	4,500	1,700	6 oz. cart. 5 gal. pail	00-021200-20813-3 00-021200-20814-0	62-3414-2930-6 62-3414-8530-8		
2214 Hi-Temp New Formula (Gray)	High temperature strength Environmental resistance	Paste	60	250/121	2	2,800	2,800	2,800	2,500	6 oz. cart. 5 gal. pail	00-021200-20833-1 00-021200-20835-5	62-3491-2830-6 62-3491-8530-6		
2214 Hi-Temp Original (Gray)	High temperature strength Environmental resistance	Paste	40	250/121	2	2,000	2,000	3,000	2,500	6 oz. cart.	00-021200-20806-5	62-3402-2930-1		
2214 Non-Metallic Filled (Cream)	High temperature strength Higher insulation value	Paste	40	250/121	7	3,000	4,000	4,500	1,500	6 oz. cart. 5 gal. pail	00-021200-20802-7 00-021200-25496-3	62-3401-0830-7 62-3401-2934-5		
* 2214 Regular (Gray)	High temperature strength Low temp curing	Paste	40	250/121	5	3,000	4,500	4,500	1,500	6 oz. cart. 1 quart 5 gal. pail	00-021200-20344-2 00-021200-20345-9 00-021200-23047-3	62-2214-2930-1 62-2214-6530-5 62-2214-8530-3		
2290 (Amber)	Low solids liquid coating for metal laminations	60	30	350/177	N/A	5,000	5,000	3,500	1,200	Gallon cart. 5 gal. pail 54 gal. drum	00-021200-76225-3 00-021200-76227-7 00-021200-76228-4	62-3847-7530-0 62-3847-8531-7 62-3847-9530-8		

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

The PR (Plastic & Rubber) series of products bonds to most plastics and rubbers with a range of viscosities that will fit all your application needs.  
**PR40, PR100, PR600, PR1500, PRGel**



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

The SF (Super Fast) series products are very fast setting and bond to most surfaces, including leathers and other acidic materials, making them the first choice for fast cure and material versatility.  
**SF20 & SF100**





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

	Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
	PR Gel (Clear)	Fast cure, gel viscosity for max gap filling	Gel	-65° to 180°F (-54° to 82°C)	20-60 sec.	24	20 gram tube 300 gram cart	00-051115-25265-5 00-051115-25282-2	62-6152-0362-7 62-6152-3360-8
	PR40 (Clear)	Low viscosity for close fitting plastic/rubber parts	40	-65° to 180°F (-54° to 82°C)	3-20 sec.	24	20 gram bottle 500 gram bottle	00-051115-25204-4 00-051115-25205-1	62-6147-0360-1 62-6147-3860-7
<b>LEAD</b>	<b>PR100</b> (Clear)	General purpose, low viscosity plastic bonder	100	-65° to 180°F (-54° to 82°C)	10-30 sec.	24	200 gram bottle 500 gram bottle 500 gram bottle 2 kilo bottle	00-051115-25214-3 00-051115-25939-5 00-051115-25213-6 00-051111-07176-2	62-6164-0360-6 62-6164-3865-1 62-6164-3860-2 62-6164-6860-9
	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 ml bottle	00-051115-25241-9	62-6182-0862-3
	PR1500 (Clear)	General purpose, high viscosity for gap filling	1,500	-65° to 180°F (-54° to 82°C)	20-60 sec.	24	200 gram bottle 500 gram bottle 500 gram bottle 2 gram tube	00-051115-25222-8 00-051115-25937-1 00-051115-25221-1 00-051115-25205-0	62-6165-0360-3 62-6165-3865-8 62-6165-3860-9 62-6137-0260-4

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

	SI Gel (Clear)	Fast cure, gel viscosity for max gap filling	Gel	-65° to 180°F (-54° to 82°C)	20-60 sec.	24	20 gram tube 300 gram cart.	00-051115-25266-2 00-051115-25284-6	62-6163-0362-4 62-6163-3360-5
	SI100 (Clear)	Low viscosity for medium gaps	100	-65° to 180°F (-54° to 82°C)	3-20 sec.	24	200 gram bottle 3 gram tube 500 gram bottle	00-051115-25268-6 00-051115-25290-7 00-051115-25267-9	62-6176-0360-0 62-6176-0363-4 62-6176-3860-6
	SI1500 (Clear)	High viscosity for gap filling	1,500	-65° to 180°F (-54° to 82°C)	5-60 sec.	24	50 gram bottle 500 gram bottle	00-048011-61662-9 00-051115-25245-7	62-6178-0862-1 62-6178-3860-2

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

	LO 100 (Clear)	General purpose, low viscosity with reduced odor and blooming	100	-65° to 180°F (-54° to 82°C)	9-20 sec	24	20 gram tube	00-048011-62732-8	62-6128-0360-1
	LO 1000 (Clear)	General purpose, high viscosity with reduced odor and blooming, suitable for minor gap filling	1,000	-65° to 180°F (-54° to 82°C)	20-25 sec	24	20 gram tube	00-051111-91664-3	62-6132-0360-3

## 3M™ Scotch-Weld™ Instant Adhesives – General Purpose

	EC Gel (Clear)	Industrial strength thixotropic gel for maximum gap fill	Gel	-65° to 180°F (-54° to 82°C)	20-60 sec.	24	300 gram cart.	00-048011-62659-8	62-6196-3360-5
	EC5 (Clear)	Very low viscosity for close fitting plastic/rubber parts Wicking grade	5	-65° to 180°F (-54° to 82°C)	10-30 sec.	24	20 gram bottle 500 gram bottle	00-051115-81285-9 00-051115-81286-6	62-6192-0360-7 62-6192-3860-3
	EC40 (Clear)	General purpose Fast curing	40	-65° to 180°F (-54° to 82°C)	5-30 sec.	24	20 gram bottle 500 gram bottle	00-048011-62645-1 00-048011-62646-8	62-6190-0360-1 62-6190-3860-7
	EC100 (Clear)	General purpose Fast curing	100	-65° to 180°F (-54° to 82°C)	10-40 sec.	24	20 gram bottle 500 gram bottle	00-048011-62638-3 00-048011-62640-6	62-6188-0360-5 62-6188-3860-1
	EC2500 (Clear)	Higher viscosity for porous materials and minor gap filling Slower cure for repositionability	2,500	-65° to 180°F (-54° to 82°C)	20-60 sec.	24	20 gram bottle 500 gram bottle	00-048011-62642-0 00-048011-62636-9	62-6186-0360-9 62-6186-3860-5

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

Product (Color)	Key Features	Typical Viscosity (cps)	Temperature Range	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
SF20 (Clear)	Fast cure Optimum performance on wide range of rubbers and plastics	20	-65° to 180°F (-54° to 82°C)	4-30 sec.	24	1 oz. bottle 1 lb. bottle	00-051111-91667-4 00-051115-25790-2	62-6151-0360-3 62-6151-3860-9
SF100 (Clear)	Fast cure, high strength with EPDM and other elastomers	100	-65° to 180°F (-54° to 82°C)	4-30 sec.	24	20 gram bottle 3 gram tube 1 lb. bottle	00-048011-62631-4 00-048011-62630-7 00-048011-62629-1	62-6174-0361-3 62-6174-0363-9 62-6174-3860-1

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

RT5000B (Black)	Rubber toughened for impact resistance High viscosity for minor gap filling	5,000	-65° to 180°F (-54° to 82°C)	30 sec	24	20 gram bottle 500 gram bottle	00-051111-916650 00-051115-252006	62-6135-0360-6 62-6135-3860-2
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## 3M™ Scotch-Weld™ Instant Adhesives – Metal

MC100 (Clear)	Multi-purpose metal bonder	100	-65° to 180°F (-54° to 82°C)	4-20 sec.	24	1 oz. bottle 1 lb. bottle	00-051111-91663-6 00-048011-62634-5	62-6130-0360-7 62-6130-3860-3
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## 3M™ Scotch-Weld™ Instant Adhesives – Engineered Grade

CA4	Fast setting for a variety of plastics and rubbers	150	-65° to 180°F (-54° to 82°C)	5-40 sec.	24	2 gram tube 1 oz. bottle 1 lb. bottle	00-021200-96601-9 00-021200-96600-2 00-021200-96597-5	62-3801-0230-1 62-3801-0330-9 62-3801-3830-5
CA5	Higher viscosity, slower setting version of CA4 for filling gaps Meets CID A-A-3097, Type II, Class 3	2,000	-65° to 180°F (-54° to 82°C)	12-60 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-74289-7 00-021200-74288-0	62-3802-0330-7 62-3802-3830-3
CA7	Very fast setting Excellent metal bonder Better shock and impact resistance	15-40	-65° to 212°F (-54° to 100°C)	1-30 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-21061-7 00-021200-21062-4	62-3812-0330-6 62-3812-3830-2
CA8	Rapid setting Excellent adhesion to metals, plastics and rubbers Meets CID A-A-3097, Type II, Class 2	70-130	-65° to 180°F (-54° to 82°C)	5-40 sec.	24	2 gram tube 1 oz. bottle 1 lb. bottle	00-021200-21065-5 00-021200-21066-2 00-021200-21067-9	62-3815-0130-3 62-3815-0330-9 62-3815-3830-5
CA9	Slower setting for parts alignment Useful for wire tracking and coil terminating 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 1 lb. bottle	00-021200-21068-6 00-021200-21069-3	62-3817-0330-5 62-3817-3830-1
CA40	Very fast setting Excellent adhesion to many substrates including flexible vinyl and EPDM rubber	20	-65° to 180°F (-54° to 82°C)	3-20 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-74290-3 00-021200-74291-0	62-3803-0330-5 62-3803-3830-1
CA40H	Higher viscosity version of CA40 Better void filling capabilities	400-600	-65° to 212°F (-54° to 100°C)	5-40 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-21073-0 00-021200-21074-7	62-3829-0330-0 62-3829-3830-6
CA50 Gel	High-viscosity, non-sag gel Less sensitive to acidic surfaces	45,000- 85,000	-65° to 212°F (-54° to 100°C)	60-120 sec.	24	20 gram tube 200 gram tube	00-021200-82332-9 00-021200-83737-1	62-3872-0330-0 62-3872-3630-0
CA100	High peel and impact strength High thermal shock and heat resistance	2,500-4,500	-65° to 212°F (-54° to 100°C)	20-70 sec.	24	1 oz. bottle 1 lb. bottle	00-021200-82334-3 00-021200-82335-0	62-3873-0330-8 62-3873-3830-4

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# 3M™ Scotch-Weld™ Instant Adhesive Primers, Activators and Debonders

Product (Color)	Key Features	Typical Viscosity (cps)	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
AC09	Instant adhesive activator Non-flammable, solvent-based California compliant	1	1-5 sec.	24	2 fl. oz. bottle 1 liter can	00-051111-07795-5 00-051111-07908-9	62-6198-0860-3 62-6198-8360-6
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 4 liter can 55 gallon drum	00-048011-62728-1 00-048011-62653-6 00-048011-62654-3	62-3907-0860-0 62-3907-7560-9 62-3907-9560-7
AC79	Instant adhesive primer for bonding of difficult-to-bond elastomers such as silicone, fluoro-elastomer and EPDM	2	1-5 sec.	24	2 fl. oz. bottle 8 fl. oz. bottle 4 liter can	00-051115-31388-2 00-051115-31389-9 00-051115-31390-5	62-3916-0860-1 62-3916-3760-0 62-3916-7560-0
AC113	Instant adhesive general purpose accelerator Will not attack plastics	<3	1-5 sec.	24	2 fl. oz. bottle 8 fl. oz. bottle Quart can 4 liter can	00-048011-62681-9 00-048011-62682-6 00-048011-62683-3 00-048011-62684-0	62-6194-0860-2 62-6194-3760-1 62-6194-6560-2 62-6194-7560-1
AC452	Instant adhesive acetone-based accelerator flashes off rapidly Excellent adhesion Overspray may attack some plastics	<2	1-5 sec.	24	2 fl. oz. bottle 8 fl. oz. bottle 12 oz. aerosol 4 liter can	00-048011-62685-7 00-048011-62686-4 00-048011-62687-1 00-048011-62689-5	62-6195-0860-9 62-6195-3760-8 62-6195-4460-4 62-6195-7560-8
Surface Activator	Clear, colorless organic-based liquid helps speed curing and prime surfaces Comes with brush and spray pump	<10	1-5 sec.	24	2 fl. oz. bottle	00-021200-87937-1	62-3804-0830-2

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## 3M™ Scotch-Weld™ Engineered Grade Instant Adhesives

3M's Engineered Grade Instant Adhesives combine high performance, excellent adhesion and temperature resistance with the speed of instant adhesives – providing you with differentiated capabilities for your most difficult thin bond line applications. **CA5, CA40, CA40H, CA50 Gel**



## 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**

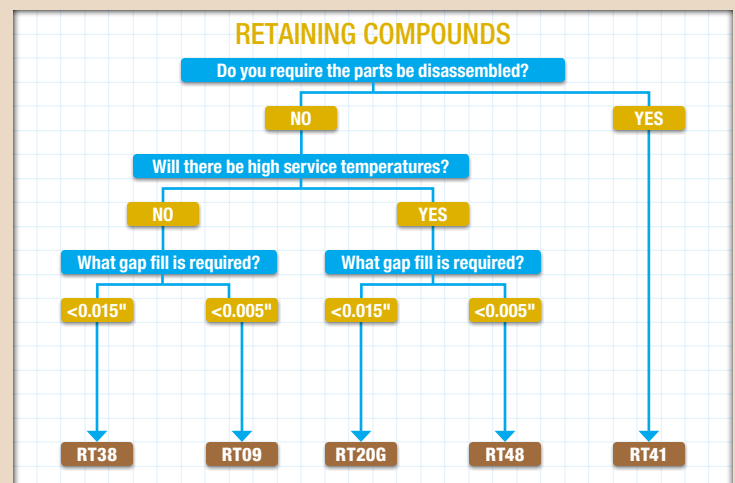
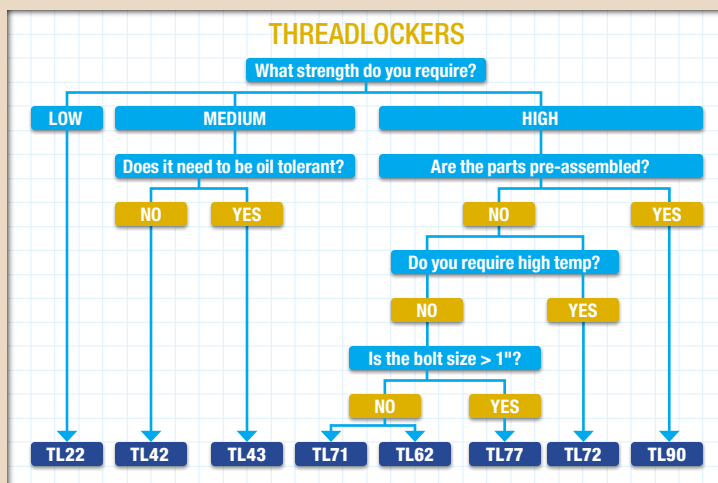


# 3M™ Scotch-Weld™ Anaerobic Adhesives – Threadlockers

Product (Color)	Key Features	Typical Viscosity (cps)	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)	< 20 min	24	10ml bottle 50ml bottle 250ml bottle	00-048011-62601-7 00-048011-62602-4 00-048011-62603-1	62-3493-1060-7 62-3493-5060-3 62-3493-6260-6
TL42 (Blue)	Nutlock - medium strength, general purpose	1,200	-65° to 300°F (-54° to 149°C)	< 20 min	24	1ml pipette 10ml bottle 50ml bottle 250ml bottle 1 liter bottle	00-048011-62604-8 00-048011-62605-5 00-048011-62606-2 00-048011-62607-9 00-051115-25124-5	62-3494-0160-4 62-3494-1060-5 62-3494-5060-1 62-3494-3960-4 62-3494-8360-2
TL43 (Blue)	Oil tolerant, medium strength general purpose	3,300	-65° to 300°F (-54° to 149°C)	< 20 min	24	10ml bottle 50ml bottle 250ml bottle 1 liter bottle	00-051115-25138-2 00-051115-25139-9 00-051115-25140-5 00-051115-25141-2	62-3428-1060-3 62-3428-5060-9 62-3428-3960-2 62-3428-8360-0
TL62 (Red)	Studlock - high strength with controlled torque tension	1,600	-65° to 300°F (-54° to 149°C)	< 20 min	24	10ml bottle 50ml bottle 250ml bottle 1 liter bottle	00-048011-62609-3 00-048011-62610-9 00-048011-62611-6 00-051115-25132-0	62-3495-1060-2 62-3495-5060-8 62-3495-3960-1 62-3495-8360-9
TL71 (Red)	Permanent studlock for bolts and studs up to 1" (25mm)	500	-65° to 300°F (-54° to 149°C)	< 20 min	24	1ml pipette 10ml bottle 50ml bottle 250ml bottle	00-051115-25125-2 00-048011-62612-3 00-048011-62613-0 00-048011-62614-7	62-3496-0160-9 62-3496-1060-0 62-3496-5060-6 62-3496-3960-9
TL72 (Red)	High temperature studlock with gap filling for larger diameter coarse threaded parts	7,000	-65° to 450°F (-54° to 232°C)	< 20 mins	24	10ml bottle 50ml bottle 250ml bottle 1 liter bottle	00-051115-25133-7 00-051115-25137-5 00-051115-25135-1 00-051115-25136-8	62-3497-1060-8 62-3497-5060-4 62-3497-3960-7 62-3497-8360-5
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)	< 20 mins	24	10ml bottle 250ml bottle	00-051115-25142-9 00-051115-25143-6 00-051115-25144-3	62-3429-1060-1 62-3429-5060-7 62-3429-3960-0
TL90 (Green)	Penetrating adhesive for pre-assembled fasteners and porosity sealing of welds	20	-65° to 300°F (-54° to 149°C)	< 20 min	24	10ml bottle 50ml bottle 250ml bottle 1 liter bottle	00-048011-62615-4 00-048011-62616-1 00-048011-62617-8 00-051115-25150-4	62-3498-1060-6 62-3498-5060-2 62-3498-3960-5 62-3498-8360-3

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

HP42	Lock/seal medium pipe threads Prevents vibration loosening & leaks	500	-65° to 300°F (-54° to 149°C)	15 min	24	50ml bottle 250ml bottle	00-054007-99630-9 00-054007-99631-6	62-3474-5060-3 62-3474-3950-7
HP45 (Purple)	High pressure sealant for all hydraulic and pneumatic fittings	14,000	-65° to 300°F (-54° to 149°C)	4 hours	24	50ml bottle 250ml bottle	00-048011-62721-2 00-048011-62722-9	62-3477-5060-6 62-3477-3960-9
PS65 (White)	General purpose for applications requiring easy disassembly	Paste	-65° to 300°F (-54° to 149°C)	2 hours	24	50ml tube 250ml tube 1 liter bottle	00-048011-62711-3 00-048011-62712-0 00-048011-62713-7	62-3701-5067-4 62-3701-3967-7 62-3701-8360-0
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 250ml tube 1 liter bottle	00-048011-62714-4 00-048011-62715-1 00-048011-62716-8	62-3478-5067-9 62-3478-3967-2 62-3478-8360-5
PS77	Lock/seal medium to coarse pipe threads; prevents vibration, loosening and leaks	15,000 @ 20 RPM	-65° to 300°F (-54° to 149°C)	15 min	24	50ml tube 250ml tube	00-054007-99635-4 00-054007-99636-1	62-3707-5067-1 62-3707-3967-4



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

Product (Color)	Key Features	Typical Viscosity (cps)	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 50ml bottle 250ml bottle 1 liter bottle	00-048011-62661-1 00-048011-62662-8 00-048011-62663-5 00-051115-31977-8	62-3435-1060-8 62-3435-5060-4 62-3435-3960-7 62-3435-8360-3
RT20G (Green)	For assembly of automotive/marine cylinder liners and heat exchanger tubes	7,000	-65° to 450°F (-54° to 232°C)	30-40 mins	24	10ml bottle 10/CV 10ml bottle 300/CV 50ml bottle 250ml bottle	00-048011-62664-2 00-051115-31751-4 00-048011-62665-9 00-048011-62666-6	62-3434-1060-1 62-3434-1360-5 62-3434-5060-7 62-3434-3960-0
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	10ml bottle 50ml bottle 250ml bottle	00-051115-81282-8 00-051115-81283-5 00-051115-81284-2	62-3460-1060-6 62-3460-5060-2 62-3460-3960-5
RT41 (Tan)	Medium strength for cylindrical parts Easier disassembly for service and bearing re-use	600	-65° to 300°F (-54° to 149°C)	15-20 mins	24	250ml bottle	00-048011-62724-3	62-3484-3960-5
RT48	High strength bonds for cylindrical parts	600	-65° to 300°F (-54° to 149°C)	10 min	24	50ml bottle 250ml bottle	00-054007-99632-3 00-054007-99633-0	62-3480-5060-0 62-3480-3950-4

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

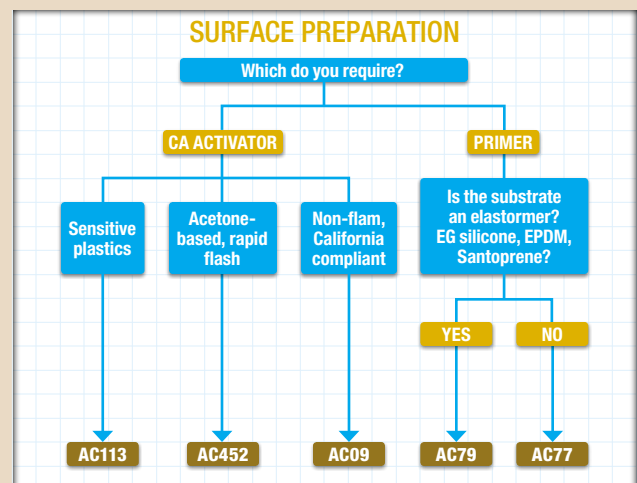
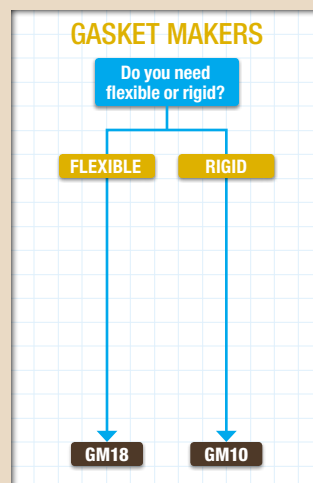
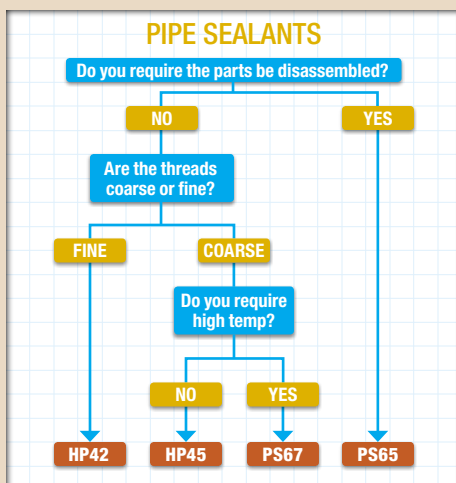
GM10 (Red)	Masking or dressing gaskets in rigid assemblies Can be screen printed High temperature resistance	Paste	-65° to 400°F (-54° to 204°C)	30 min	24	50ml tube	00-048011-62652-9	62-3453-5067-2
GM18 (Red)	Instant flexible seal without a primer on mating aluminum flanges	Paste	-65° to 300°F (-54° to 149°C)	30 min	24	300 gram cart. 50ml tube	00-048011-62660-4 00-048011-62658-1	62-3454-3362-7 62-3454-5067-0

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




AC649	Acetone-based green primer for inactive or very cold surfaces 30-day part life for pre-application California compliant	<3	N/A	<5 min	24	2 fl. oz. bottle 8 fl. oz. bottle 4 liter can	00-048011-62708-3 00-048011-62709-0 00-048011-62707-6	62-3918-0860-7 62-3918-3760-6 62-3918-7560-6
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**LEAD** Denotes a Lead Product    **\*** Consider these products first when evaluating adhesives for your application.

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™ EPX™ Applicators and Nozzles

		Replacement Plunger Orders	37 ml (2:1) & 42 ml (2:3)	45 ml (10:1)	50 ml (1:1)	200 ml (2:1 & 1:1)	400 ml (2:1 & 1:1)	490 ml (10:1)	Static Mixing Nozzle Options
<b>3M™ Scotch-Weld™ EPX™ Plus II Applicator</b>  <b>Stock #:</b> 62-9170-9930-1 <b>UPC:</b> 0-00-21200-50004-6 	<b>1:1 Plunger</b>  <b>Stock #:</b> 62-9170-9911-1 <b>UPC:</b> 0-00-21200-50005-3			✓				<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 37ml and 50ml <b>Stock #:</b> 62-9171-9153-8 <b>UPC:</b> 0-00-21200-50008-4	
	<b>2:1 Plunger</b>  <b>Stock #:</b> 62-9170-9921-0 <b>UPC:</b> 0-00-21200-50006-0	✓						<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 37ml and 50ml <b>Stock #:</b> 62-9171-9153-8 <b>UPC:</b> 0-00-21200-50008-4	
	<b>10:1 Plunger</b>  <b>Stock #:</b> 62-9160-9910-4 <b>UPC:</b> 0-00-51115-69044-0	✓						<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Orange, 45ml <b>Stock #:</b> 62-9154-9136-9 <b>UPC:</b> 0-00-51115-69043-3	
<b>3M™ EPX™ Metal Applicator 50 ml</b>  <b>Stock #:</b> 62-9740-9935-0 <b>UPC:</b> 0-00-21200-21789-0 	<b>2:1 Plunger</b>  <b>Stock #:</b> 62-9744-9930-3 <b>UPC:</b> 0-00-21200-82314-5	✓	✓					<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 37ml and 50ml <b>Stock #:</b> 62-9171-9153-8 <b>UPC:</b> 0-00-21200-50008-4	
	<b>3M™ Scotch-Weld™ EPX™ Manual Applicator 200 ml</b>  <b>Stock #:</b> 62-9136-9930-2 <b>UPC:</b> 0-00-21200-87977-7					✓			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200ml and 400ml <b>Stock #:</b> 62-9176-9127-1 <b>UPC:</b> 0-00-21200-97331-4
<b>3M™ EPX™ Pneumatic Applicator 50 ml</b>  <b>Stock #:</b> 62-9781-9930-5 <b>UPC:</b> 0-00-21200-83528-5 	N/A	✓	✓					<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 37ml and 50ml <b>Stock #:</b> 62-9171-9153-8 <b>UPC:</b> 0-00-21200-50008-4	
	<b>3M™ Scotch-Weld™ EPX™ Manual Applicator 200 ml</b>  <b>Stock #:</b> 62-9136-9930-2 <b>UPC:</b> 0-00-21200-87977-7								<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 37ml and 50ml <b>Stock #:</b> 62-9178-9150-9 <b>UPC:</b> 0-00-51115-81449-5
<b>3M™ Scotch-Weld™ EPX™ Manual Applicator 200 ml</b>  <b>Stock #:</b> 62-9136-9930-2 <b>UPC:</b> 0-00-21200-87977-7 	<b>2:1 Plunger</b>  <b>Stock #:</b> 62-9136-9938-5 <b>UPC:</b> 0-00-21200-87981-4							<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 200ml and 400ml <b>Stock #:</b> 62-9142-9930-0 <b>UPC:</b> 0-00-21200-87982-1	

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™ EPX™ Applicators and Nozzles

		Replacement Plunger Orders	37 ml (2:1) & 42 ml (2:3)	45 ml (10:1)	50 ml (1:1)	200 ml (2:1 & 1:1)	400 ml (2:1 & 1:1)	490 ml (10:1)	Static Mixing Nozzle Options
<b>3M™ EPX™ 200, 250, 400 ml Manual Applicator</b>  Stock #: 62-9148-9930-7  UPC: 0-00-51111-98073-6		N/A			✓	✓		<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200ml and 400ml Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4	
			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 200ml and 400ml Stock #: 62-9142-9930-0 UPC: 0-00-21200-87982-1						
<b>3M™ EPX™ 490 ml Manual Applicator</b>  Stock #: 62-9182-9930-6  UPC: 0-00-51115-71115-2		N/A					✓	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical Orange, 490ml Stock #: 62-9158-9136-0 UPC: 0-00-51115-69042-6	
			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 490ml Stock #: 62-9184-9490-7 UPC: 0-00-51115-81619-2						
<b>3M™ Scotch-Weld™ EPX™ Pneumatic Applicator 200 ml</b>  Stock #: 62-9140-9930-4  UPC: 0-00-21200-87978-4		N/A			✓			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200ml and 400ml Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4	
			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 200ml and 400ml Stock #: 62-9142-9930-0 UPC: 0-00-21200-87982-1						
<b>3M™ EPX™ 400 ml Pneumatic Applicator</b>  Stock #: 62-9145-9930-3  UPC: 0-00-21200-87979-1		N/A					✓	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200ml and 400ml Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4	
			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 200ml and 400ml Stock #: 62-9142-9930-0 UPC: 0-00-21200-87982-1						
<b>3M™ EPX™ 490 ml Pneumatic Applicator</b>  Stock #: 62-9152-9930-9  UPC: 0-00-51115-69041-9		N/A					✓	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical Orange, 490 ml Stock #: 62-9158-9136-0 UPC: 0-00-51115-69042-6	
			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 490 ml Stock #: 62-9184-9490-7 UPC: 0-00-51115-81619-2						
<b>Standard Caulk Gun</b>		N/A	3M™ Concrete Repair Urethane 8.4 oz cartridges				<b>3M™ Concrete Repair 8.4 oz Cartridge Nozzles</b> Stock #: 62-9637-9935-8 UPC: 0-00-48011-53382-7		

# 3M™ Scotch-Weld™ Structural Adhesives Coverage Guide

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

Bead Size Dimension*	Linear Ft. per 37 ml (2:1 Cart.)	Linear Ft. per 43 ml (2:3 Cart.)	Linear Ft. per 45 ml (10:1 Cart.)	Linear Ft. per 50 ml (1:1 Cart.)	Linear Ft. per 200 ml (1:1 & 2:1 Cart.)	Linear Ft. per 400 ml (1:1 & 2:1 Cart.)	Linear Ft. per 490 ml (10:1 Cart.)
1/2 in.	2.0	2.2	2.4	2.5	10	21	26
3/8 in.	3.5	3.9	4.2	4.5	18	37	45
1/4 in.	8.0	9.0	9.3	10.5	41	83	102
1/8 in.	31.0	35.7	37.2	41.5	165	331	405
1/16 in.	122.0	142.0	147.7	165.0	656	1313	1600

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

Wet Thickness per 1000 Square Ft.	Square Ft. per gal. (approx.)	Approx. gal. reqd. per 1000 Square Ft.
1/2 in.	3.2	312.0
1/8 in.	12.8	78.0
1/16 in.	25.6	39.0
1/32 in.	51.2	20.0
25 mils	64.0	16.0
5 mil	320.0	3.1

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

Bead Size Dimension*	Approx. Linear Ft. per gal.	Approx. gal. per 1000 Lineal Ft.
1/2 in.	196	5.0
3/8 in.	350	3.0
1/4 in.	785	1.3
1/8 in.	3,130	0.32
1/16 in.	12,420	0.08

\* 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.

## 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. 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 solvent to evaporate 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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1-800-362-3550  
[www.3M.com/structuraladhesives](http://www.3M.com/structuraladhesives)

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