

3M™ Scotch-Weld™ Structural Adhesives

3M Scotch-Weld™  
Acrylic Low Odor  
Adhesive  
DP8805 NS Green

Product Selection Guide

Matching 3M Structural Adhesives  
to your performance requirements



# Improving Product and Process

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

## Trusted Innovations from Aerospace to Office Space

With over 50 years of experience developing innovative structural adhesives for aerospace, automotive and hundreds of other industries, 3M delivers the solutions you can trust. Our advanced formulations create durable bonds, even on challenging materials or in extreme conditions.

## Advanced Product Designs and Process Innovations

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

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

## 3M Global Service and Support

3M supports our customers with the testing, technology, and training needed to create better products. Our world-wide support staff has the experience you can rely on for everything from structural adhesive selection to process improvement.

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





## Simplifying adhesive decisions for your application

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

### Q: What materials will be bonded?

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

### Q: What is the preferred cure speed?

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

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

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

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

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

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

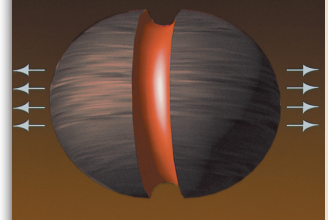
**A:** Structural adhesives come in many forms, including low viscosity liquids and non-sag pastes, one- and two-component formulations, short and long work lives, and various package sizes and shapes. Most two-part structural adhesives are available in both bulk containers and convenient, easy-to-use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

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

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

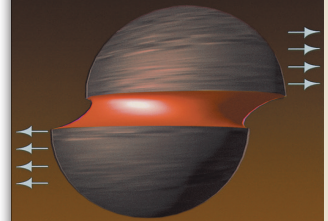
- **Epoxy adhesives** come in both two-part adhesives (that cure upon mixing the two components) and one-part adhesives (that cure with temperature). They generally have the highest strength and overall performance. They also provide the best resistance to high temperatures, solvents and outdoor weathering. They adhere well to metals, woods and concrete, and the flexible epoxy adhesives also bond to some plastics and rubbers. Epoxy adhesives usually require clean, abraded surfaces to obtain maximum bond strength.
- **Acrylic adhesives** are two-part adhesives that provide excellent bond strength and durability, although slightly lower than epoxy adhesives. However, they have several features that make them easier to use in many applications and manufacturing processes. These benefits include a much faster cure speed, higher tolerance for oily or unprepared bonding surfaces and the ability to bond a wide variety of materials, including nearly all plastics. Newer acrylic adhesive formulations are room temperature stable with a long shelf life, and some have much lower odor than regular acrylic adhesives.
- **Urethane adhesives** are two-part adhesives that are relatively flexible when cured, and therefore tend to have excellent impact resistance and good adhesion to most plastics. They also bond well to woods, concrete and rubbers, but they tend to have reduced resistance to solvents and high temperatures. Uncured adhesive components are sensitive to moisture.
- **Cyanoacrylate adhesives** (instant adhesives) are one-component, lower viscosity liquids that cure extremely quickly with just contact pressure and surface moisture. They adhere well, with thin bond lines, to plastics, metals and rubbers. With the use of primers, they can also adhere to low surface energy plastics and elastomers. They tend to have low flexibility, peel strength and impact resistance compared to other structural adhesives. They are generally used for applications such as gasket bonding and smaller assemblies.
- **Anaerobic adhesives** are one-part adhesives that cure on active metal surfaces when oxygen gets excluded from the bond line. These products keep your factory running efficiently, reducing maintenance and leakage. They do not bond well to glass, plastics or rubbers, and are primarily used for applications such as locking threads and sealing pipe connections.

#### Tensile



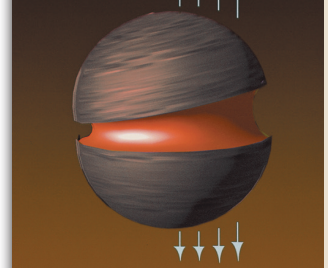
**Tensile** is pull exerted equally over the entire joint. Pull direction is straight and away from the adhesive bond.

#### Shear



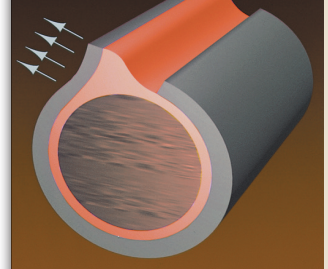
**Shear** is pull directed across the adhesive, forcing the substrates to slide over each other.

#### Cleavage



**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



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



# Key Markets & Applications for 3M™ Scotch-Weld™ Structural Adhesives



## Sporting Goods

### Key Benefits:

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

### Lead Products:

DP420NS Black, DP8810NS, PR100

## Specialty Vehicle

### Key Benefits:

- Reduces weight
- High strength
- Vibration & fatigue resistant

### Lead Products:

DP8810NS, LSB60NS, TL42



## Signage

### Key Benefits:

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

### Lead Products:

DP8805NS, DP8405NS, DP100 Plus

## Metalworking

### Key Benefits:

- High strength
- Reduces surface preparation
- Replaces mechanical fasteners

### Lead Products:

DP420NS Black, DP8410NS, LSB60NS





## Electronics

### Key Benefits:

- Low halogen
- Fast curing
- Potting

### Lead Products:

DP420LH, DP270, DP8805NS, PR100



## Appliance

### Key Benefits:

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

### Lead Products:

DP125 Gray, DP8810NS, TL42



## Aerospace

### Key Benefits:

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

### Lead Products:

2216 Gray, DP100FR, DP640



## Plastic, Composite & Rubber

### Key Benefits:

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

### Lead Products:

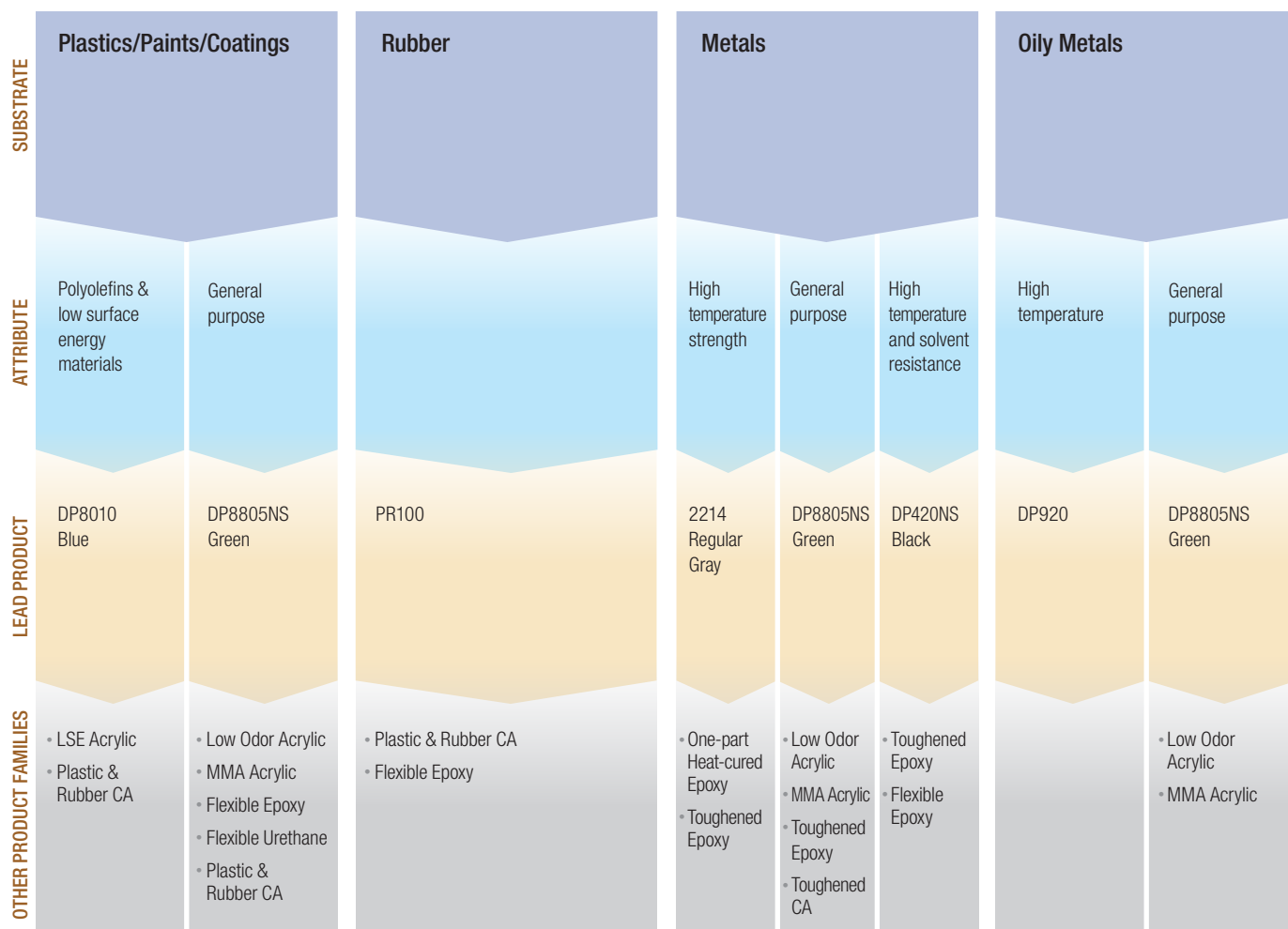
DP8010 Blue, DP420NS, PR100





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

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



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

■ SUBSTRATE   ■ ATTRIBUTE   ■ LEAD PRODUCT   ■ OTHER PRODUCT FAMILIES

## STRUCTURAL ADHESIVE FAMILIES

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

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

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

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

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

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

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

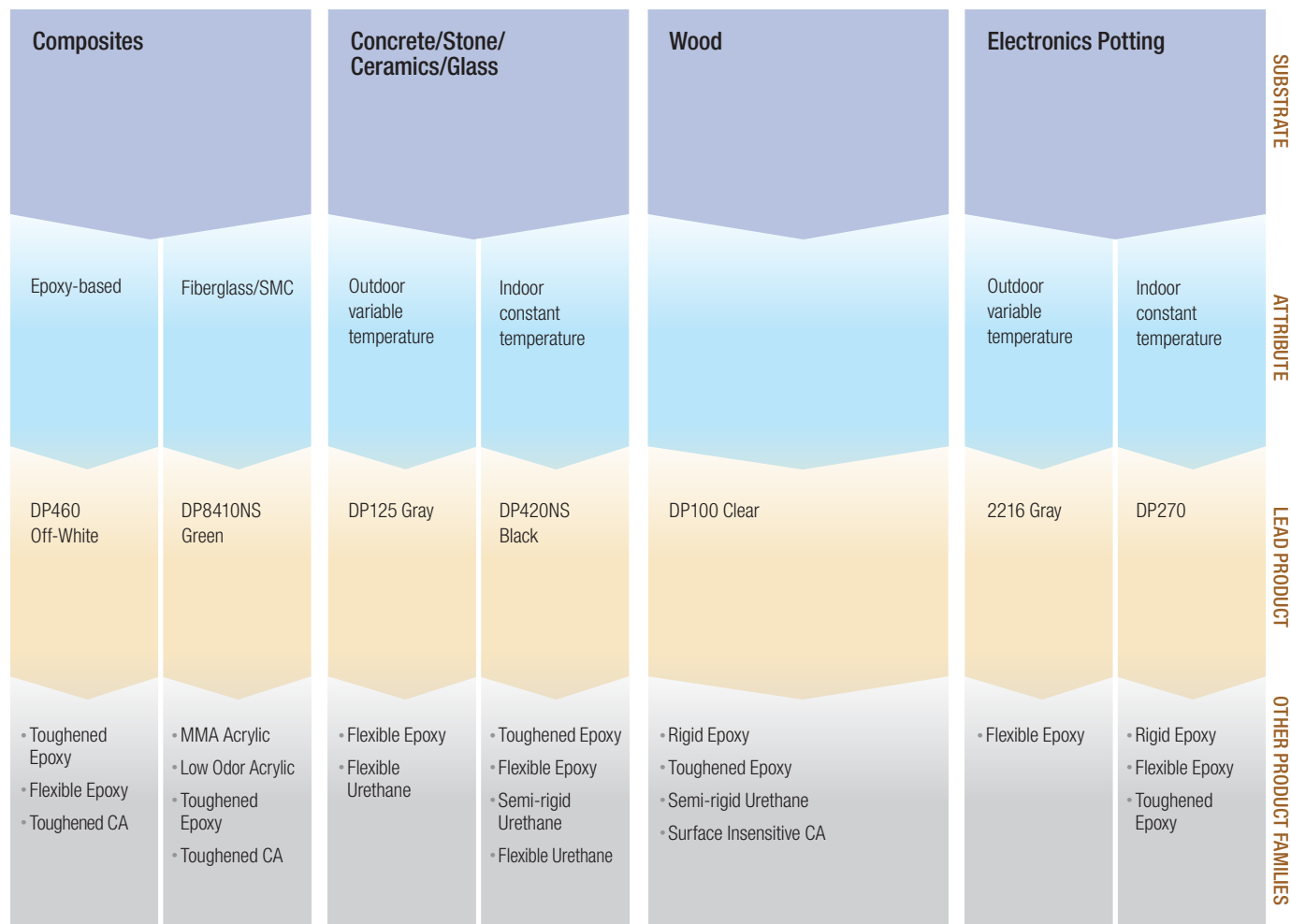
**Semi-rigid Urethane Adhesives** have higher tensile modulus, and lower elongation capability, with greater long-term holding power.

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



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

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



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

■ SUBSTRATE   ■ ATTRIBUTE   ■ LEAD PRODUCT   ■ OTHER PRODUCT FAMILIES

## INSTANT ADHESIVE FAMILIES

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

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

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

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

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

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

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

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

## ANAEROBIC ADHESIVE FAMILIES

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

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

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

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

# Substrate Selector

**Step 1: Select Both Substrates**

**Step 2: Determine Key Attribute**

**Step 3: Select Product Family**

(see charts in back of guide for lead product)

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

■ = Best in Class Product

■ = Suggested Alternate Product

\*with primer



## Work Life vs Viscosity Chart

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



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

3M's Low Odor and MMA Acrylic Adhesives are designed for all of your sign application needs. They provide structural strength, fast cure and environmental resistance – making them the first choice for the sign industry. **DP8805NS, DP8810NS, DP8405NS & DP8410NS**



# 3M™ Scotch-Weld™ Rigid Epoxies

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

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



# 3M™ Scotch-Weld™ Flexible Epoxies

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

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# 3M™ Scotch-Weld™ Toughened Epoxies

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

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# 3M™ Scotch-Weld™ Standard MMA Acrylics

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

# 3M™ Scotch-Weld™ Low Odor Acrylics

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

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

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

# 3M™ Scotch-Weld™ Flexible Urethanes

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

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

|   | Product (Color)           | Key Features                   | Mix Ratio (Volume) B/A | Approximate Viscosity at 75°F (24°C) (cP) | Approximate Mixed Work Life at 75°F (24°C) | Approximate Time to Handling Strength at 75°F (24°C) | Floating Roller Peel at 75°F (24°C) | Overlap Shear (psi) |             |              | Size                                                                       | UPC                                                                                                   | Stock #                                                                                |
|---|---------------------------|--------------------------------|------------------------|-------------------------------------------|--------------------------------------------|------------------------------------------------------|-------------------------------------|---------------------|-------------|--------------|----------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------|
|   |                           |                                |                        |                                           |                                            |                                                      |                                     | -40°F (-40°C)       | 75°F (24°C) | 180°F (82°C) |                                                                            |                                                                                                       |                                                                                        |
| * | DP600 600 (Gray)          | Concrete repair Self-leveling  | 1:1                    | 6,000                                     | 1 minute                                   | 4 minutes                                            | 20                                  | 3,200               | 2,300       | 700          | 50ml<br>400ml<br>8.4 fl. oz.<br>5 gal. pail B<br>5 gal. pail A             | 00-021200-56602-8<br>00-051111-98303-4<br>00-021200-96596-8<br>00-021200-96574-6<br>00-021200-96575-3 | 62-2649-5030-4<br>62-2649-3530-5<br>62-2649-1233-8<br>62-2649-8535-9<br>62-2749-8535-7 |
|   | DP600NS 600NS (Gray)      | Concrete repair Non-sag        | 1:1                    | Paste                                     | 1 minute                                   | 4 minutes                                            | 8                                   | 2,700               | 2,300       | 700          | 50ml<br>400ml                                                              | 00-021200-56606-6<br>00-051111-98312-6                                                                | 62-2652-5030-8<br>62-2652-3530-9                                                       |
|   | DP601 601 (Gray)          | Rigid Self-leveling            | 1:1                    | 6,000                                     | 1 minute                                   | 4 minutes                                            | 20                                  | 3,200               | 2,300       | 700          | 50ml<br>5 gal. pail B<br>5 gal. pail A<br>50 gal. drum B<br>50 gal. drum A | 00-021200-96410-7<br>00-021200-96451-0<br>00-021200-96452-7<br>00-021200-96507-4<br>00-021200-96508-1 | 62-2649-5031-2<br>62-2649-8530-0<br>62-2749-8530-8<br>62-2649-9530-9<br>62-2749-9530-7 |
|   | DP601NS 601NS (Gray)      | Rigid Non-sag                  | 1:1                    | Paste                                     | 1 minute                                   | 4 minutes                                            | 8                                   | 2,700               | 2,300       | 700          | 50ml                                                                       | 00-021200-96407-7                                                                                     | 62-2652-5031-6                                                                         |
|   | DP605NS 605NS (Off-White) | Semi-rigid Non-sag             | 1:1                    | 150,000                                   | 5 minutes                                  | 20 minutes                                           | 40                                  | 4,000               | 2,000       | 600          | 50ml<br>200ml<br>5 gal. pail B<br>5 gal. pail A                            | 00-021200-82252-0<br>00-021200-87853-4<br>00-021200-82253-7<br>00-021200-82254-4                      | 62-3592-1435-0<br>62-3592-3830-0<br>62-3592-8530-1<br>62-3692-8530-9                   |
|   | DP608 608 (Black)         | Flexible Non-sag               | 1:1                    | Paste                                     | 10 minutes                                 | 90 minutes                                           | 16                                  | 3,000               | 2,500       | 500          | 50ml<br>5 gal. pail B<br>5 gal. pail A<br>50 gal. drum B<br>50 gal. drum A | 00-021200-96418-3<br>00-021200-96513-5<br>00-021200-96514-2<br>00-021200-96515-9<br>00-021200-96516-6 | 62-3268-5030-2<br>62-3268-8530-8<br>62-3368-8530-6<br>62-3268-9530-7<br>62-3368-9530-5 |
|   | DP620NS 620NS (Black)     | Flexible Non-sag               | 1:1                    | Paste                                     | 20 minutes                                 | 4 hours                                              | 40                                  | 3,000               | 2,500       | 500          | 50ml<br>5 gal. Pail B<br>5 gal. Pail A<br>50 gal. Drum B<br>50 gal. Drum A | 00-021200-96416-9<br>00-021200-96449-7<br>00-021200-96450-3<br>00-021200-96505-0<br>00-021200-96506-7 | 62-2645-5030-2<br>62-2645-8530-8<br>62-2745-8530-6<br>62-2645-9530-7<br>62-2745-9530-5 |
|   | 3532 B/A (Brown)          | Multi-purpose Semi-rigid bonds | 1:1                    | 30,000                                    | 10 minutes                                 | 90 minutes                                           | 25                                  | 2,500               | 2,000       | 300          | 2 oz. kit<br>Quart kit<br>5 gal. pail B<br>5 gal. pail A                   | 00-021200-20878-2<br>00-021200-20879-9<br>00-021200-20881-2<br>00-021200-20935-2                      | 62-3532-0515-6<br>62-3532-6430-2<br>62-3532-8515-8<br>62-3632-8516-4                   |
|   | 3535 B/A (Off-White)      | Multi-purpose Semi-rigid bonds | 1:1                    | 30,000                                    | 3 minutes                                  | 30 minutes                                           | 25                                  | 2,500               | 2,000       | 300          | 2 oz. kit<br>Quart kit                                                     | 00-021200-20887-4<br>00-021200-20888-1                                                                | 62-3535-0515-9<br>62-3535-6430-5                                                       |

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

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

DP8010 Blue



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

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





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

| Product (Color)                  | Key Features                                          | Approximate Viscosity at 75°F (24°C) (cP) | Cure Conditions |             | Floating Roller Peel at 75°F (24°C) | Overlap Shear (psi) |             |              |               |                                             | UPC                                                         | Stock #                                            |
|----------------------------------|-------------------------------------------------------|-------------------------------------------|-----------------|-------------|-------------------------------------|---------------------|-------------|--------------|---------------|---------------------------------------------|-------------------------------------------------------------|----------------------------------------------------|
|                                  |                                                       |                                           | Time (min.)     | Temp. (F/C) |                                     | -67°F (-55°C)       | 75°F (24°C) | 180°F (82°C) | 230°F (121°C) | Size                                        |                                                             |                                                    |
| 1386 (Cream)                     | High temperature strength<br>Impact resistance        | 150,000                                   | 60              | 350/177     | 10                                  | 3,000               | 5,500       | 4,500        | 2,500         | 1 quart<br>5 gal. pail                      | 00-021200-19917-2<br>00-021200-19919-6                      | 62-1386-6525-2<br>62-1386-8525-0                   |
| 1469 (Cream)                     | High temperature strength<br>Low viscosity            | 60,000                                    | 120             | 350/177     | 2                                   | 3,150               | 3,700       | 3,700        | 3,600         | 1 quart<br>5 gal. pail                      | 00-021200-19949-3<br>00-021200-19950-9                      | 62-1469-6525-6<br>62-1469-8525-4                   |
| 2086 (Gray)                      | High temperature strength<br>High viscosity           | Paste                                     | 60              | 350/177     | 5                                   | 3,000               | 5,000       | 5,000        | 2,200         | 5 gal. pail                                 | 00-021200-20235-3                                           | 62-2086-8525-5                                     |
| 2214 Hi-Density (Gray)           | High temperature strength<br>Low temp curing          | Paste                                     | 40              | 250/121     | 5                                   | 3,000               | 4,500       | 4,500        | 1,700         | 6 oz. cart.<br>5 gal. pail                  | 00-021200-20813-3<br>00-021200-20814-0                      | 62-3414-2930-6<br>62-3414-8530-8                   |
| 2214 Hi-Temp New Formula (Gray)  | High temperature strength<br>Environmental resistance | Paste                                     | 60              | 250/121     | 2                                   | 2,800               | 2,800       | 2,800        | 2,500         | 6 oz. cart.<br>5 gal. pail                  | 00-021200-20833-1<br>00-021200-20835-5                      | 62-3491-2830-6<br>62-3491-8530-6                   |
| 2214 Hi-Temp Original (Gray)     | High temperature strength<br>Environmental resistance | Paste                                     | 40              | 250/121     | 2                                   | 2,000               | 2,000       | 3,000        | 2,500         | 6 oz. cart.                                 | 00-021200-20806-5                                           | 62-3402-2930-1                                     |
| 2214 Non-Metallic Filled (Cream) | High temperature strength<br>Higher insulation value  | Paste                                     | 40              | 250/121     | 7                                   | 3,000               | 4,000       | 4,500        | 1,500         | 6 oz. cart.<br>5 gal. pail                  | 00-021200-20802-7<br>00-021200-25496-3                      | 62-3401-0830-7<br>62-3401-2934-5                   |
| * 2214 Regular (Gray)            | High temperature strength<br>Low temp curing          | Paste                                     | 40              | 250/121     | 5                                   | 3,000               | 4,500       | 4,500        | 1,500         | 6 oz. cart.<br>1 quart<br>5 gal. pail       | 00-021200-20344-2<br>00-021200-20345-9<br>00-021200-23047-3 | 62-2214-2930-1<br>62-2214-6530-5<br>62-2214-8530-3 |
| 2290 (Amber)                     | Low solids liquid coating for metal laminations       | 60                                        | 30              | 350/177     | N/A                                 | 5,000               | 5,000       | 3,500        | 1,200         | Gallon cart.<br>5 gal. pail<br>54 gal. drum | 00-021200-76225-3<br>00-021200-76227-7<br>00-021200-76228-4 | 62-3847-7530-0<br>62-3847-8531-7<br>62-3847-9530-8 |

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

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



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

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





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

|      | Product (Color) | Key Features                                               | Typical Viscosity (cP) | Temperature Range            | Time to Handling | Full Cure (Hours) | Size                                                                   | UPC                                                                              | Stock #                                                              |
|------|-----------------|------------------------------------------------------------|------------------------|------------------------------|------------------|-------------------|------------------------------------------------------------------------|----------------------------------------------------------------------------------|----------------------------------------------------------------------|
| LEAD | 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<br>300 gram cart                                          | 00-051115-25265-5<br>00-051115-25282-2                                           | 62-6152-0362-7<br>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<br>500 gram bottle                                      | 00-051115-25204-4<br>00-051115-25205-1                                           | 62-6147-0360-1<br>62-6147-3860-7                                     |
|      | PR100 (Clear)   | General purpose, low viscosity plastic bonder              | 100                    | -65° to 180°F (-54° to 82°C) | 10-30 sec.       | 24                | 200 gram bottle<br>500 gram bottle<br>500 gram bottle<br>2 kilo bottle | 00-051115-25214-3<br>00-051115-25939-5<br>00-051115-25213-6<br>00-051111-07176-2 | 62-6164-0360-6<br>62-6164-3865-1<br>62-6164-3860-2<br>62-6164-6860-9 |
|      | PR600 (Clear)   | Medium viscosity with some gap filling for plastic/rubbers | 600                    | -65° to 180°F (-54° to 82°C) | 4-40 sec.        | 24                | 50 ml bottle                                                           | 00-051115-25241-9                                                                | 62-6182-0862-3                                                       |
|      | PR1500 (Clear)  | General purpose, high viscosity for gap filling            | 1,500                  | -65° to 180°F (-54° to 82°C) | 20-60 sec.       | 24                | 200 gram bottle<br>500 gram bottle<br>500 gram bottle<br>2 gram tube   | 00-051115-25222-8<br>00-051115-25937-1<br>00-051115-25221-1<br>00-051115-25205-0 | 62-6165-0360-3<br>62-6165-3865-8<br>62-6165-3860-9<br>62-6137-0260-4 |

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

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

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

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

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

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

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

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

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

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

|                    |                                                                                      |       |                                 |        |    |                                   |                                      |                                  |
|--------------------|--------------------------------------------------------------------------------------|-------|---------------------------------|--------|----|-----------------------------------|--------------------------------------|----------------------------------|
| RT5000B<br>(Black) | Rubber toughened for<br>impact resistance<br>High viscosity for minor<br>gap filling | 5,000 | -65° to 180°F<br>(-54° to 82°C) | 30 sec | 24 | 20 gram bottle<br>500 gram bottle | 00-051111-916650<br>00-051115-252006 | 62-6135-0360-6<br>62-6135-3860-2 |
|--------------------|--------------------------------------------------------------------------------------|-------|---------------------------------|--------|----|-----------------------------------|--------------------------------------|----------------------------------|

## 3M™ Scotch-Weld™ Instant Adhesives – Metal

|                  |                            |     |                                 |           |    |                              |                                        |                                  |
|------------------|----------------------------|-----|---------------------------------|-----------|----|------------------------------|----------------------------------------|----------------------------------|
| MC100<br>(Clear) | Multi-purpose metal bonder | 100 | -65° to 180°F<br>(-54° to 82°C) | 4-20 sec. | 24 | 1 oz. bottle<br>1 lb. bottle | 00-051111-91663-6<br>00-048011-62634-5 | 62-6130-0360-7<br>62-6130-3860-3 |
|------------------|----------------------------|-----|---------------------------------|-----------|----|------------------------------|----------------------------------------|----------------------------------|

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

|          |                                                                                                                                     |                   |                                  |             |    |                                             |                                                             |                                                    |
|----------|-------------------------------------------------------------------------------------------------------------------------------------|-------------------|----------------------------------|-------------|----|---------------------------------------------|-------------------------------------------------------------|----------------------------------------------------|
| CA4      | Fast setting for a variety<br>of plastics and rubbers                                                                               | 150               | -65° to 180°F<br>(-54° to 82°C)  | 5-40 sec.   | 24 | 2 gram tube<br>1 oz. bottle<br>1 lb. bottle | 00-021200-96601-9<br>00-021200-96600-2<br>00-021200-96597-5 | 62-3801-0230-1<br>62-3801-0330-9<br>62-3801-3830-5 |
| CA5      | Higher viscosity, slower<br>setting version of CA4<br>for filling gaps<br>Meets CID A-A-3097,<br>Type II, Class 3                   | 2,000             | -65° to 180°F<br>(-54° to 82°C)  | 12-60 sec.  | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-74289-7<br>00-021200-74288-0                      | 62-3802-0330-7<br>62-3802-3830-3                   |
| CA7      | Very fast setting<br>Excellent metal bonder<br>Better shock and impact<br>resistance                                                | 15-40             | -65° to 212°F<br>(-54° to 100°C) | 1-30 sec.   | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-21061-7<br>00-021200-21062-4                      | 62-3812-0330-6<br>62-3812-3830-2                   |
| CA8      | Rapid setting<br>Excellent adhesion to metals,<br>plastics and rubbers<br>Meets CID A-A-3097,<br>Type II, Class 2                   | 70-130            | -65° to 180°F<br>(-54° to 82°C)  | 5-40 sec.   | 24 | 2 gram tube<br>1 oz. bottle<br>1 lb. bottle | 00-021200-21065-5<br>00-021200-21066-2<br>00-021200-21067-9 | 62-3815-0130-3<br>62-3815-0330-9<br>62-3815-3830-5 |
| CA9      | Slower setting for<br>parts alignment<br>Useful for wire tracking and<br>coil terminating<br>Meets CID A-A3097,<br>Type II, Class 3 | 1,000-1,700       | -65° to 180°F<br>(-54° to 82°C)  | 20-70 sec.  | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-21068-6<br>00-021200-21069-3                      | 62-3817-0330-5<br>62-3817-3830-1                   |
| CA40     | Very fast setting<br>Excellent adhesion to many<br>substrates including flexible<br>vinyl and EPDM rubber                           | 20                | -65° to 180°F<br>(-54° to 82°C)  | 3-20 sec.   | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-74290-3<br>00-021200-74291-0                      | 62-3803-0330-5<br>62-3803-3830-1                   |
| CA40H    | Higher viscosity version<br>of CA40<br>Better void filling capabilities                                                             | 400-600           | -65° to 212°F<br>(-54° to 100°C) | 5-40 sec.   | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-21073-0<br>00-021200-21074-7                      | 62-3829-0330-0<br>62-3829-3830-6                   |
| CA50 Gel | High-viscosity, non-sag gel<br>Less sensitive to acidic<br>surfaces                                                                 | 45,000-<br>85,000 | -65° to 212°F<br>(-54° to 100°C) | 60-120 sec. | 24 | 20 gram tube<br>200 gram tube               | 00-021200-82332-9<br>00-021200-83737-1                      | 62-3872-0330-0<br>62-3872-3630-0                   |
| CA100    | High peel and<br>impact strength<br>High thermal shock and<br>heat resistance                                                       | 2,500-4,500       | -65° to 212°F<br>(-54° to 100°C) | 20-70 sec.  | 24 | 1 oz. bottle<br>1 lb. bottle                | 00-021200-82334-3<br>00-021200-82335-0                      | 62-3873-0330-8<br>62-3873-3830-4                   |

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

| Product (Color)   | Key Features                                                                                                                  | Typical Viscosity (cps) | Time to Handling | Full Cure (Hours) | Size                                                                  | UPC                                                                              | Stock #                                                              |
|-------------------|-------------------------------------------------------------------------------------------------------------------------------|-------------------------|------------------|-------------------|-----------------------------------------------------------------------|----------------------------------------------------------------------------------|----------------------------------------------------------------------|
| AC09              | Instant adhesive activator<br>Non-flammable, solvent-based<br>California compliant                                            | 1                       | 1-5 sec.         | 24                | 2 fl. oz. bottle<br>1 liter can                                       | 00-051111-07795-5<br>00-051111-07908-9                                           | 62-6198-0860-3<br>62-6198-8360-6                                     |
| AC77              | Instant adhesive primer for bonding of difficult-to-bond plastics such as polyethylene, polypropylene and polyacetal          | <3                      | 1-5 sec.         | 24                | 2 fl. oz. bottle<br>4 liter can<br>55 gallon drum                     | 00-048011-62728-1<br>00-048011-62653-6<br>00-048011-62654-3                      | 62-3907-0860-0<br>62-3907-7560-9<br>62-3907-9560-7                   |
| AC79              | Instant adhesive primer for bonding of difficult-to-bond elastomers such as silicone, fluoro-elastomer and EPDM               | 2                       | 1-5 sec.         | 24                | 2 fl. oz. bottle<br>8 fl. oz. bottle<br>4 liter can                   | 00-051115-31388-2<br>00-051115-31389-9<br>00-051115-31390-5                      | 62-3916-0860-1<br>62-3916-3760-0<br>62-3916-7560-0                   |
| AC113             | Instant adhesive general purpose accelerator<br>Will not attack plastics                                                      | <3                      | 1-5 sec.         | 24                | 2 fl. oz. bottle<br>8 fl. oz. bottle<br>Quart can<br>4 liter can      | 00-048011-62681-9<br>00-048011-62682-6<br>00-048011-62683-3<br>00-048011-62684-0 | 62-6194-0860-2<br>62-6194-3760-1<br>62-6194-6560-2<br>62-6194-7560-1 |
| AC452             | Instant adhesive acetone-based accelerator<br>flashes off rapidly<br>Excellent adhesion<br>Overspray may attack some plastics | <2                      | 1-5 sec.         | 24                | 2 fl. oz. bottle<br>8 fl. oz. bottle<br>12 oz. aerosol<br>4 liter can | 00-048011-62685-7<br>00-048011-62686-4<br>00-048011-62687-1<br>00-048011-62689-5 | 62-6195-0860-9<br>62-6195-3760-8<br>62-6195-4460-4<br>62-6195-7560-8 |
| Surface Activator | Clear, colorless organic-based liquid helps speed curing and prime surfaces<br>Comes with brush and spray pump                | <10                     | 1-5 sec.         | 24                | 2 fl. oz. bottle                                                      | 00-021200-87937-1                                                                | 62-3804-0830-2                                                       |

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

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



## 3M™ Scotch-Weld™ Threadlockers

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



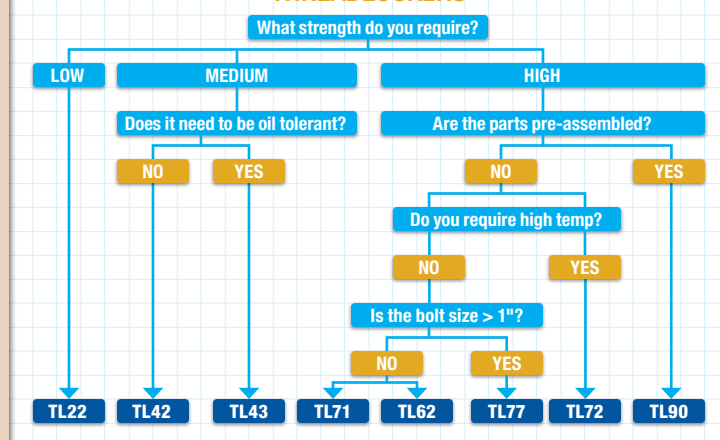
# 3M™ Scotch-Weld™ Anaerobic Adhesives – Threadlockers

| Product (Color) | Key Features                                                                         | Typical Viscosity (cps) | Temperature Range             | Time to Handling | Full Cure (Hours) | Size                                                                        | UPC                                                                                                   | Stock #                                                                                |
|-----------------|--------------------------------------------------------------------------------------|-------------------------|-------------------------------|------------------|-------------------|-----------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------|
| TL22 (Purple)   | Screwlock- low removal torque fasteners less than a 1/4" (6mm)                       | 1,200                   | -65° to 300°F (-54° to 149°C) | < 20 min         | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle                                  | 00-048011-62601-7<br>00-048011-62602-4<br>00-048011-62603-1                                           | 62-3493-1060-7<br>62-3493-5060-3<br>62-3493-3960-6                                     |
| TL42 (Blue)     | Nutlock - medium strength, general purpose                                           | 1,200                   | -65° to 300°F (-54° to 149°C) | < 20 min         | 24                | 1ml pipette<br>10ml bottle<br>50ml bottle<br>250ml bottle<br>1 liter bottle | 00-048011-62604-8<br>00-048011-62605-5<br>00-048011-62606-2<br>00-048011-62607-9<br>00-051115-25124-5 | 62-3494-0160-4<br>62-3494-1060-5<br>62-3494-5060-1<br>62-3494-3960-4<br>62-3494-8360-2 |
| TL43 (Blue)     | Oil tolerant, medium strength general purpose                                        | 3,300                   | -65° to 300°F (-54° to 149°C) | < 20 min         | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle<br>1 liter bottle                | 00-051115-25138-2<br>00-051115-25139-9<br>00-051115-25140-5<br>00-051115-25141-2                      | 62-3428-1060-3<br>62-3428-5060-9<br>62-3428-3960-2<br>62-3428-8360-0                   |
| TL62 (Red)      | Studlock - high strength with controlled torque tension                              | 1,600                   | -65° to 300°F (-54° to 149°C) | < 20 min         | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle<br>1 liter bottle                | 00-048011-62609-3<br>00-048011-62610-9<br>00-048011-62611-6<br>00-051115-25132-0                      | 62-3495-1060-2<br>62-3495-5060-8<br>62-3495-3960-1<br>62-3495-8360-9                   |
| TL71 (Red)      | Permanent studlock for bolts and studs up to 1" (25mm)                               | 500                     | -65° to 300°F (-54° to 149°C) | < 20 min         | 24                | 1ml pipette<br>10ml bottle<br>50ml bottle<br>250ml bottle                   | 00-051115-25125-2<br>00-048011-62612-3<br>00-048011-62613-0<br>00-048011-62614-7                      | 62-3496-0160-9<br>62-3496-1060-0<br>62-3496-5060-6<br>62-3496-3960-9                   |
| TL72 (Red)      | High temperature studlock with gap filling for larger diameter coarse threaded parts | 7,000                   | -65° to 450°F (-54° to 232°C) | < 20 mins        | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle<br>1 liter bottle                | 00-051115-25133-7<br>00-051115-25137-5<br>00-051115-25135-1<br>00-051115-25136-8                      | 62-3497-1060-8<br>62-3497-5060-4<br>62-3497-3960-7<br>62-3497-8360-5                   |
| TL77 (Red)      | Heavy duty permanent for fasteners up to 1.5" (38mm) with coarse threads             | 7,000                   | -65° to 300°F (-54° to 149°C) | < 20 mins        | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle                                  | 00-051115-25142-9<br>00-051115-25143-6<br>00-051115-25144-3                                           | 62-3429-1060-1<br>62-3429-5060-7<br>62-3429-3960-0                                     |
| TL90 (Green)    | Penetrating adhesive for pre-assembled fasteners and porosity sealing of welds       | 20                      | -65° to 300°F (-54° to 149°C) | < 20 min         | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle<br>1 liter bottle                | 00-048011-62615-4<br>00-048011-62616-1<br>00-048011-62617-8<br>00-051115-25150-4                      | 62-3498-1060-6<br>62-3498-5060-2<br>62-3498-3960-5<br>62-3498-8360-3                   |

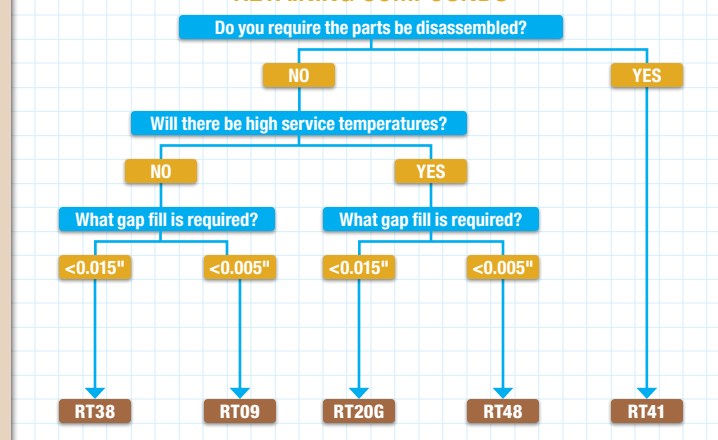
# 3M™ Scotch-Weld™ Anaerobic Adhesives – Pipe Sealant

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

## THREADLOCKERS



## RETAINING COMPOUNDS





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

| Product (Color)  | Key Features                                                                                     | Typical Viscosity (cps) | Temperature Range                | Time to Handling | Full Cure (Hours) | Size                                                                         | UPC                                                                                      | Stock #                                                                      |
|------------------|--------------------------------------------------------------------------------------------------|-------------------------|----------------------------------|------------------|-------------------|------------------------------------------------------------------------------|------------------------------------------------------------------------------------------|------------------------------------------------------------------------------|
| RT09<br>(Green)  | For tight tolerances and press fit augmentation                                                  | 125                     | -65° to 300°F<br>(-54° to 149°C) | 10-30 mins       | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle<br>1 liter bottle                 | 00-048011-62661-1<br>00-048011-62662-8<br>00-048011-62663-5<br>00-051115-31977-8         | 62-3435-1060-8<br>62-3435-5060-4<br>62-3435-3960-7<br>62-3435-8360-3         |
| RT20G<br>(Green) | For assembly of automotive/<br>marine cylinder liners and<br>heat exchanger tubes                | 7,000                   | -65° to 450°F<br>(-54° to 232°C) | 30-40 mins       | 24                | 10ml bottle<br>10/CV<br>10ml bottle<br>300/CV<br>50ml bottle<br>250ml bottle | 00-048011-62664-2<br><br>00-051115-31751-4<br><br>00-048011-62665-9<br>00-048011-62666-6 | 62-3434-1060-1<br><br>62-3434-1360-5<br><br>62-3434-5060-7<br>62-3434-3960-0 |
| RT38<br>(Green)  | Fast setting, high strength for<br>bearings, bushings or sleeves<br>on shafts or in housings     | 2,500                   | -65° to 300°F<br>(-54° to 149°C) | 10-15 mins       | 24                | 10ml bottle<br>50ml bottle<br>250ml bottle                                   | 00-051115-81282-8<br>00-051115-81283-5<br>00-051115-81284-2                              | 62-3460-1060-6<br>62-3460-5060-2<br>62-3460-3960-5                           |
| RT41<br>(Tan)    | Medium strength for<br>cylindrical parts<br>Easier disassembly for service<br>and bearing re-use | 600                     | -65° to 300°F<br>(-54° to 149°C) | 15-20 mins       | 24                | 250ml bottle                                                                 | 00-048011-62724-3                                                                        | 62-3484-3960-5                                                               |
| RT48             | High strength bonds for<br>cylindrical parts                                                     | 600                     | -65° to 300°F<br>(-54° to 149°C) | 10 min           | 24                | 50ml bottle<br>250ml bottle                                                  | 00-054007-99632-3<br>00-054007-99633-0                                                   | 62-3480-5060-0<br>62-3480-3950-4                                             |

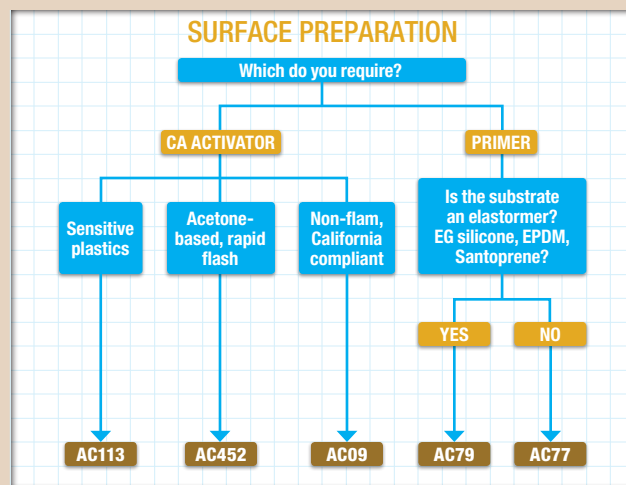
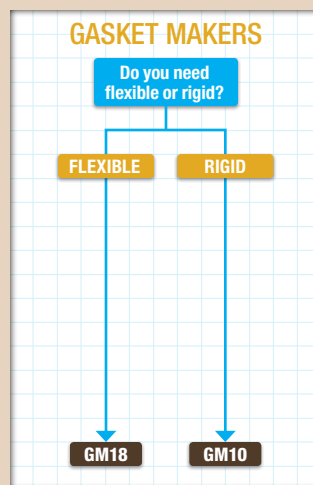
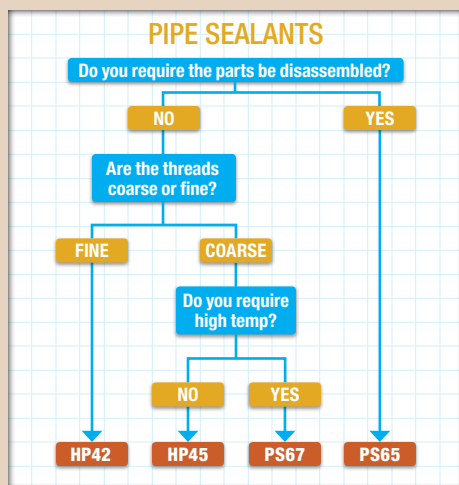
# 3M™ Scotch-Weld™ Anaerobic Adhesives – Gasket Maker

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

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

|       |                                                                                                                                        |    |     |        |    |                                                     |                                                             |                                                    |
|-------|----------------------------------------------------------------------------------------------------------------------------------------|----|-----|--------|----|-----------------------------------------------------|-------------------------------------------------------------|----------------------------------------------------|
| AC649 | Acetone-based green<br>primer for inactive or very<br>cold surfaces<br>30-day part life for<br>pre-application<br>California compliant | <3 | N/A | <5 min | 24 | 2 fl. oz. bottle<br>8 fl. oz. bottle<br>4 liter can | 00-048011-62708-3<br>00-048011-62709-0<br>00-048011-62707-6 | 62-3918-0860-7<br>62-3918-3760-6<br>62-3918-7560-6 |
|-------|----------------------------------------------------------------------------------------------------------------------------------------|----|-----|--------|----|-----------------------------------------------------|-------------------------------------------------------------|----------------------------------------------------|

**LEAD** Denotes a Lead Product    **\*** Consider these products first when evaluating adhesives for your application.  
 Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.



## 3M™ EPX™ Applicators and Nozzles

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

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



# 3M™ EPX™ Applicators and Nozzles

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

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

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

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

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

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

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

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

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

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

## Surface Preparation Tips

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

### METALS

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

### PLASTICS AND RUBBERS

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

### GLASS

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



### Industrial Adhesives & Tapes Division

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