

# 3M™ Scotch-Weld™ Structural Adhesives for Large Structure Bonding



Rivetless  
Weldless  
Screwless  
Worry less

## Truck sides to elevator doors, dependability without holes

### Takes work to put holes in a panel or add burn marks

Why work at creating potential problems for yourself? Holes invite corrosion and leaks. Rivets and screws through those holes concentrate stress and can loosen or fail with vibration. Welding generates fumes and heat for workers and burn ridges that need to be refinished for a smooth panel.

With 3M™ Scotch-Weld™ Structural Adhesives, you reduce work and worries with multiple production and end use benefits:

- Distribute stress uniformly over the bonded area and maintain surface integrity and physical properties of the panel
- Use thinner, lighter panel materials without concerns about distortion, splitting, or crazing
- Secure even small or thin bonding edges such as honeycomb
- Apply in irregular patterns to follow contours and random shapes
- Save work of drilling and surface refinishing; keep panels smooth and clean for a more attractive appearance
- Hold for the long term with resistance to vibration and impact
- Bond dissimilar materials without worries of galvanic corrosion or stresses of different coefficients of thermal expansion/contraction

### Market and Application Ideas

- Honeycomb panels in rail cars, elevators, and aircraft
- Hat channel stiffeners in metal enclosures
- Delivery truck side walls
- Sign facings and cabinets
- Corrugated panels to tube frame



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Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity (cP)	Approximate Mixed Worklife (minutes)	Bell Peel (piw)	Overlap Shear (psi)		
						-67°F (-55°C)	75°F (24°C)	180°F (82°C)
LSB90 (Gray)	High performance Two-part flexible epoxy adhesive	1:1	25,000	90	55	3000	3000	400
LSB60 (Gray)	High performance Two-part toughened epoxy adhesive	1:1	30,000	90	14	2500	4300	800
LSB60NS (Gray)	High performance Two-part toughened epoxy adhesive with flow control	1:1	125,000	90	10	2500	4300	800
807 (Off-White)	Short work life Two-part toughened acrylic adhesive	1:1	50,000	5	20	2000	4300	800
812 (Off-White)	Fast strength build Two-part toughened acrylic adhesive	1:1	50,000	10	20	2100	4800	1000
825 (Off-White)	Medium work life Two-part toughened acrylic adhesive	1:1	50,000	25	20	2700	4500	1000
920 (Off-White)	Two-part toughened epoxy adhesive Bonds to oily metals	2:1	80,000	20	30	4400	3700	800

\*The substrates used for the above testing are etched aluminum. Performance on other substrates will vary. Please see individual product data sheets for more information.

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



Available in bulk or convenient Duo-Pak dispensing cartridges to meet production volume requirements.



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