

**3M** Science.  
Applied to Life.™



**3M**

**Scotch-Weld**™  
Structural Adhesive

## Product Selection Guide

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

# 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.



# Advancing design, process and performance

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



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

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



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

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



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

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

# Simplifying Adhesive Decisions for Your Application

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

## Q: What materials will be bonded?

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



## Q: What is the preferred cure speed?

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



## Q: What surface preparation will be required?

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



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

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



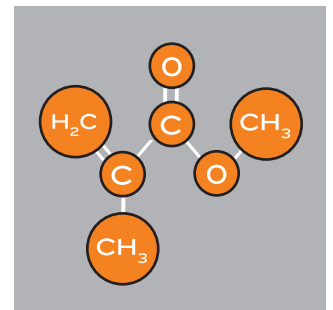
## Q: How are structural adhesives used and applied?

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



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

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



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

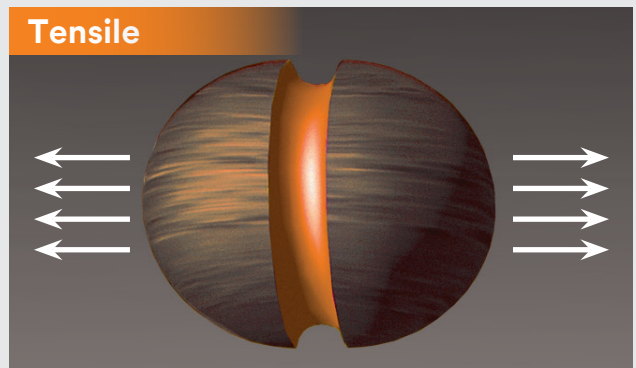
- **Acrylic adhesives** are two-part adhesives that provide excellent bond strength and durability, although slightly lower than epoxy adhesives. However, they have several features that make them easier to use in many applications and manufacturing processes. These benefits include a much faster cure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

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

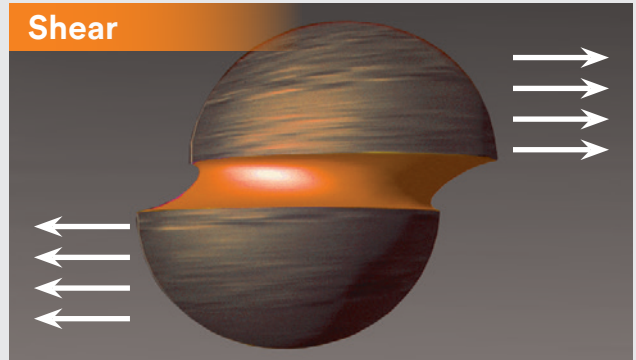
- **Cyanoacrylate adhesives** (instant adhesives) are one-component, lower viscosity liquids that cure extremely quickly with just contact pressure and surface moisture. They adhere well, with thin bond lines, to plastics, metals and rubbers. With the use of primers, they can also adhere to low surface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

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

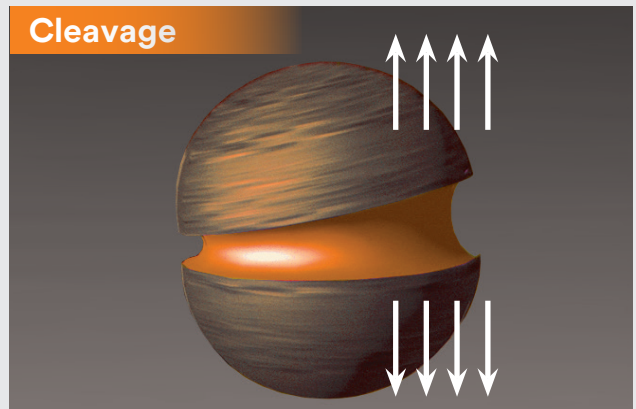
- **PUR adhesives** (Polyurethane-reactive adhesives) are one-part adhesives that apply like a hot melt, but cure with ambient moisture for near structural strength bonds. Fast set times and build strength over the next 24-48 hours can reach as much as 1,000 psi in overlap shear strength. They are flexible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



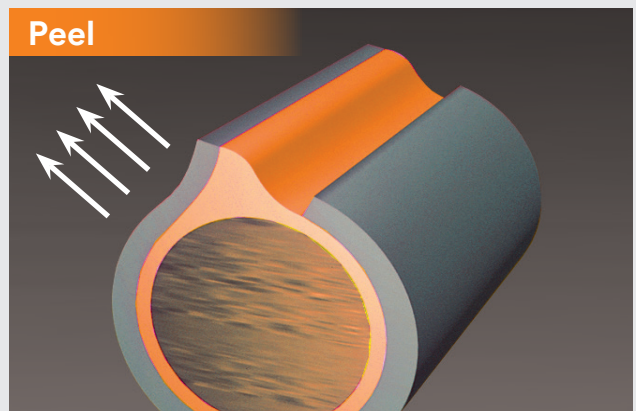
**Tensile** is pull exerted equally over the entire joint. Pull direction is straight and away from the adhesive bond.



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



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



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



# Key Markets & Applications

For 3M™ Scotch-Weld™ Structural Adhesives



## Sporting Goods

### Key Features & Benefits:

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

### Key Products:

DP420NS Black, DP8810NS, PR100, TS230

## Specialty Vehicle

### Key Features & Benefits:

- Weight reduction
- High strength
- Vibration & fatigue resistance

### Key Products:

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, DP8810NS, TS230, TL42

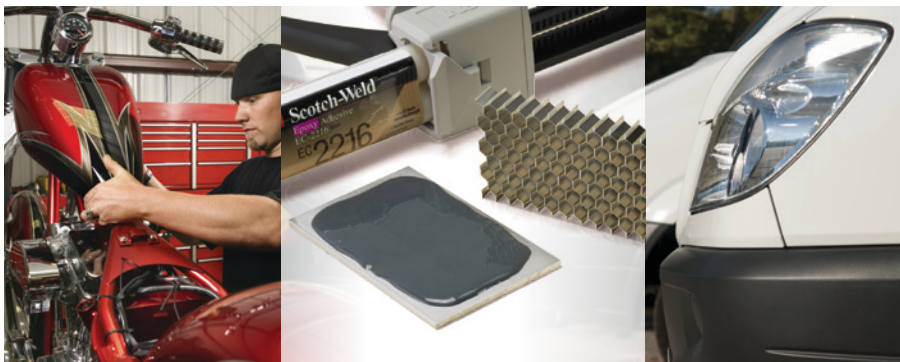
## Aerospace

### Key Features & Benefits:

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

### Key Products:

2216 Gray, DP100FR, DP640



## Plastic, Composite & Rubber

### Key Features & Benefits:

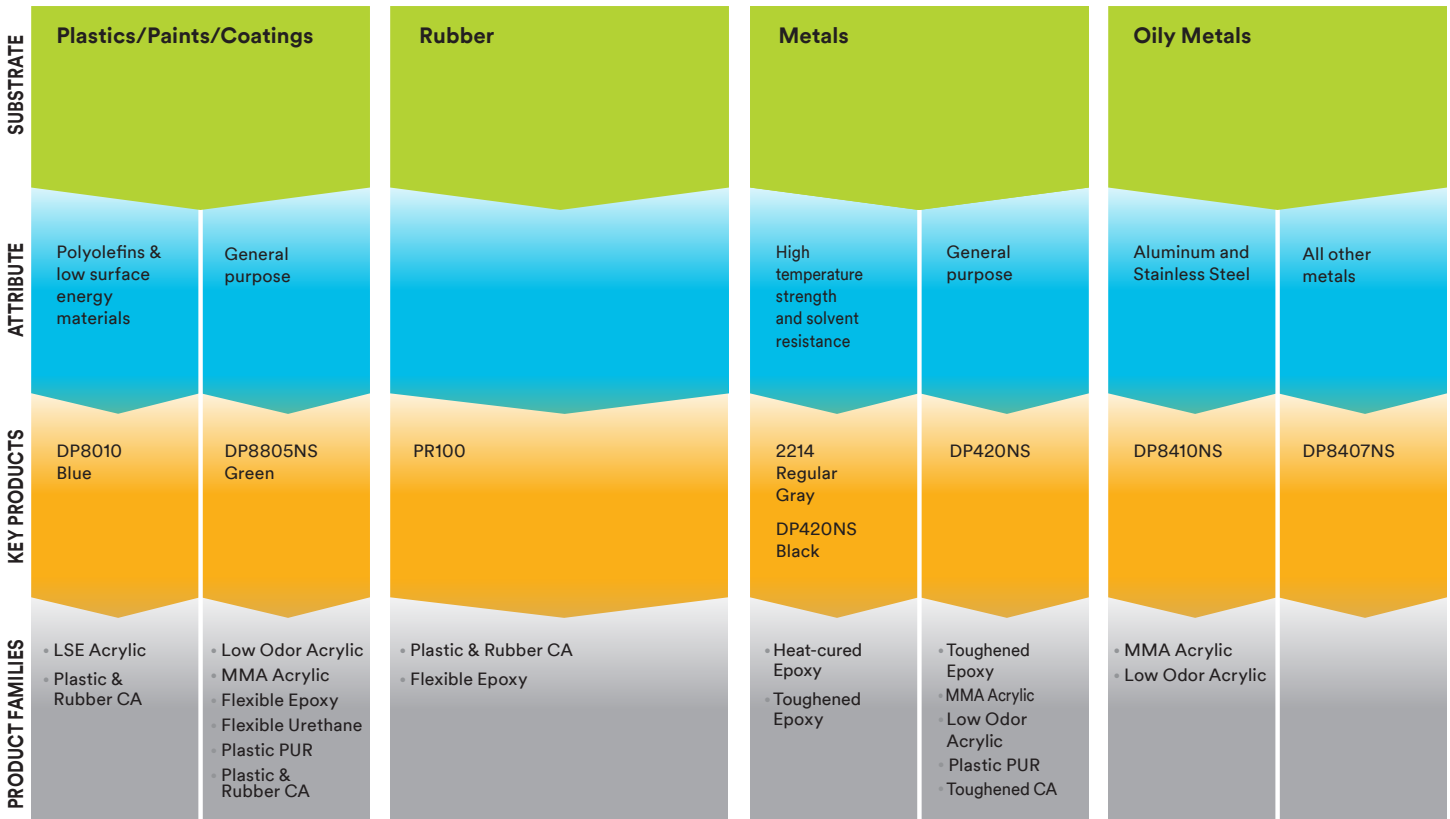
- Bonding of low surface energy plastics without priming
- Impact resistant composite bonding

### 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.

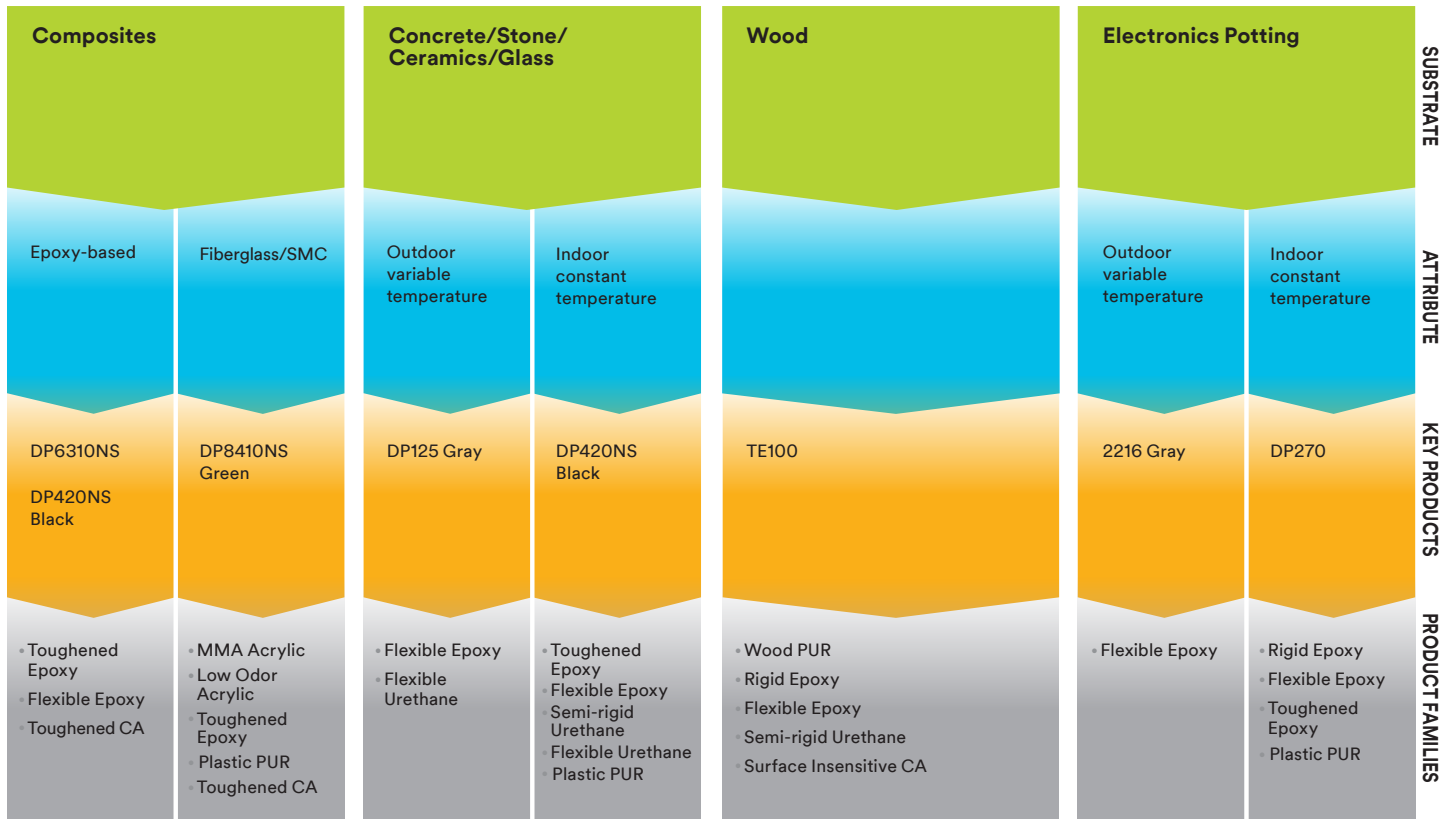
## Instant Adhesive Families

**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	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 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 Toughened Epoxy 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 Flexible 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

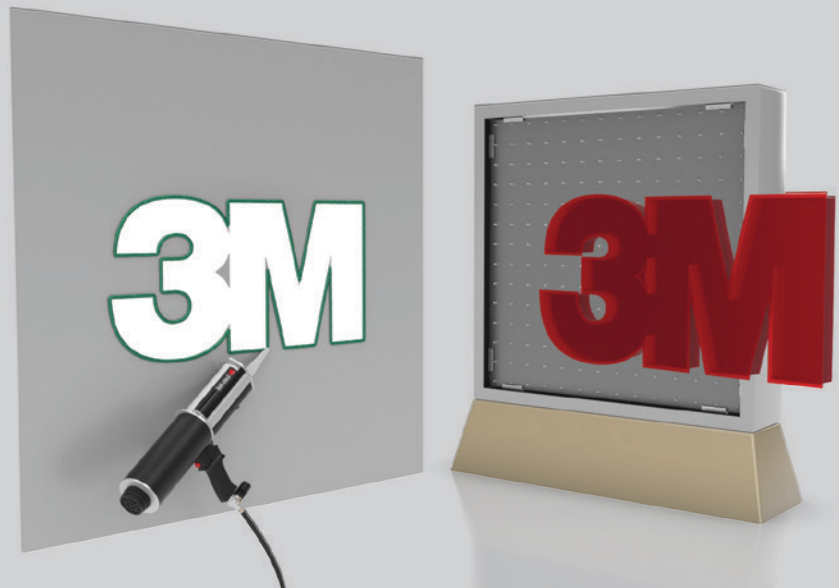
Bead Size Dimension* inches/mm	Approx. lineal ft/gal (m/liter)	Approx. gal/1,000 lineal ft (liter/1,000 m)
1/2 in (12.7 mm)	196 ft (16 m)	5 gal (63 liter)
3/8 in (9.5 mm)	350 ft (28 m)	3 gal (36 liter)
1/4 in (6.4 mm)	785 ft (63 m)	1.3 gal (16 liter)
1/8 in (3.2 mm)	3,130 ft (252 m)	0.3 gal (4 liter)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

### 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™ 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 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08994-1 00-021200-87260-0 00-021200-87261-7 00-021200-82345-9 00-021200-82344-2	62-3575-1437-1 62-3575-3830-5 62-3575-3530-1 62-3675-8531-2 62-3575-8531-4
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 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08989-7 00-048011-56744-0 00-048011-56743-3 00-048011-57230-7 00-048011-57229-1	62-3531-1436-6 62-3531-3830-8 62-3531-3530-4 62-3631-8530-7 62-3531-8530-9
DP100NS 100NS (Translucent)	General purpose Non-sag	1:1	95,000	5 minutes	20 minutes	2 (4)	900 (6)	1,500 (10)	300 (2)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08974-3 00-021200-87264-8 00-021200-87265-5 00-021200-82257-5 00-021200-82256-8	62-3265-1436-1 62-3265-3830-3 62-3265-3530-9 62-3365-8530-2 62-3265-8530-4
DP270 270 (Black)	Rigid potting compound Non-corrosive	1:1	12,000	60 minutes	3 hours	2 (4)	1,200 (8)	2,500 (17)	300 (2)	48.5mL 200mL 400mL Gallon kit 5 gal. pail A 5 gal. pail B	00-638060-08975-0 00-021200-87836-7 00-021200-87837-4 00-021200-82263-6 00-021200-82265-0 00-021200-82264-3	62-3266-1436-9 62-3266-3830-1 62-3266-3530-7 62-3266-7430-6 62-3366-8530-0 62-3266-8530-2
DP270 270 (Clear)	Rigid potting compound Non-corrosive	1:1	12,000	60 minutes	3 hours	2 (4)	1,200 (8)	2,500 (17)	300 (2)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08973-6 00-021200-87834-3 00-021200-87835-0 00-021200-82251-3 00-021200-82250-6	62-3262-1436-8 62-3262-3830-0 62-3262-3530-6 62-3362-8530-9 62-3262-8530-1
1751 B/A (Gray)	Excellent void filler Rigid bonds	3:2	700,000	45 minutes	10 hours	4 (7)	1,400 (10)	2,000 (14)	500 (3)	2 oz. tube kit Pint kit Quart kit Gallon kit 5 gal. pail A 5 gal. pail B	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 62-1752-8530-3 62-1751-8530-5
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 Pint kit Quart kit Gallon kit 5 gal. pail A 5 gal. pail B	00-021200-20148-6 00-021200-20150-9 00-021200-20152-3 00-021200-20154-7 00-021200-20160-8 00-021200-20155-4	62-1838-0530-8 62-1838-5430-6 62-1838-6430-5 62-1838-7430-4 62-1839-8530-8 62-1838-8530-0
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 Quart kit 5 gal. pail A 5 gal. pail B	00-021200-22645-8 00-021200-22646-5 00-021200-82635-1 00-021200-82634-4	62-3520-0535-9 62-3520-6435-6 62-3620-8531-8 62-3520-8531-0
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 Quart kit Gallon kit 5 gal. pail A 5 gal. pail B	00-021200-20258-2 00-021200-20260-5 00-021200-20262-9 00-021200-20269-8 00-021200-20264-3	62-2158-5430-8 62-2158-6430-7 62-2158-7430-6 62-2159-8530-0 62-2158-8530-2
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 400mL Pint kit Gallon kit 55 gal. drum A 55 gal. drum B	00-021200-20842-3 00-021200-45184-3 00-021200-20843-0 00-021200-20846-1 00-051111-091640-7 00-051111-91639-1	62-3501-0530-0 62-3501-3530-7 62-3501-5430-8 62-3501-7430-6 62-3601-9530-9 62-3501-9530-1

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

KEY PRODUCT	Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PU (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
								-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
KEY PRODUCT	DP100 Plus 100 Plus (Clear)	Very flexible Colorless	1:1	8,500	4 minutes	20 minute	55 (98)	3,000 (21)	3,500 (24)	200 (1)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08976-7 00-021200-87266-2 00-021200-87267-9 00-021200-87198-6 00-021200-87197-9	62-3272-1436-7 62-3272-3830-9 62-3272-3530-5 62-3372-8530-8 62-3272-8530-0
	DP105 105 (Clear)	Very flexible Colorless	1:1	6,500	5 minutes	20 minute	50 (89)	3,500 (24)	2,000 (14)	150 (1)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08981-1 00-021200-87270-9 00-021200-87271-6 00-021200-87206-8 00-021200-87205-1	62-3287-1436-5 62-3287-3830-7 62-3287-3530-3 62-3387-8530-6 62-3287-8530-8
	DP110 110 (Gray)	General purpose Flexible bonds	1:1	55,000	8 minutes	20 minute	40 (71)	2,700 (19)	3,500 (24)	250 (2)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08990-3 00-021200-87274-7 00-021200-87275-4 00-021200-82472-2 00-021200-82471-5	62-3533-1431-3 62-3533-3830-4 62-3533-3530-0 62-3633-8531-1 62-3533-8531-3
	DP110 110 (Translucent)	General purpose Flexible bonds	1:1	50,000	8 minutes	20 minute	40 (71)	2,500 (17)	2,500 (17)	200 (1)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08993-4 00-021200-87846-6 00-021200-87847-3 00-021200-82467-8 00-021200-82466-1	62-3563-1438-5 62-3563-3830-1 62-3563-3530-7 62-3663-8531-8 62-3563-8531-0
KEY PRODUCT	DP125 125 (Gray)	High performance Very flexible bonds	1:1	52,500	25 minutes	2.5 hours	90 (160)	3,400 (23)	4,300 (30)	400 (3)	48.5mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08985-9 00-021200-87844-2 00-021200-87845-9 00-021200-87218-1 00-021200-87217-4	62-3293-1437-1 62-3293-3830-5 62-3293-3530-1 62-3393-8530-4 62-3293-8530-6
	DP125 125 (Translucent)	High performance Very flexible bonds	1:1	15,000	25 minutes	2.5 hours	85 (151)	4,000 (28)	2,500 (17)	150 (1)	48.5mL 200mL 400mL	00-638060-08983-5 00-021200-87842-8 00-021200-87843-5	62-3291-1436-7 62-3291-3830-9 62-3291-3530-5
	DP190 (Translucent)	High performance Flexible bonds	1:1	10,000	80 minutes	6 hours	60 (107)	3,500 (24)	1,200 (8)	150 (1)	48.5mL 200mL 400mL	00-638060-08980-4 00-021200-87838-1 00-021200-87839-8	62-3286-1436-7 62-3286-3830-9 62-3286-3530-5
*	DP190 (Gray)	High performance Slightly flexible bonds	1:1	80,000	90 minutes	10 hours	50 (89)	1,500 (10)	2,500 (17)	400 (3)	48.5mL 200mL 400mL	00-638060-08992-7 00-021200-87840-4 00-021200-87841-1	62-3553-1436-0 62-3553-3830-9 62-3553-3530-8
	2216 B/A (Gray)	High performance Very flexible bonds	2:3	80,000	90 minutes	10 hours	50 (89)	3,000 (21)	3,200 (22)	400 (3)	43mL Duo-Pak 2 oz. tube kit Pint kit Quart kit Gallon kit 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-021200-56659-2 00-021200-20351-0 00-021200-20354-1 00-021200-20356-5 00-021200-20358-9 00-021200-20365-7 00-021200-20360-2 00-021200-20366-4 00-021200-20361-9	62-2216-1435-7 62-2216-0530-6 62-2216-5430-4 62-2216-6430-3 62-2216-7430-2 62-2217-8530-6 62-2216-8530-8 62-2217-9530-5 62-2216-9530-7
	2216 B/A (Translucent)	General purpose Very flexible bonds	1:1	10,000	2 hours	14 hours	70 (125)	3,000 (21)	1,700 (12)	140 (1)	2 oz. tube kit Pint kit Quart kit Gallon kit 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-021200-20851-5 00-021200-20852-2 00-021200-20854-6 00-021200-20856-0 00-021200-64981-3 00-021200-64980-6 00-021200-20927-7 00-021200-20859-1	62-3508-0530-5 62-3508-5430-3 62-3508-6430-2 62-3508-7430-1 62-3608-8535-4 62-3508-8535-6 62-3608-9530-4 62-3508-9530-6
	2216NS B/A (Tan)	High performance Non-sag	2:3	350,000	2 hours	10 hours	50 (89)	2,000 (14)	2,500 (17)	400 (3)	5 gal. pail A 5 gal. pail B	00-021200-87180-1 00-021200-87179-5	62-3378-8530-5 62-3278-8530-7

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™ Toughened Epoxies

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PLI (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
DP405 405 (Black)	Tough durable bonds High impact resistance	2:1	40,000	4 minutes	15 minutes	40 (71)	4,500 (31)	4,500 (31)	600 (4)	50mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08971-2 00-051111-07700-9 00-051111-07699-6 00-051111-07708-5 00-051111-07707-8	62-2814-1436-7 62-2814-3830-9 62-2814-3530-5 62-2914-8530-8 62-2814-8530-0
DP420 420 (Black)	Tough durable bonds High impact resistance	2:1	30,000	20 minutes	2 hours	75 (133)	4,500 (31)	4,500 (31)	1,250 (9)	50mL 200mL 400mL Gallon Kit 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-638060-08966-8 00-021200-41530-2 00-021200-41529-6 00-051115-25796-4 00-021200-41532-6 00-021200-41531-9 00-021200-41534-0 00-021200-41533-3	62-2778-1436-4 62-2778-3830-6 62-2778-3530-2 62-2778-7530-8 62-2878-8530-5 62-2778-8530-7 62-2878-9530-4 62-2778-9530-6
DP420 420 (Off-White)	Tough durable bonds High impact resistance	2:1	30,000	20 minutes	2 hours	70 (125)	4,500 (31)	4,500 (31)	450 (3)	50mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08978-1 00-021200-87832-9 00-021200-87833-6 00-021200-82239-1 00-021200-82238-4	62-3280-1436-0 62-3280-3830-2 62-3280-3530-8 62-3380-8530-1 62-3280-8530-3
DP420LH 420LH (Off-White)	Tough durable bonds Low halogen	2:1	30,000	20 minutes	2 hours	70 (125)	4,500 (31)	4,500 (31)	1,250 (9)	50mL 200mL 400mL	00-638060-08972-9 00-051111-07697-2 00-051111-07696-5	62-2818-1436-8 62-2818-3830-0 62-2818-3530-6
KEY PRODUCT DP420NS 420NS (Black)	Tough durable bonds Non-sag	2:1	180,000	20 minutes	2 hours	60 (107)	4,500 (31)	4,500 (31)	1,250 (9)	50mL 200mL 400mL 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-638060-08987-3 00-021200-39286-3 00-021200-39287-0 00-021200-31309-7 00-021200-56587-8 00-048011-58133-0 00-048011-58132-3	62-3299-1436-0 62-3299-3832-8 62-3299-3532-4 62-3399-8530-1 62-3299-8535-2 62-3399-9530-0 62-3299-9530-2
DP460 460 (Black)	Tough durable bonds	2:1	30,000	60 minutes	4 hours	80 (142)	4,500 (31)	4,500 (31)	700 (5)	5 gal. pail A 5 gal. pail B	00-021200-25319-5 00-021200-25318-8	62-3397-8530-5 62-3297-8530-7
DP460 460 (Off-White)	Tough durable bonds	2:1	30,000	60 minutes	4 hours	80 (142)	4,500 (31)	4,500 (31)	700 (5)	50mL 200mL 400mL Quart kit 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-638060-08998-9 00-021200-87830-5 00-021200-87831-2 00-021200-82226-1 00-021200-82228-5 00-021200-82227-8 00-021200-83757-9 0-00-76308-14623-8	62-3593-1436-6 62-3593-3830-8 62-3593-3530-4 62-3593-6430-4 62-3693-8530-7 62-3593-8530-9 62-3693-9530-6 62-3593-9532-4
DP460NS 460NS (Off-White)	Tough durable bonds Non-sag	2:1	125,000	60 minutes	4 hours	70 (125)	4,900 (34)	4,650 (32)	1,350 (9)	50mL 200mL 400mL 5 gal. pail A 5 gal. pail B	00-638060-08968-2 00-021200-43671-0 00-021200-43672-7 00-021200-43674-1 00-021200-43673-4	62-2792-1436-5 62-2792-3830-7 62-2792-3530-3 62-2892-8530-6 62-2792-8530-8
LSB60 (Gray)	Tough durable bonds High impact resistance	1:1	30,000	90 minutes	10 hours	15 (27)	3,400 (23)	4,500 (31)	900 (6)	400mL 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-051115-63411-6 00-051115-63416-1 00-051115-63414-7 00-051115-63418-5 00-051115-63417-8	62-3554-3532-2 62-3654-8532-5 62-3554-8532-7 62-3654-9532-4 62-3554-9532-6
LSB60NS (Gray)	Tough durable bonds Non-sag High impact resistance	1:1	180,000	90 minutes	10 hours	30 (53)	3,800 (26)	4,500 (31)	800 (6)	400mL 5 gal. pail A 5 gal. pail B	00-051115-63426-0 00-051115-63428-4 00-051115-63427-7	62-3562-3532-5 62-3662-8532-8 62-3562-8532-0
LSB360NS (Green)	Tough durable bonds Non-sag Extra long work life Bonds oily metals	1:1	Paste	10 hours	16 hours	30 (53)	4,000 (28)	3,900 (27)	800 (6)	400mL 55 gal. drum A 55 gal. drum B	00-051111-64291-3 00-051115-64360-6 00-051115-64391-0	62-3560-3530-3 62-3660-9530-5 62-3560-9530-7

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™ Heat-Cured Epoxies

Product (Color)	Key Features	Approximate Viscosity at 75°F/24°C (cp)		Cure Conditions		Overlap Shear: psi (MPa)				Size	UPC	Stock #
		Time (min.)	Temp. F (C)	Temp. F (C)	Temp. F (C)	Temp. F (C)	Temp. F (C)	Temp. F (C)	Temp. F (C)			
1386 (Cream)	High temperature strength Impact resistance	150,000	60	350 (177)	10 (18)	3,000 (21)	5,500 (38)	4,500 (31)	2,500 (17)	1 quart	00-021200-19917-2	62-1386-6525-2
1469 (Cream)	High temperature strength Low viscosity	60,000	120	350 (177)	2 (4)	3,150 (22)	3,700 (26)	3,700 (26)	3,600 (25)	1 quart 5 gal. pail	00-021200-19949-3 00-021200-19950-9	62-1469-6525-6 62-1469-8525-4
2214 Hi-Density (Gray)	High temperature strength Low temp curing	Paste	40	250 (121)	5 (9)	3,000 (21)	4,500 (31)	4,500 (31)	1,700 (12)	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 (4)	2,800 (19)	2,800 (19)	2,800 (19)	2,500 (17)	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 (4)	2,000 (14)	2,000 (14)	3,000 (21)	2,500 (17)	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 (12)	3,000 (21)	4,000 (28)	4,500 (31)	1,500 (10)	2 oz. tube 6 oz. cart.	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 (9)	3,000 (21)	4,500 (31)	4,500 (31)	1,500 (10)	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)	5 (9)	5,000 (34)	5,000 (34)	3,500 (24)	1,200 (8)	Gallon cont. 5 gal. pail 55 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

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™ 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

KEY PRODUCT	Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #	
							2,500 (17)	3,500 (24)	2,200 (15)				
													-20°F (-29°C)
	DP805 (Off-White)	Fast strength build Minimal surface prep	1:1	110,000	3 minutes	10 minutes	35 (62)	2,500 (17)	3,500 (24)	2,200 (15)	48.5mL 200mL	00-638060-08982-8 00-021200-87828-2	62-3288-1436-3 62-3288-3830-5
	DP820 (Light Yellow)	Tough durable bonds Minimal surface prep	1:1	55,000	15 minutes	40 minutes	20 (36)	3,100 (21)	3,150 (22)	1,900 (13)	48.5mL 200mL 400mL	00-638060-08977-4 00-021200-89348-3 00-021200-89349-0	62-3277-1436-6 62-3277-3830-8 62-3277-3530-4
	DP8405NS 8405NS (Green)	High impact Adhesion to most plastics	10:1	70,000	5 minutes	15 minutes	50 (89)	2,600 (18)	4,100 (28)	900 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-68963-5 00-051115-68964-2 00-051115-68981-9 00-051115-68986-4 00-051115-68980-2 00-051115-68987-1	62-2856-1445-9 62-2856-3630-4 62-2952-7530-9 62-2856-8530-1 62-2952-8530-8 62-2856-9530-0
	DP8407NS 8407NS (Gray)	High impact Adhesion to most plastics	10:1	20,000	7 minutes	24 minutes	50 (89)	3,400 (23)	4,500 (31)	1,400 (10)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-076308-86273-2 00-076308-86285-5 00-076308-86366-1 00-076308-86306-7 00-076308-86367-8 00-076308-98878-4	62-2853-1445-6 62-2853-3630-1 62-2953-7530-7 62-2853-8530-8 62-2953-8530-6 62-2853-9530-7
	DP8410NS 8410NS (Green)	High impact Adhesion to most plastics	10:1	70,000	10 minutes	25 minutes	50 (89)	3,600 (25)	4,100 (28)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-70994-4 00-051115-70995-1 00-051115-68981-9 00-051115-70997-5 00-051115-68980-2 00-051115-71101-5	62-2860-1445-1 62-2860-3630-6 62-2952-7530-9 62-2860-8530-3 62-2952-8530-8 62-2860-9530-2
	DP8425NS 8425NS (Green)	High impact Adhesion to most plastics	10:1	70,000	25 minutes	50 minutes	50 (89)	3,800 (26)	3,700 (26)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-81303-0 00-051115-81302-3 00-051115-68981-9 00-051115-81298-9 00-051115-81414-3 00-051115-81031-6	62-2862-1445-7 62-2862-3630-2 62-2952-7530-9 62-2862-8530-9 62-2962-8530-7 62-2862-9530-8

# 3M™ Scotch-Weld™ Low Odor Acrylics

	DP810 810 (Black)	Tough durable bond High impact resistance	1:1	20,000	10 minutes	20 minutes	30 (53)	1,200 (8)	3,600 (25)	500 (3)	48.5mL 200mL 1 gallon pail A 1 gallon pail B 4.4 gal. pail A 4.4 gal. pail B	00-638060-08967-5 00-021200-49079-8 00-048011-56712-9 00-048011-56711-2 00-021200-49081-1 00-021200-49080-4	62-2788-1436-3 62-2788-3830-5 62-2888-7530-5 62-2788-7530-7 62-2888-8730-0 62-2788-8730-2
	DP810 810 (Tan)	Tough durable bonds High impact resistance	1:1	20,000	10 minutes	20 minutes	30 (53)	1,200 (8)	3,600 (25)	500 (3)	48.5mL 200mL 400mL 4.4 gal. pail A 4.4 gal. pail B	00-638060-08986-6 00-021200-31311-0 00-021200-31312-7 00-021200-45233-8 00-021200-45230-7	62-3298-1436-2 62-3298-3830-4 62-3298-3530-0 62-3398-8730-9 62-3298-8730-1
	DP810NS 810NS (Tan)	Tough durable bonds Non-sag	1:1	95,000	10 minutes	20 minutes	20 (36)	1,200 (8)	4,000 (28)	500 (3)	48.5mL 200mL 400mL	00-638060-08969-9 00-021200-49084-2 00-021200-49083-5	62-2799-1436-0 62-2799-3830-2 62-2799-3530-8
	DP8805NS 8805NS (Green)	Low odor Fast rate of strength build	10:1	80,000	5 minutes	10 minutes	30 (53)	800 (5)	3,600 (25)	900 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-076308-98433-5 00-076308-98439-7 00-051115-81415-0 00-076308-98440-3 00-051115-81414-3 00-076308-98441-0	62-2852-1446-6 62-2852-3631-1 62-2962-7530-8 62-2852-8531-8 62-2962-8530-7 62-2852-9531-7
	DP8810NS 8810NS (Green)	Low odor Fast rate of strength build	10:1	80,000	10 minutes	20 minutes	30 (53)	900 (6)	3,600 (25)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051128-99432-0 00-051128-99431-3 00-051115-81415-0 00-076308-98442-7 00-051115-81414-3 00-076308-98443-4	62-2854-1446-2 62-2852-3631-7 62-2962-7530-8 62-2854-8531-4 62-2962-8530-7 62-2854-9531-3
	DP8810NS (Gray)	Low odor Fast rate of strength build	10:1	80,000	10 minutes	20 minutes	30 (53)	900 (6)	3,600 (25)	800 (6)	45mL 490mL	00-076308-86152-0 00-076308-98485-4	62-2858-1450-5 62-2858-3631-8
	DP8825NS 8825NS (Green)	Low odor Fast rate of strength build	10:1	80,000	25 minutes	50 minutes	20 (36)	1,000 (7)	3,000 (21)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-81288-0 00-051115-81289-7 00-051115-81415-0 00-051115-81290-3 00-051115-81414-3 00-051115-81291-0	62-2866-1445-8 62-2866-3630-3 62-2962-7530-8 62-2866-8530-0 62-2962-8530-7 62-2866-9530-9

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™ 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)			Size	UPC	Stock #
								-20°F (-29°C)	75°F (24°C)	150°F (66°C)			
								875 (6)	2,000 (14)	475 (3)			
DP8005 (Black)	Bonds polyolefins and low surface energy materials	10:1	25,000	3 minutes	3 hours	N/A	875 (6)	2,000 (14)	475 (3)	45mL 490mL	00-051128-99352-1 00-051128-99298-2	62-2779-1445-3 62-2779-3630-8	
DP8005 (Off-White)	Bonds polyolefins and low surface energy materials	10:1	25,000	3 minutes	3 hours	N/A	750 (5)	2,200 (15)	500 (3)	45mL 490mL	00-051128-99349-1 00-051128-99297-5	62-2786-1445-8 62-2786-3630-3	
DP8010 (Blue)	Bonds polyolefins and low surface energy materials	10:1	20,000	10 minutes	1 hour	N/A	2,700 (19)	2,700 (19)	500 (3)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-71600-3 00-051115-71601-0 00-021200-49113-9 00-051115-71669-0 00-021200-49115-3 00-076308-14203-2	62-2863-1445-5 62-2863-3630-0 62-2883-7530-6 62-2863-8530-7 62-2883-8530-5 62-2863-9532-2	
DP8010NS (Blue)	Bonds polyolefins and low surface energy materials Non-sag	10:1	65,000	10 minutes	1 hour	N/A	2,700 (19)	2,700 (19)	500 (3)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 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™ 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)			
								3,200 (22)	2,300 (16)	700 (5)			
DP600 (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 400mL 8.4 fl. oz. 5 gal. pail A 5 gal. pail B	00-638060-08962-0 00-051111-98303-4 00-021200-96596-8 00-021200-96575-3 00-021200-96574-6	62-2649-5032-0 62-2649-3530-5 62-2649-1233-8 62-2749-8535-7 62-2649-8535-9	
DP600NS (Gray)	Concrete repair Non-sag	1:1	Paste	1 minute	4 minutes	8 (14)	2,700 (19)	2,300 (16)	700 (5)	48.5mL 400mL	00-638060-08964-4 00-051111-98312-6	62-2652-5032-4 62-2652-3530-9	
DP601 (Gray)	Rigid Self-leveling	1:1	6,000	1 minute	4 minutes	20 (36)	3,200 (22)	2,300 (16)	700 (5)	48.5mL 50 gal. drum A 50 gal. drum B	00-638060-08963-7 00-021200-96508-1 00-021200-96507-4	62-2649-5033-8 62-2749-9530-7 62-2649-9530-9	
DP601NS (Gray)	Rigid Non-sag	1:1	Paste	1 minute	4 minutes	8 (14)	2,700 (19)	2,300 (16)	700 (5)	48.5mL	00-638060-08965-1	62-2652-5033-2	
DP605NS (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 200mL 5 gal. pail A 5 gal. pail B	00-638060-08997-2 00-021200-87853-4 00-021200-82254-4 00-021200-82253-7	62-3592-1436-8 62-3592-3830-0 62-3692-8530-9 62-3592-8530-1	
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 400mL 5 gal. pail A 5 gal. pail B 50 gal. drum A 50 gal. drum B	00-076308-86407-1 00-076308-86398-2 00-076308-86782-9 00-076308-86748-5 00-076308-86783-6 00-076308-86749-2	62-3590-1448-7 62-3590-3630-8 62-3690-8530-3 62-3590-8530-5 62-3690-9530-2 62-3590-9530-4	
DP6330NS (Green)	Multi-purpose Energy absorbing	1:1	Non-sag paste	30 minutes	2 hours	20 (36)	3,600 (25)	3,600 (25)	1,000 (7)	48.5mL 400mL 5 gal. pail A 5 gal. pail B 50 gal. drum A 50 gal. drum B	00-076308-86431-6 00-076308-86433-0 00-076308-86780-5 00-076308-86701-0 00-076308-86781-2 00-076308-86727-0	62-3565-1448-9 62-3565-3630-0 62-3605-8530-1 62-3635-8530-7 62-3605-9530-0 62-3565-9530-6	
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 Quart kit 5 gal. pail A 5 gal. pail B	00-021200-20878-2 00-021200-20879-9 00-021200-20935-2 00-021200-20881-2	62-3532-0515-6 62-3532-6430-2 62-3632-8516-4 62-3532-8515-8	
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 Quart kit 5 gal. pail A 5 gal. pail B	00-021200-20887-4 00-021200-20888-1 00-051111-07486-2 00-051111-07485-5	62-3535-0515-9 62-3535-6430-5 62-3635-8530-8 62-3535-8530-0	



# 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 400mL 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-638060-08961-3 00-051111-98301-0 00-021200-96462-6 00-021200-96461-9 00-076308-14205-6 00-076308-87087-4	62-2648-5031-4 62-2648-3530-7 62-2748-8530-0 62-2648-8530-2 62-2748-9531-7 62-2648-9531-9
* 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 5 gal. pail A 5 gal. pail B 55 gal. drum A 55 gal. drum B	00-638060-08960-6 00-076308-14144-8 00-076308-14135-6 00-076308-14135-5 00-076308-14146-3	62-2645-5031-0 62-2745-8531-4 62-2645-8531-6 62-2745-9531-3 62-2645-9531-5
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 400mL	00-638060-08991-0 00-021200-89544-9	62-3549-1436-8 62-3549-3530-6
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 Quart kit 5 gal. pail A 5 gal. pail B	00-021200-20901-7 00-021200-20902-4 00-021200-20942-0 00-021200-20904-8	62-3549-0501-0 62-3549-6401-7 62-3649-8501-0 62-3549-8501-2
DP5001 5001 (Black)	Flexible Conveyor belt repair	1:1	100,000	1 minute	15 minutes	N/A	N/A	600 (4)	N/A	48.5mL 400mL	00-638060-08988-0 00-051111-98296-9	62-3528-5033-3 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 (8)	N/A	400mL 5 gal. pail A 5 gal. pail B	00-051111-98297-6 00-021200-96584-5 00-021200-96583-8	62-3527-3530-2 62-3527-9535-4 62-3627-8535-6

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™ 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 @ 250°F (121°C) (cp)	Approximate Open Time at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Shore D	Elongation %	Size	UPC	Stock #
EZ250015 (Off-White)	Fast set time	7,000	1.5 minutes	15 seconds	65	750	1/10 gal. 5 gal.	00-051115-23545-0 00-051115-23546-7	62-3850-5230-3 62-3850-8530-3
EZ250060 (Off-White)	Medium set time	7,000	2 minutes	60 seconds	60	675	1/10 gal. 5 gal.	00-051115-23550-4 00-051115-23551-1	62-3852-5230-9 62-3852-8530-9
EZ250120 (Off-White)	Medium set time Low viscosity Thin bond lines	3,000	4 minutes	120 seconds	60	625	1/10 gal.	00-051115-23554-2	62-3853-5230-7
TE015 (Off-White)	Fast set time	7,000	1.5 minutes	15 seconds	65	750	1/10 gal. 2 kilo 5 gal.	00-051115-25156-6 00-076308-14109-7 00-021200-39211-5	62-3464-5238-6 62-3464-6830-9 62-3464-8530-3
TE030 (Off-White)	Fast set time High viscosity	16,000	1 minute	30 seconds	60	725	1/10 gal. 5 gal. 55 gal. drum	00-051115-25157-3 00-021200-82484-5 00-021200-82483-8	62-3876-5238-1 62-3876-8530-8 62-3876-9530-7
* TE100 (Off-White)	Medium set time Thin bond lines	7,000	2 minutes	60 seconds	61	675	1/10 gal. 5 gal.	00-051115-25161-0 00-021200-87244-0	62-3889-5238-4 62-3889-8530-1
TE200 (Off-White)	Medium set time Low viscosity Thin bond lines	3,000	4 minutes	120 seconds	60	625	1/10 gal. 2 kilo	00-051115-25164-1 00-048011-53272-1	62-3894-5238-4 62-3894-6839-8

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

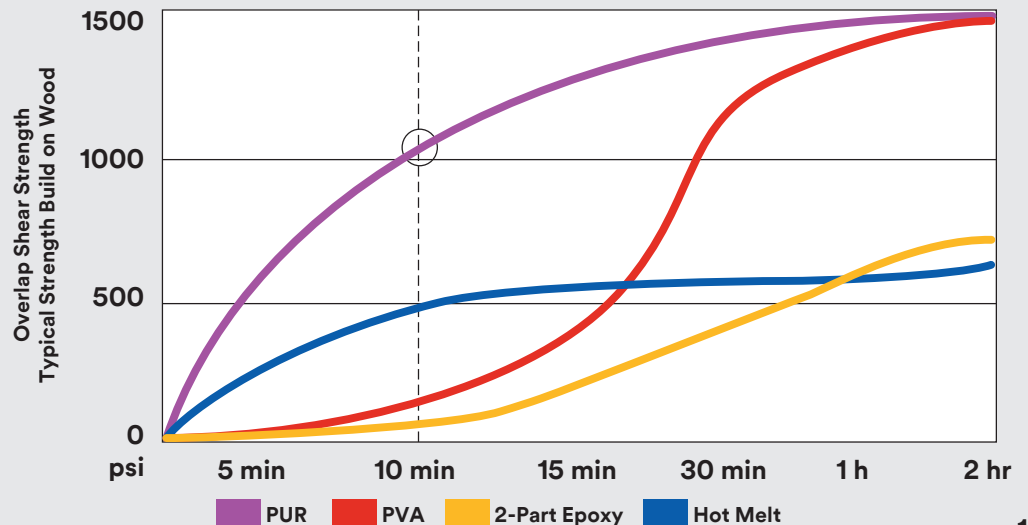
**KEY PRODUCT** Denotes product to consider first in this category \* After Key Products, consider these.

**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™ 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 (121°C)	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 00-051115-23542-9	62-3851-5230-1 62-3851-8530-1
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 00-051115-23562-7 00-051115-23560-3	62-3854-5230-5 62-3854-6839-2 62-3854-8530-5
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 00-048011-57401-1	62-3891-5230-7 62-3891-6839-4
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 00-021200-89573-9	62-3887-5238-8 62-3887-8530-5
* 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 00-048011-53355-1 00-021200-83695-4	62-3886-5238-0 62-3886-6839-4 62-3886-8530-7
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	00-051115-64536-5 00-051115-64430-6	62-3858-5238-9 62-3898-6839-9
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.	00-051115-25160-3 00-021200-25343-0	62-3898-5238-5 62-3898-8530-2
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	62-3860-8530-2
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. 2 kilo 5 gal. 55 gal. drum	00-051115-25163-4 00-048011-53274-5 00-021200-89451-0 00-021200-89452-7	62-3892-5238-8 62-3892-6839-2 62-3892-8530-5 62-3892-9531-2
TS230 (Black)	Extrudable/sprayable, long open time, bonds plastics to metal, glass, and wood	9,000	4 minutes	150 seconds	45	700	1/10 gal. 2 kilo 5 gal.	00-051115-25166-5 00-048011-53273-8 00-021200-89583-8	62-3897-5238-7 62-3897-6839-1 62-3897-8530-4
KEY PRODUCT TS230 (Off-White)	Extrudable/sprayable long open time, bonds plastics to metal, glass, and wood	9,000	4 minutes	150 seconds	45	700	1/10 gal. 2 kilo 5 gal. 55 gal. drum	00-051115-25165-8 00-048011-53271-4 00-021200-83640-4 00-021200-83639-8	62-3870-5238-4 62-3870-6839-8 62-3870-8530-1 62-3870-9530-0
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	62-3733-8530-1

# 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	62-9865-9930-6
Preheater	PUR Easy 250 Preheater, preheats up to four 1/10 gal. cartridges, 120V, Dual Temp	00-051115-23564-1	62-9865-9935-5
System Accessories for hands-free dispensing	Applicator Bench Mount Bracket Assembly (bracket only) Hot Melt Applicator Foot Pedal Assembly 9277	00-021200-30086-8 00-021200-82278-0	62-9895-9950-1 62-9277-9930-4
Cartridge Nozzle	High Temperature Nozzles for PUR 1/10 gal. cartridges (Sample, 5/bag)		78-8132-7930-0
Repair Kits and Replacement Parts	Adhesive Applicator Housing/Shroud Assembly Kit Applicator Nozzle Shroud Benchmount Quick Exhaust Assembly Replacement Kit Applicator Air Coupler Filter Kit Applicator Air Supply Line Kit Applicator Air Valve Kit Applicator Swivel Connector Applicator End Cap Applicator Heat Tube Assembly (120V) Kit Applicator Heat Tube (240V) Applicator On/Off Switch Kit Applicator Power Cord Kit (120V) Applicator Wire Stand High Temperature (250 Degrees F) PUR Preheater Thermostat/TCO Kit Low Temperature (170 Degrees F) PUR Preheater Thermostat/TCO Kit	00-051115-25783-4 00-048011-58320-4 00-021200-31357-8 00-021200-89475-6 00-021200-89479-4 00-048011-57410-3 00-048011-58298-6 00-021200-89476-3 00-021200-89486-2 00-021200-25303-4 00-021200-89482-4 00-021200-89481-7 00-021200-89483-1 00-051115-23619-8 00-051115-23618-1	62-9865-9950-4 62-9845-0029-8 62-9895-9952-7 62-9895-0001-2 62-9895-0005-3 62-9845-0009-0 62-9845-9934-0 62-9895-0003-8 62-9895-0023-6 62-9895-0043-4 62-9895-0024-4 62-9895-0021-0 62-9895-0033-5 62-9865-9938-9 62-9865-9990-0

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.



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

Product	Description	UPC	Stock #
Alternate Nozzle System not for use with disposable nozzles	Applicator Main Nozzle Assembly (includes nozzle, tip, tip cap and valve) Applicator Main Nozzle Applicator Extension Tip, .072 in orifice Applicator Tip, .125 in orifice Applicator Tip, .063 in orifice Applicator Tip Cap Applicator Valve Assembly	00-021200-89514-2 00-021200-89515-9 00-021200-89471-8 00-021200-89473-2 00-021200-89472-5 00-021200-87194-8 00-021200-83730-2	62-9895-0019-4 62-9895-0018-6 62-9895-0015-2 62-9895-0017-8 62-9895-0016-0 62-9773-0014-4 62-9773-0012-8

## 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
PR100 (Clear)	General purpose, low viscosity plastic bonder	100	-65° to 180°F (-54° to 82°C)	10-20 sec.	24	20 gram bottle 500 gram bottle 500 gram bottle, 25/CV 2 kilo bottle	00-051115-25214-3 00-051115-25213-6 00-051115-25939-5 00-051111-07176-2	62-6164-0360-6 62-6164-3860-2 62-6164-3865-1 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 gram bottle 500 gram bottle	00-051115-25241-9 00-051115-25240-2	62-6182-0862-3 62-6182-3860-4
PR1500 (Clear)	General purpose, high viscosity for gap filling	1,500	-65° to 180°F (-54° to 82°C)	20-60 sec.	24	2 gram tube 20 gram bottle 500 gram bottle 500 gram bottle, 25/CV	00-051115-25202-0 00-051115-25222-8 00-051115-25221-1 00-076308-14147-9	62-6137-0260-4 62-6165-0360-3 62-6165-3860-9 62-6165-3866-6

KEY PRODUCT

## 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	3 gram tube 20 gram bottle 500 gram bottle	00-051115-25290-7 00-051115-25268-6 00-051115-25267-9	62-6176-0363-4 62-6176-0360-0 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

LO100 (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 bottle 500 gram bottle	00-048011-62732-8 00-051115-25188-7	62-6128-0360-1 62-6128-3860-7
LO1000 (Clear)	General purpose, high viscosity with reduced odor and blooming, suitable for minor gap filling	1,000	-65° to 180°F (-54° to 82°C)	20-25 sec	24	20 gram bottle 500 gram bottle	00-051111-91664-3 00-048011-62738-0	62-6132-0360-3 62-6132-3860-9

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

EI 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 cont.	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

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

Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
SF20 (Clear)	Fast cure Optimum performance on wide range of rubbers and plastics	20	-65° to 180°F (-54° to 82°C)	4-30 sec.	24	20 gram bottle 500 gram 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	3 gram tube 20 gram bottle 500 gram bottle	00-048011-62630-7 00-048011-62631-4 00-048011-62629-1	62-6174-0363-9 62-6174-0361-3 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	00-051111-91665-0 00-051115-25200-6	62-6135-0360-6 62-6135-3860-2
-----------------	--------------------------------------------------------------------------------	-------	------------------------------	--------	----	-----------------------------------	----------------------------------------	----------------------------------

## 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	20 gram bottle 500 gram bottle	00-051111-91663-6 00-048011-62634-5	62-6130-0360-7 62-6130-3860-3
---------------	----------------------------	-----	------------------------------	-----------	----	-----------------------------------	----------------------------------------	----------------------------------

## 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 cart.	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

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

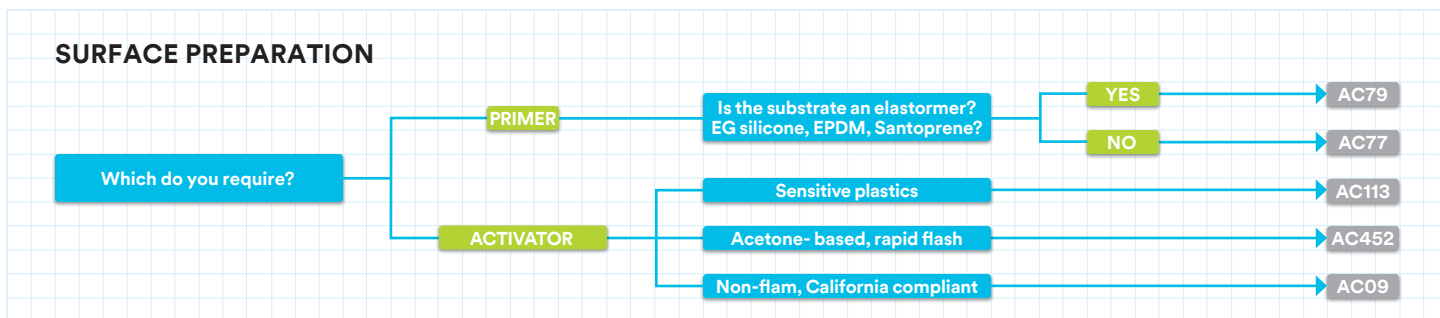
Product (Color)	Key Features	Typical Viscosity (cP)	Time to Handling	Full Cure (Hours)	Size	UPC	Stock #
AC09	Instant adhesive activator Non-flammable, solvent-based California compliant	1	1-5 sec.	24	2 fl. oz. bottle 1 liter can	00-051111-07795-5 00-051111-07908-9	62-6198-0860-3 62-6198-8361-4
AC77	Instant 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	00-048011-62728-1 00-048011-62653-6	62-3907-0860-0 62-3907-7560-9
AC79	Instant adhesive primer for bonding of difficult-to-bond elastomers such as silicone, fluoroelastomer and EPDM VOC compliant	2	1-5 sec.	24	2 fl. oz. bottle 8 fl. oz. bottle 4 liter can	00-051115-31388-2 00-051115-31389-9 00-051115-31390-5	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 1 liter 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 4 liter can	00-048011-62685-7 00-048011-62686-4 00-048011-62689-5	62-6195-0860-9 62-6195-3760-8 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

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™ 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™ Plastic and Rubber Instant Adhesives

The PR (Plastic & Rubber) series of products bonds to most plastics and rubbers with a range of viscosities that will fit all your application needs. Just a single drop per square inch bonds several thousand pounds of holding power. They provide proven, world record strength with a hold of 8 metric tons. PR40, PR100, PR600, PR1500 and PRGel



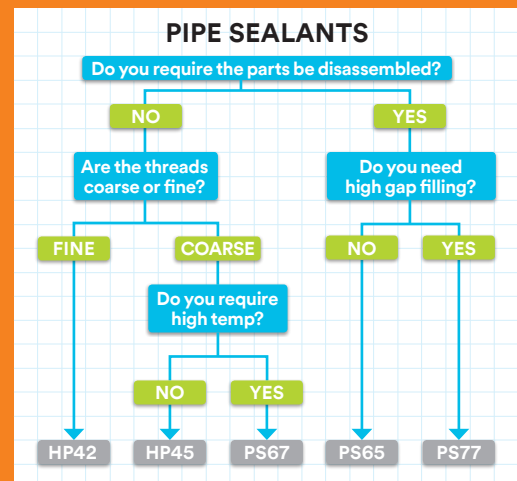
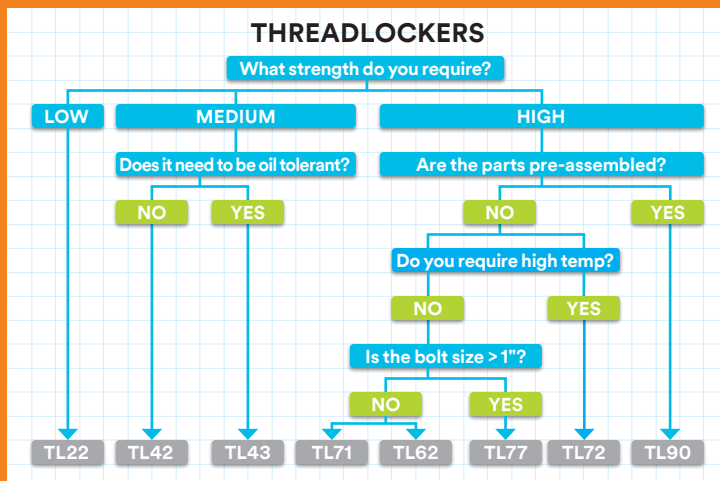


# 3M™ Scotch-Weld™ Anaerobic Adhesives – Threadlockers

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 50mL bottle 250mL bottle	00-048011-62601-7 00-048011-62602-4 00-048011-62603-1	62-3493-1060-7 62-3493-5060-3 62-3493-3960-6
TL42 (Blue)	Nutlock - medium strength, general purpose	1,200	-65° to 300°F (-54° to 149°C)	< 30 minutes	24	1mL pipette 10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-048011-62604-8 00-048011-62605-5 00-048011-62606-2 00-048011-62607-9 00-051115-25124-5	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)	< 30 minutes	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)	< 30 minutes	24	10mL bottle 50mL bottle 250mL bottle	00-048011-62609-3 00-048011-62610-9 00-048011-62611-6	62-3495-1060-2 62-3495-5060-8 62-3495-3960-1
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 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)	< 30 minutes	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 62-3497-3961-5 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)	< 30 minutes	24	10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-051115-25142-9 00-051115-25143-6 00-051115-25144-3 00-076308-14204-9	62-3429-1060-1 62-3429-5060-7 62-3429-3960-0 62-3429-8361-6
TL90 (Green)	Penetrating adhesive for pre-assembled fasteners and porosity sealing of welds	20	-65° to 300°F (-54° to 149°C)	< 30 minutes	24	10mL bottle 50mL bottle 250mL bottle 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 Sealants

HP42 (Brown)	Medium strength sealant for hydraulic and pneumatic fittings with fine threads	400-800	-65° to 300°F (-54° to 149°C)	< 30 minutes	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)	< 30 minutes	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)	2-5 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	00-048011-62714-4 00-048011-62715-1	62-3478-5067-9 62-3478-3967-2
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 250mL tube	00-054007-99635-4 00-054007-99636-1	62-3707-5067-1 62-3707-3967-4



## 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 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 62-3435-8360-5
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	Medium viscosity, high strength, fast curing formulation	600	-65° to 300°F (-54° to 149°C)	15-20 mins	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 Makers

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 minutes	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 minutes	24	300 gram cart. 50mL tube	00-048011-62660-4 00-048011-62658-1	62-3454-3362-7 62-3454-5067-0
GM74 (Orange)	Form-in-place gasketing product designed for multi-purpose applications on rigid metal flanges and surfaces	Paste	-65° to 300°F (-54° to 149°C)	< 30 minutes	24	50mL bottle, 10/CV	00-054007-99634-7	62-3459-5067-9

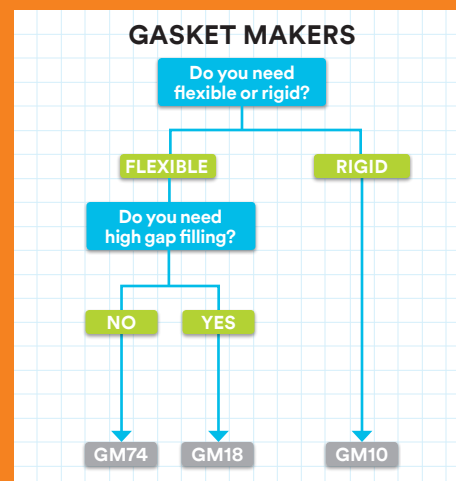
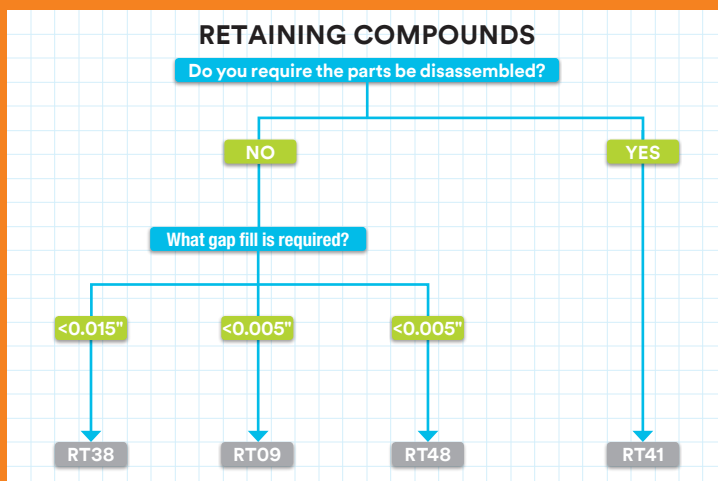
## 3M™ Scotch-Weld™ Anaerobic Adhesives – Activators

AC649 (Green)	Acetone-based green primer for inactive or very cold surfaces 30-day part life for pre-application California compliant	<3	N/A	<5 minutes	24	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
---------------	-------------------------------------------------------------------------------------------------------------------------------	----	-----	------------	----	-----------------------------------------------------	-------------------------------------------------------------	----------------------------------------------------



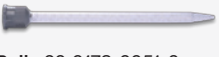






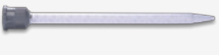


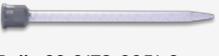



For lead times on bulk adhesives, please contact your 3M representative.

**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™ EPX™ Applicators and Nozzles

		Replacement Plunger Orders							Static Mixing 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)	490 mL (10:1)		
<b>3M™ Scotch-Weld™ EPX™ Plus II Applicator*</b>  Stock #: 62-9170-9932-7 UPC: 00-063806-01001-7  *Includes 1:1, 2:1 and 10:1 plunger.	<b>1:1/2:1 Shared Plunger</b> Stock #: 62-9170-9913-7 UPC: 00-063806-01000-0		✓	✓					<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 48.5mL/50mL Stock #: 62-9154-9148-4 UPC: 0-00-76308-86434-7	 Bulk: 62-9171-9954-9 Bulk: 0-00-63806-01003-1
			✓	✓					<b>3M™ EPX™ Mixing Nozzle</b> Helical White, 48.5mL/50mL Stock #: 62-9178-9151-7 UPC: 00-063806-01004-8	 Bulk: 62-9178-9951-0 Bulk: 00-063806-01005-5
	<b>2:1 Plunger</b> Used only for <b>2216 epoxy</b> Stock #: 62-9170-9922-8 UPC: 0-00-76308-86390-6	✓							<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 43mL Stock #: 62-9171-9153-8 UPC: 0-00-21200-50008-4	 Bulk: 62-9171-9953-1 Bulk: 0-00-21200-50009-1
	<b>10:1 Plunger</b> Stock #: 62-9160-9911-2 UPC: 0-00-76308-86391-3	✓							<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Orange, 45mL Stock #: 62-9154-9136-9 UPC: 0-00-51115-81449-0	 Bulk: 62-9178-9950-2 Bulk: 0-00-51115-81467-9
<b>3M™ EPX™ Metal Applicator</b>  Stock #: 62-9740-9935-0 UPC: 0-00-21200-21789-0		✓							<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 43mL Stock #: 62-9171-9153-8 UPC: 0-00-21200-50008-4	 Bulk: 62-9171-9953-1 Bulk: 0-00-21200-50009-1
	<b>2:1 Plunger</b> Stock #: 62-9744-9930-3 UPC: 0-00-21200-82314-5								<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical White, 43mL Stock #: 62-9178-9150-9 UPC: 0-00-51115-81449-5	 Bulk: 62-9178-9950-2 Bulk: 0-00-51115-81467-9
				✓					<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 43mL/48.5mL Stock #: 62-9154-9148-4 UPC: 0-00-76308-86434-7	 Bulk: 62-9171-9954-9 Bulk: 0-00-63806-01003-1
				✓					<b>3M™ EPX™ Mixing Nozzle</b> Helical White, 48.5mL/50mL Stock #: 62-9178-9151-7 UPC: 00-063806-01004-8	 Bulk: 62-9178-9951-0 Bulk: 00-063806-01005-5
<b>3M™ EPX™ Pneumatic Applicator 48.5/50 mL</b>  Stock #: 62-9781-9931-3 UPC: 00-063806-01006-2	N/A		✓	✓					<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 43mL/48.5mL Stock #: 62-9154-9148-4 UPC: 0-00-76308-86434-7	 Bulk: 62-9171-9954-9 Bulk: 0-00-63806-01003-1
			✓	✓					<b>3M™ EPX™ Mixing Nozzle</b> Helical White, 48.5mL/50mL Stock #: 62-9178-9151-7 UPC: 00-063806-01004-8	 Bulk: 62-9178-9951-0 Bulk: 00-063806-01005-5
<b>3M™ Scotch-Weld™ EPX™ Manual Applicator 200 mL</b>  Stock #: 62-9136-9930-2 UPC: 0-00-21200-87977-7	<b>1:1/2:1 Shared Plunger</b> Stock #: 62-9136-9938-5 UPC: 0-00-21200-87981-4				✓	✓			<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Gold, 200mL and 400mL Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4	 Bulk: 62-9176-9127-1 Bulk: 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	 Bulk: 62-9142-9930-0 Bulk: 0-00-21200-87982-1



# 3M™ EPX™ Applicators and Nozzles

		Replacement Plunger Orders						Static Mixing Nozzle Options	
		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)	490 mL (10:1)		
<b>3M™ EPX™ 200, 400 mL Manual Applicator</b>    <b>Stock #:</b> 62-9148-9930-7 <b>UPC:</b> 0-00-51111-98073-6	N/A				✓	✓	✓	<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™ 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 							
<b>3M™ EPX™ 490 mL Manual Applicator</b>    <b>Stock #:</b> 62-9182-9930-6 <b>UPC:</b> 0-00-51115-71115-2	N/A						✓	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical Orange, 490mL <b>Stock #:</b> 62-9158-9136-0 <b>UPC:</b> 0-00-51115-69042-6 	
		<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 490mL <b>Stock #:</b> 62-9184-9490-7 <b>UPC:</b> 0-00-51115-81619-2 							
<b>3M™ Scotch-Weld™ EPX™ Pneumatic Applicator 200 mL</b>    <b>Stock #:</b> 62-9140-9930-4 <b>UPC:</b> 0-00-21200-87978-4	N/A				✓			<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™ 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 							
<b>3M™ EPX™ 400 mL Pneumatic Applicator</b>    <b>Stock #:</b> 62-9145-9930-3 <b>UPC:</b> 0-00-21200-87979-1	N/A					✓		<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™ 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 							
<b>3M™ EPX™ 490 mL Pneumatic Applicator</b>    <b>Stock #:</b> 62-9152-9930-9 <b>UPC:</b> 0-00-51115-69041-9	N/A						✓	<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Helical Orange, 490 mL <b>Stock #:</b> 62-9158-9136-0 <b>UPC:</b> 0-00-51115-69042-6 	
		<b>3M™ Scotch-Weld™ EPX™ Mixing Nozzle</b> Square Green, 490 mL <b>Stock #:</b> 62-9184-9490-7 <b>UPC:</b> 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> <b>Stock #:</b> 62-9637-9935-8 <b>UPC:</b> 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.

# Improvements Worth Smiling About

## Taking the toothache out of product assembly



Over the decades, 3M dental technology has been enabling faster visits, fewer repairs and less painful experiences for dental patients.

Manufacturing engineers also wanted those same things in their bonding solutions, so 3M's adhesive and dental labs worked together to improve the manufacturing process when using adhesives. Utilizing 3M dental's proven, enhanced technology, they were able to find a solution that provided a low odor adhesive for manufacturing and assembly, while also improving production time.

No longer delayed by the ache of slow-acting adhesives, 3M has given manufacturing engineers something to smile about.

## 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.

**Technical Information:** The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information. **Product Selection and Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property. **Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. **3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE.** If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price. **Limitation of Liability:** Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



### Industrial Adhesives & Tapes Division

3M Center  
Building 225-3S-06  
St. Paul, MN 55144-1000  
1-800-362-3550  
[www.3M.com/structuraladhesives](http://www.3M.com/structuraladhesives)

3M, Scotch-Weld, EPX and  
Scotch Brite are trademarks of  
3M Company.  
Please recycle. Printed in USA.  
© 2017 3M. All rights reserved.  
78-9236-7114-9