

**3M** Science.  
Applied to Life.™



**Scotch-Weld**™  
Structural Adhesive

## Product Selection Guide

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

EMEA March 2020

# We Help You Make It. Better.

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

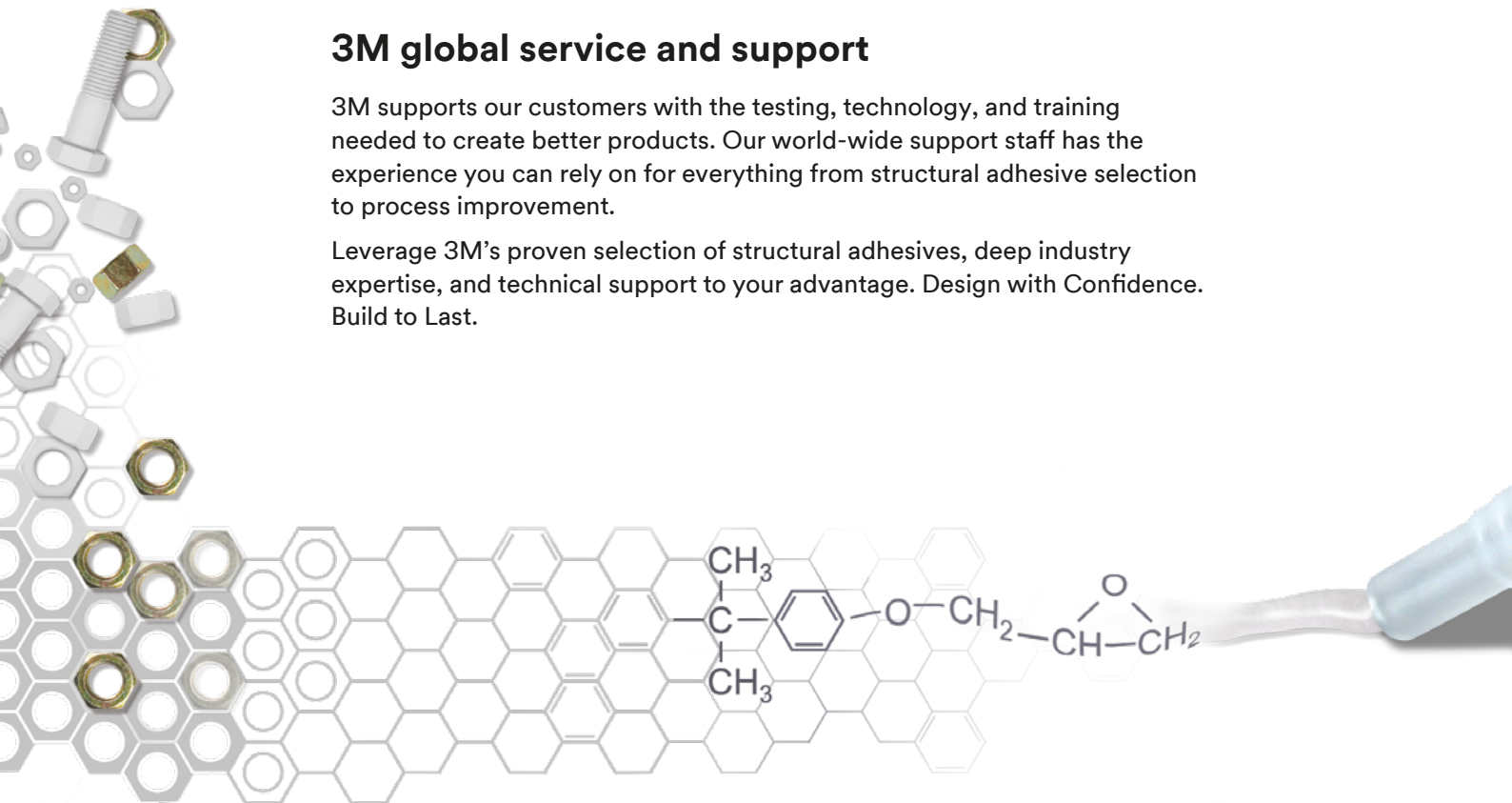
## Trusted innovations from aerospace to office space

With over 60 years of experience developing innovative structural adhesives for aerospace, automotive and hundreds of other industries, 3M delivers the solutions you can trust. Our advanced formulations create durable bonds, even on challenging materials or in extreme conditions.

## 3M global service and support

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

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



## Advancing design, process and performance

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



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

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



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

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



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

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

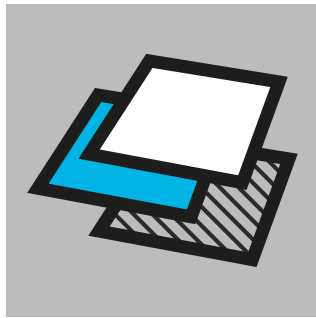


# Simplifying Adhesive Decisions for Your Application

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

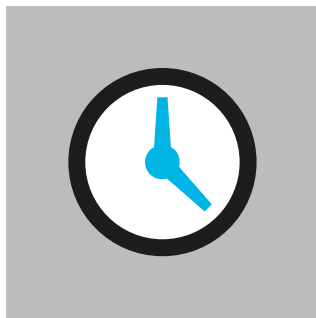
## Q: What materials will be bonded?

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



## Q: What is the preferred cure speed?

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



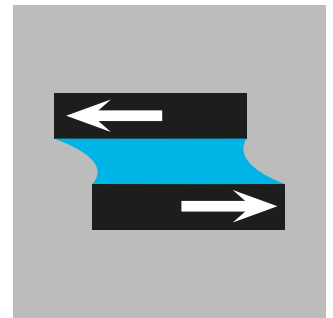
## Q: What surface preparation will be required?

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



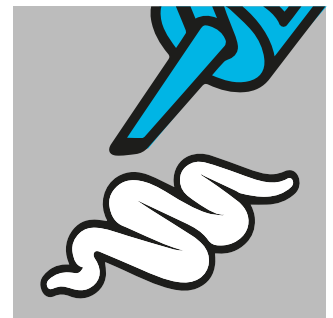
## Q: What types of joints are best for structural adhesives?

A: Joint designs that put the adhesive bond under shear, tension, or compression forces will provide the highest strength. Designs that tend to apply peel or cleavage forces to the adhesive, where the applied stresses are not distributed over the entire bond area, will have lower bond strength, but the bond may still be sufficient for the needs of the application. In addition, optimum bond line thickness typically ranges from 125  $\mu$  to 500  $\mu$ . The adhesive qualification process should always include testing of prototype assemblies to ensure the adhesive will provide enough performance.



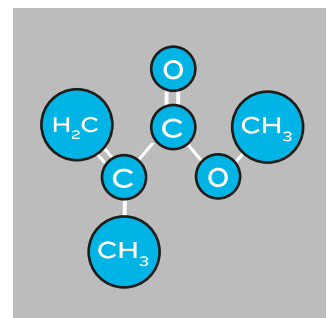
## Q: How are structural adhesives used and applied?

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



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

A: All structural adhesives provide at least 7 MPa of overlap shear strength to aluminum, but the different adhesive chemistries have various properties:



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

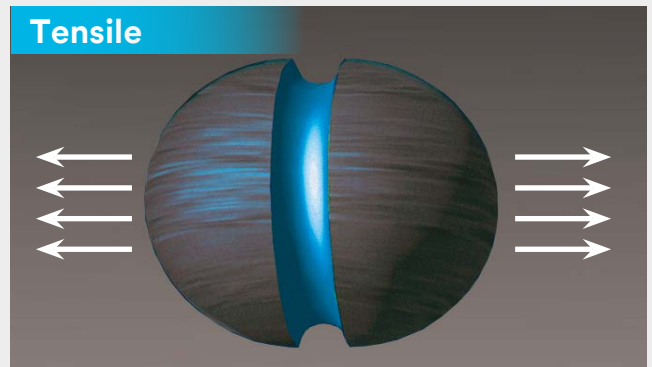
- **Acrylic adhesives** are two-part adhesives that provide excellent bond strength and durability, although slightly lower than epoxy adhesives. However, they have several features that make them easier to use in many applications and manufacturing processes. These benefits include a much faster cure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

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

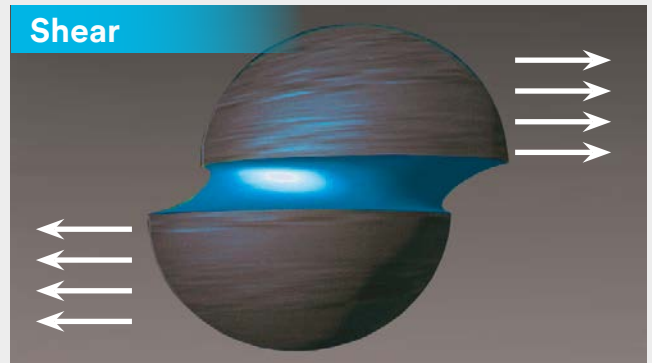
- **Cyanoacrylate adhesives** (instant adhesives) are one-component, lower viscosity liquids that cure extremely quickly with just contact pressure and surface moisture. They adhere well, with thin bond lines, to plastics, metals and rubbers. With the use of primers, they can also adhere to low surface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

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

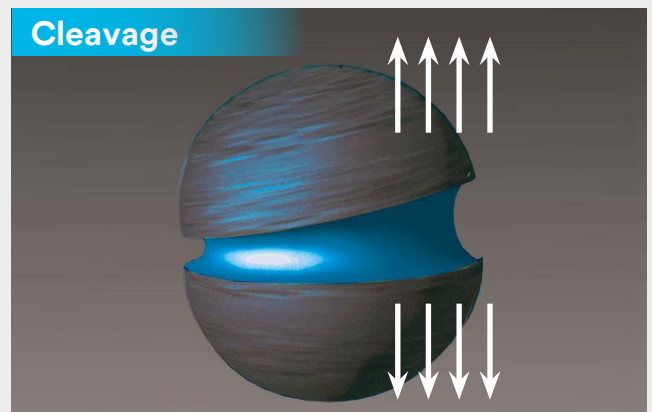
- **PUR adhesives** (Polyurethane-reactive adhesives) are one-part adhesives that apply like a hot melt, but cure with ambient moisture for near structural strength bonds. Fast set times and build strength over the next 24-48 hours can reach as much as 7 MPa in overlap shear strength. They are flexible and resistant to temperature extremes and most solvents. Most commonly used in bonds where at least one substrate contains or transmits moisture (such as wood or plastic).



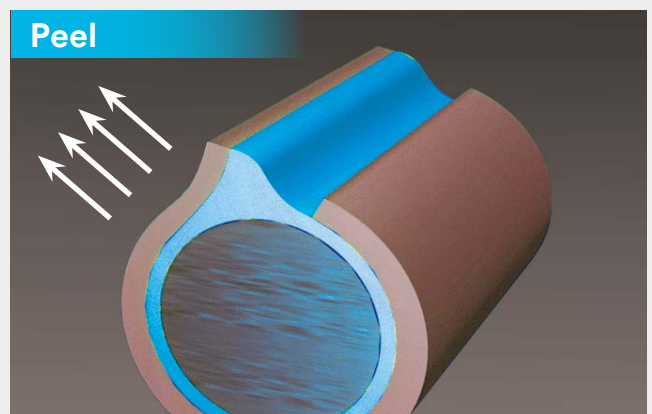
**Tensile** is pull exerted equally over the entire joint. Pull direction is straight and away from the adhesive bond.



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



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



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

# Key Markets & Applications

## For 3M™ Scotch-Weld™ Structural Adhesives



### Sporting Goods

#### Key Features & Benefits:

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

#### Key Products:

DP420NS Black, DP8810NS, PR100, TS230

### Specialty Vehicle

#### Key Features & Benefits:

- Weight reduction
- High strength
- Vibration & fatigue resistance

#### Key Products:

DP6330NS, DP8410NS, 7260FC NS, TL42



### Signage

#### Key Features & Benefits:

- One adhesive to bond all of your substrates
- Strong formulations and thin bond lines
- Weather resistance
- UL recognition

#### Key Products:

DP8805NS, DP8405NS, DP100 Plus



### Metalworking

#### Key Features & Benefits:

- High strength and durability
- Reduced surface preparation before bonding, and no grinding after bonding
- Save weight and improve appearance with adhesives instead of welds or rivets

#### Key Products:

DP420NS Black, DP8407NS, DP8410NS





## Electronics

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

- Low halogen formulations available to meet customer needs
- Fast cure to speed production
- Protect sensitive electrical connections from the environment

### **Key Products:**

DP270, DP8805NS, TS230, PR100



## Appliance

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

- Simplify operations by bonding after powdercoating
- Eliminate the challenge of bonding rigid to flexible substrates
- Noise damping
- Reduce complexity-bond and seal glass to metal in one step

### **Key Products:**

DP125 Gray, DP6310NS, DP8810NS, TS230, TL42



## Aerospace

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

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

### **Key Products:**

2216 Gray, DP100FR, TL70



## Plastic, Composite & Rubber

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

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

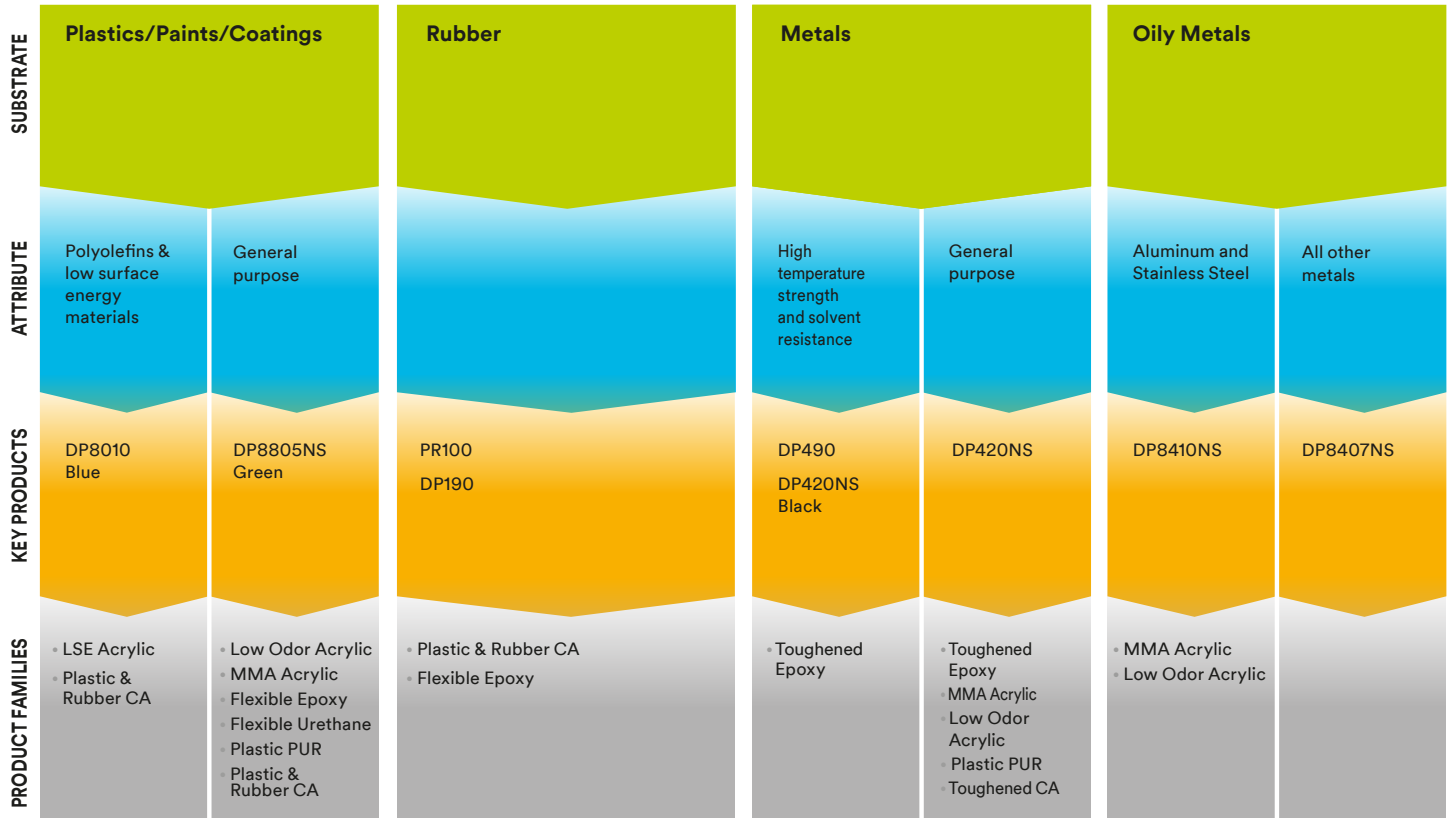
### **Key Products:**

DP8010 Blue, DP190, DP6310NS, 2216, TS230, PR100, DP490



# 3M™ Scotch-Weld™ Adhesives Selector Guide

**Step 1: Select Most Difficult Substrate**   **Step 2: Determine Key Attribute**   **Step 3: Select Product Family**



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

**SUBSTRATE**   **ATTRIBUTE**   **KEY PRODUCT**   **PRODUCT FAMILIES**

## Structural Adhesive Families

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

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

**Toughened Epoxy Adhesives** — Higher tensile strength at lower elongations for fatigue resistance; best suited for dynamic stresses. They have long-term holding power, higher peel strength, and exceptional higher resistance against shock, vibration and impact loads. Lower adhesion to most thermoplastics.

**Heat-cured Epoxy Adhesives** — One-component, rigid adhesives with outstanding strength at elevated temperatures. These adhesives require a thermal cure, typically around 250-350°F (120-180°C) for 40-60 minutes.

**MMA Acrylic Adhesives** — Provides greater adhesion to a wide variety of materials including most plastics and paint systems, are tolerant of many surface contaminations. High impact resistance for metal bonds.

**Low Odor Acrylic Adhesives** — Less odor than typical acrylic adhesives and faster rate of strength build than most two-part structural adhesives. Excellent adhesion to a variety of materials, including plastics and paint systems. They provide high impact resistance for plastic bonds; and are tolerant of many surface contaminations.

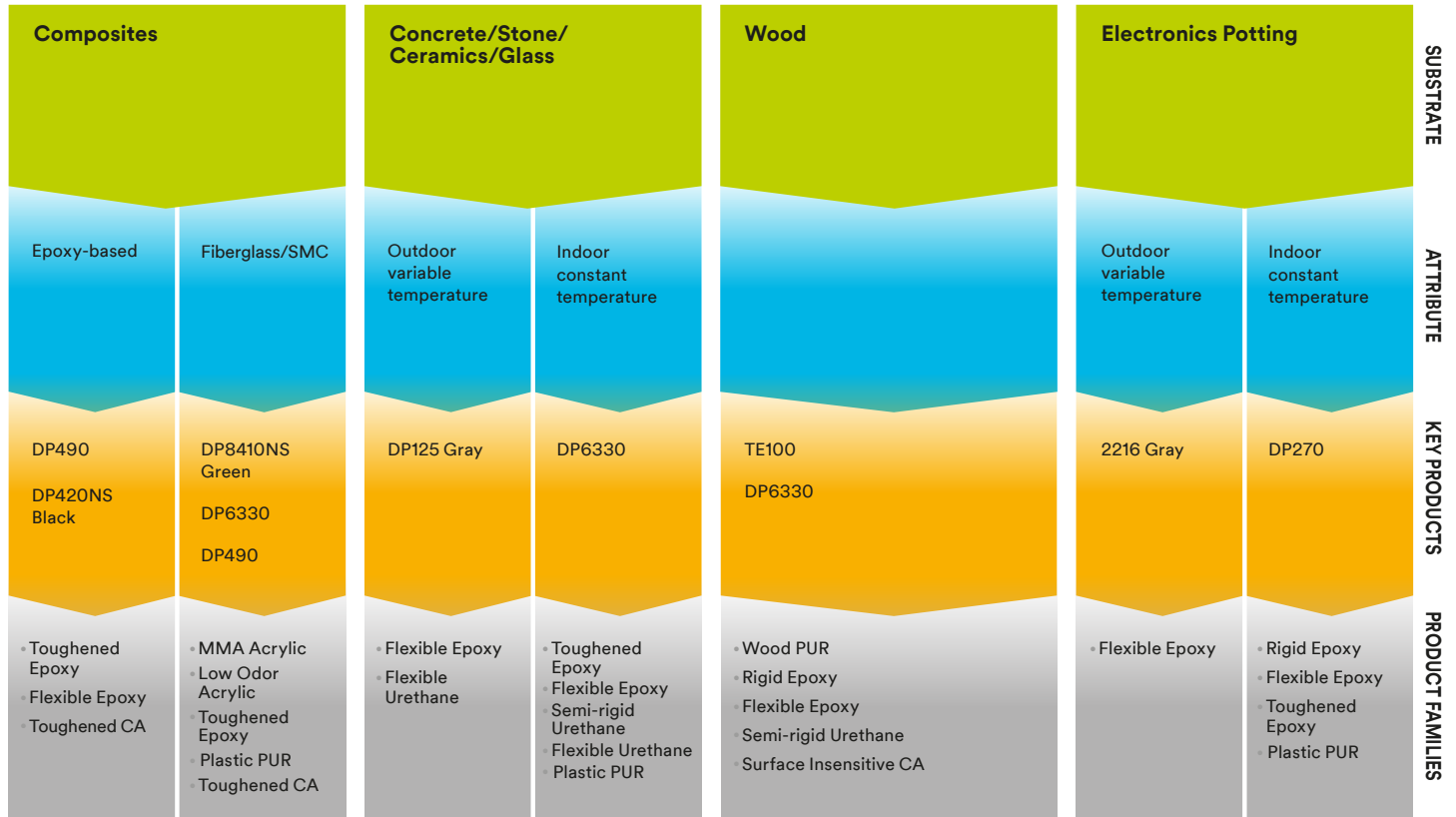
**LSE Acrylic Adhesives** — Outstanding adhesion to polyolefin materials such as polypropylene, polyethylene and TPO without surface treatment.

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

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



**Step 1: Select Most Difficult Substrate**   **Step 2: Determine Key Attribute**   **Step 3: Select Product Family**



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

■ SUBSTRATE   ■ ATTRIBUTE   ■ KEY PRODUCT   ■ PRODUCT FAMILIES

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

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

### 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.

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

### PUR Adhesive Families

**Wood PUR** – Higher shear strength at lower elongations for long term holding power. Mostly used for rigid wood substrates and some plastics.

**Plastic PUR** – Higher impact strength, elongation and flexibility for greater capacity to withstand movement of bonded parts. Higher adhesion to most plastics, glass and aluminum.

### 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.

# Substrate Selector

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

|                               | Plastic/Paints/Coatings             |   | Rubber   | Metals                                     |   |  | Oily Metals   |                             | Composites  |   | Concrete/Stone/Ceramics/Glass  |   | Wood   |   |
|-------------------------------|-------------------------------------|---|--|--|---|--|---|-----------------------------|---|---|--|---|--|---|
|                               | Low Surface Energy                  | General Purpose   |  | Temperature and Solvent Resistant          | Stainless Steel & Aluminum  | Other Metals   | Stainless Steel & Aluminum  | Other Metals                | Fiberglass/SMC  | Epoxy   | Indoor   | Outdoor   |  |   |
| Plastic/Paints/Coatings       | Low Surface Energy                  | LSE Acrylic* Plastic & Rubber CA                              | LSE Acrylic* Plastic & Rubber CA   | Plastic & Rubber CA*                       | N/A   | LSE Acrylic  | LSE Acrylic   | LSE Acrylic                 | LSE Acrylic   | LSE Acrylic   | LSE Acrylic  | LSE Acrylic   | LSE Acrylic  | LSE Acrylic Surface Insensitive CA*   |
|                               | General Purpose                     | LSE Acrylic* Plastic & Rubber CA                              | LO Acrylic MMA Acrylic Plastic PUR Flexible Epoxy Plastic & Rubber CA          | Plastic & Rubber CA* Plastic PUR           | Toughened Epoxy Flexible Epoxy  | LO Acrylic MMA Acrylic Flexible Epoxy Plastic PUR Plastic & Rubber CA  | DP8407NS Toughened Epoxy Flexible Epoxy Plastic PUR Plastic & Rubber CA | LO Acrylic MMA Acrylic      | DP8407NS  | Semi-rigid Urethane MMA Acrylic LO Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR | Semi-rigid Urethane MMA Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR | Flexible Epoxy Rigid Urethane Flexible Urethane Plastic PUR     | Flexible Epoxy Flexible Urethane Plastic PUR                               | Wood PUR Flexible Epoxy Rigid Urethane Surface Insensitive CA                 |
| Rubber                        | Plastic & Rubber CA*                | Plastic & Rubber CA* Plastic PUR                              | Plastic & Rubber CA*   | N/A  | Flexible Epoxy Plastic PUR  | Flexible Epoxy Plastic PUR   | N/A   | N/A                         | Plastic & Rubber CA* Plastic PUR  | Plastic & Rubber CA* Plastic PUR  | Flexible Epoxy Plastic PUR   | Flexible Epoxy Plastic PUR                                      | Surface Insensitive CA* Plastic PUR Flexible Epoxy                         |   |
| Metals                        | Temperature and Solvent Resistant   | N/A   | Toughened Epoxy Flexible Epoxy   | N/A  | Toughened Epoxy Flexible Epoxy  | Toughened Epoxy Flexible Epoxy   | One-part 2214 Toughened Epoxy   | 2214                        | 2214  | Toughened Epoxy Flexible Epoxy Plastic PUR  | Toughened Epoxy Flexible Epoxy Plastic PUR                                 | Toughened Epoxy Flexible Epoxy                                  | Flexible Epoxy   | Toughened Epoxy Plastic PUR Flexible Epoxy                                    |
|                               | Stainless Steel & Aluminum          | LSE Acrylic   | LO Acrylic MMA Acrylic Flexible Epoxy Plastic PUR Plastic & Rubber CA          | Plastic & Rubber CA* Plastic PUR           | Toughened Epoxy Flexible Epoxy  | LO Acrylic MMA Acrylic Toughened Epoxy Flexible Epoxy Rigid Epoxy      | 2214 Toughened Epoxy  | LO Acrylic MMA Acrylic      | DP8407NS 2214   | Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Plastic PUR                | Semi-rigid Urethane Toughened Epoxy MMA Acrylic LO Acrylic Plastic PUR     | Toughened Epoxy Flexible Epoxy                                  | Flexible Epoxy   | Plastic PUR Toughened Epoxy Rigid Epoxy Flexible Epoxy Surface Insensitive CA |
|                               | Other Metals                        | LSE Acrylic   | DP8407NS Toughened Epoxy Flexible Epoxy Plastic PUR Plastic & Rubber CA        | Plastic & Rubber CA* Plastic PUR           | 2214 Toughened Epoxy  | 2214 Toughened Epoxy   | Toughened Epoxy Flexible Epoxy 2214 DP810                               | DP8407NS 2214               | DP8407NS 2214   | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR                        | Toughened Epoxy Flexible Epoxy 2214 Plastic PUR                            | Toughened Epoxy 2214  | Flexible Epoxy   | Plastic PUR Toughened Epoxy   |
| Oily Metals                   | Stainless Steel & Aluminum          | LSE Acrylic   | LO Acrylic MMA Acrylic   | N/A  | 2214  | LO Acrylic MMA Acrylic   | DP8407NS 2214   | LO Acrylic MMA Acrylic      | DP8407NS  | MMA Acrylic LO Acrylic  | MMA Acrylic LO Acrylic 2214  | N/A   | N/A  | N/A   |
|                               | Other Metals                        | LSE Acrylic   | DP8407NS   | N/A  | 2214  | DP8407NS 2214  | DP8407NS 2214   | DP8407NS                    | DP8407NS 2214   | DP8407NS  | 2214   | N/A   | N/A  | N/A   |
| Composites                    | Fiberglass/SMC                      | LSE Acrylic   | Semi-rigid Urethane MMA Acrylic LO Acrylic Flexible Epoxy Urethane Plastic PUR | Plastic & Rubber CA* Plastic PUR           | Toughened Epoxy Flexible Epoxy Plastic PUR                                    | Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Plastic PUR | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR          | MMA Acrylic LO Acrylic      | DP8407NS  | Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Flexible Epoxy Plastic PUR | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR             | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR  | Semi-rigid Urethane Flexible Epoxy Flexible Urethane Plastic PUR           | Semi-rigid Urethane Toughened Epoxy Rigid Urethane Flexible Epoxy Plastic PUR |
|                               | Epoxy                               | LSE Acrylic   | Semi-rigid Urethane MMA Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR     | Plastic & Rubber CA* Plastic PUR           | Toughened Epoxy Flexible Epoxy Plastic PUR                                    | Semi-rigid Urethane Toughened Epoxy MMA Acrylic LO Acrylic Plastic PUR | Toughened Epoxy Flexible Epoxy 2214 Plastic PUR                         | MMA Acrylic LO Acrylic 2214 | 2214  | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR                        | Toughened Epoxy Flexible Epoxy Plastic PUR                                 | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR  | Semi-rigid Urethane Flexible Epoxy Plastic PUR                             | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR                |
| Concrete/Stone/Ceramics/Glass | Indoor                              | LSE Acrylic   | Flexible Epoxy Rigid Urethane Flexible Urethane Plastic PUR                    | Flexible Epoxy Plastic PUR                 | Toughened Epoxy Flexible Epoxy  | Toughened Epoxy Flexible Epoxy   | Toughened Epoxy 2214  | N/A                         | N/A   | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR                        | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR             | Toughened Epoxy Flexible Epoxy Rigid Urethane Flexible Urethane | Flexible Epoxy Flexible Urethane   | Flexible Epoxy Plastic PUR Flexible Urethane                                  |
|                               | Outdoor                             | LSE Acrylic   | Flexible Epoxy Flexible Urethane Plastic PUR                                   | Flexible Epoxy Plastic PUR                 | Flexible Epoxy  | Flexible Epoxy   | Flexible Epoxy  | N/A                         | N/A   | Semi-rigid Urethane Flexible Epoxy Flexible Urethane Plastic PUR                      | Semi-rigid Urethane Flexible Epoxy Plastic PUR                             | Flexible Epoxy Flexible Urethane                                | Flexible Epoxy Flexible Urethane   | Flexible Epoxy Plastic PUR Flexible Urethane                                  |
| Wood                          | LSE Acrylic Surface Insensitive CA* | Wood PUR Flexible Epoxy Rigid Urethane Surface Insensitive CA | Plastic PUR Surface Insensitive CA*  | Toughened Epoxy Plastic PUR Flexible Epoxy | Plastic PUR Toughened Epoxy Rigid Epoxy Flexible Epoxy Surface Insensitive CA | Plastic PUR Toughened Epoxy  | N/A   | N/A                         | Semi-rigid Urethane Toughened Epoxy Rigid Urethane Flexible Epoxy Plastic PUR | Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR                        | Flexible Epoxy Plastic PUR Flexible Urethane                               | Flexible Epoxy Plastic PUR Flexible Urethane                    | Wood PUR Rigid Epoxy Toughened Epoxy Rigid Urethane Surface Insensitive CA |   |

**BEST IN CLASS PRODUCT** **SUGGESTED ALTERNATE PRODUCT** \*with primer

# 3M™ Scotch-Weld™ Structural Adhesives

## Coverage Guide

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

| Bead Size Dimension* mm | m per 45 mL (10:1 Cart.) | m per 48,5 - 50 mL (1:1 & 2:1 Cart.) | m per 400 mL (1:1 & 2:1 Cart.) | m per 490 mL (10:1 Cart.) |
|-------------------------|--------------------------|--------------------------------------|--------------------------------|---------------------------|
| 12.7 mm                 | 0.7m                     | 0.8 m                                | 6 m                            | 8 m                       |
| 9.5 mm                  | 1 m                      | 1 m                                  | 11 m                           | 14 m                      |
| 6.4 mm                  | 3 m                      | 3 m                                  | 25 m                           | 31 m                      |
| 3.2 mm                  | 11 m                     | 13 m                                 | 101 m                          | 123 m                     |
| 1.6 mm                  | 45 m                     | 50 m                                 | 400 m                          | 488 m                     |

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

| Wet Thickness mm | m <sup>2</sup> /liter | liter/1,000 m <sup>2</sup> |
|------------------|-----------------------|----------------------------|
| 0.8 mm           | 1 m <sup>2</sup>      | 794 liter                  |
| 0.64 mm          | 1.5 m <sup>2</sup>    | 635 liter                  |
| 0.13 mm          | 8 m <sup>2</sup>      | 127 liter                  |

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

| Bead Size Dimension* mm | Approx. m/liter | Approx. liter/1,000m |
|-------------------------|-----------------|----------------------|
| 12.7 mm                 | 16 m            | 63 liter             |
| 9.5 mm                  | 28 m            | 36 liter             |
| 6.4 mm                  | 63 m            | 16 liter             |
| 3.2 mm                  | 252 m           | 4 liter              |
| 1.6 mm                  | 1,000 m         | 1 liter              |

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

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

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

3M's Low Odor and MMA Acrylic Adhesives are designed for all of your sign application needs. They provide excellent impact strength, high peel strength and greatly extended shelf life compared to ordinary structural adhesives. With high structural strength, fast cure and environmental resistance, they are the first choice for the sign industry. DP8805NS, DP8810NS, DP8825NS, DP8405NS, DP8407NS, DP8410NS and DP8425NS





## 3M™ Scotch-Weld™ Rigid Epoxies

| Product (Color)                   | Key Features                         | Mix Ratio (Volume) B:A | Approx. Viscosity at 24°C | Approx. Mixed Work Life at 24°C | Approx. Time to Handling Strength at 24°C | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |      | Size  | Stock #  |                  |
|-----------------------------------|--------------------------------------|------------------------|---------------------------|---------------------------------|---|-----------------------------------|--------------------|------|------|---|--|------------------|
|                                   |                                      |                        |                           |                                 |   |                                   | -55°C              | 24°C | 82°C |   |  |                  |
| DP100<br>100<br>(Clear)           | General purpose Rigid bonds          | 1:1                    | 13,000                    | 5 minutes                       | 20 minutes                                | 4                                 | 6                  | 10   | 2    | 48.5mL<br>200mL<br>5 gal. pail A<br>5 gal. pail B                     | 7100200484<br>7100075490<br>7100086557<br>7100086558               | *                |
| DP100FR<br>100FR<br>(Off-White)   | Flame retardant<br>UL94 V-0 rating   | 1:1                    | 80,000                    | 6 minutes                       | 20 minutes                                | 4                                 | 9                  | 15   | 6    | 48.5mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B                     | 7100148760<br>7000028577<br>7010366158<br>7010366123               | *                |
| DP100NS<br>100NS<br>(Translucent) | General purpose Non-sag              | 1:1                    | 95,000                    | 5 minutes                       | 20 minutes                                | 4                                 | 6                  | 10   | 2    | 48.5mL<br>200mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B            | 7100148744<br>7100014024<br>7100082554<br>7010367412<br>7010295308 |                  |
| DP270<br>270<br>(Black)           | Rigid potting compound Non-corrosive | 1:1                    | 12,000                    | 60 minutes                      | 3 hours                                   | 4                                 | 8                  | 17   | 2    | 48.5mL<br>400mL<br>Gallon kit<br>5 gal. pail A<br>5 gal. pail B       | 7100200491<br>7100082565<br>7000121253<br>7000046463<br>7000046439 | *<br>*<br>*<br>* |
| DP270<br>270<br>(Clear)           | Rigid potting compound Non-corrosive | 1:1                    | 12,000                    | 60 minutes                      | 3 hours                                   | 4                                 | 8                  | 17   | 2    | 48.5mL<br>5 gal. pail A<br>5 gal. pail B                              | 7100200493<br>7000028575<br>7000028567                             | *                |
| 1751 B/A<br>(Gray)                | Excellent void filler Rigid bonds    | 3:2                    | 700,000                   | 45 minutes                      | 10 hours                                  | 7                                 | 10                 | 14   | 3    | Pint kit<br>Quart kit<br>Gallon kit<br>5 gal. pail A<br>5 gal. pail B | 7000046336<br>7000046337<br>7000046339<br>7010309727<br>7010367210 |                  |
| 1838 B/A<br>(Green)               | Multi-purpose Rigid bonds            | 4:5                    | 400,000                   | 60 minutes                      | 8 hours                                   | 7                                 | 10                 | 21   | 3    | 2 oz. tube kit<br>Quart kit<br>5 gal. pail A<br>5 gal. pail B         | 7000000810<br>7000046340<br>7010309728<br>7010367213               | *                |
| 3520 B/A<br>(Translucent)         | Tough durable bonds                  | 1:1                    | 12,000                    | 230 minutes                     | 8 hours                                   | 7                                 | 27                 | 35   | 5    | 300mL kit<br>2 L kit<br>10 L kit                                      | 7100183880<br>7100185158<br>7100183879                             | *<br>*<br>*      |

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

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\* These products are in stock

# 3M™ Scotch-Weld™ Flexible Epoxies

| Product (Color)                                  | Key Features                                | Mix Ratio (Volume) B:A | Approx. Viscosity at 24°C | Approx. Mixed Work Life at 24°C | Approx. Time to Handling Strength at 24°C | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |               | Size           | Stock #    |   |
|--|---|------------------------|---------------------------|---------------------------------|---|-----------------------------------|--------------------|------|---------------|----------------|------------|---|
|  |   |                        |                           |                                 |   |                                   | -55°C              | 24°C | 82°C          |                |            |   |
| KEY PRODUCT<br>DP100 Plus<br>100 Plus<br>(Clear) | Very flexible<br>Colorless                  | 1:1                    | 8,500                     | 4 minutes                       | 20 minute                                 | 98                                | 21                 | 24   | 1             | 48.5mL         | 7100148750 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 200mL          | 7100069498 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 400mL          | 7000121255 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail A  | 7100046020 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      | 5 gal. pail B | 7100084539     |            |   |
| KEY PRODUCT<br>DP105<br>105<br>(Clear)           | Very flexible<br>Colorless                  | 1:1                    | 6,500                     | 5 minutes                       | 20 minute                                 | 89                                | 24                 | 14   | 1             | 48.5mL         | 7100200485 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail A  | 7000000856 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail B  | 7000000850 |   |
| DP110<br>110<br>(Gray)                           | General purpose<br>Flexible bonds           | 1:1                    | 55,000                    | 8 minutes                       | 20 minute                                 | 71                                | 19                 | 24   | 2             | 48.5mL         | 7100200487 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail A  | 7010299362 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail B  | 7010299357 |   |
| DP110<br>110<br>(Translucent)                    | General purpose<br>Flexible bonds           | 1:1                    | 50,000                    | 8 minutes                       | 20 minute                                 | 71                                | 17                 | 17   | 1             | 48.5mL         | 7100200486 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 400mL          | 7000079998 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail A  | 7010366163 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail B  | 7010366143 |   |
| KEY PRODUCT<br>DP125<br>125<br>(Gray)            | High performance<br>Very flexible bonds     | 1:1                    | 52,500                    | 25 minutes                      | 2.5 hours                                 | 160                               | 23                 | 30   | 3             | 48.5mL         | 7100200488 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 400mL          | 7100076727 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail A  | 7100084588 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail B  | 7100084538 | ★ |
| DP125<br>125<br>(Translucent)                    | High performance<br>Very flexible bonds     | 1:1                    | 15,000                    | 25 minutes                      | 2.5 hours                                 | 151                               | 28                 | 17   | 1             | 48.5mL         | 7100148734 |   |
| DP190<br>(Translucent)                           | High performance<br>Flexible bonds          | 1:1                    | 10,000                    | 80 minutes                      | 6 hours                                   | 107                               | 24                 | 8    | 1             | 48.5mL         | 7100148752 |   |
| DP190<br>(Gray)                                  | High performance<br>Slightly flexible bonds | 1:1                    | 80,000                    | 90 minutes                      | 10 hours                                  | 89                                | 10                 | 17   | 3             | 48.5mL         | 7100200489 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 400mL          | 7100200490 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 10 Liter Kit   | 7000080020 | ★ |
| 2216 B/A<br>(Gray)                               | High performance<br>Very flexible bonds     | 2:3                    | 80,000                    | 90 minutes                      | 10 hours                                  | 89                                | 21                 | 22   | 3             | 43mL Duo-Pak   | 7000046357 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 2 oz. tube kit | 7000000812 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 135 ml         | 7100141716 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 250 ml         | 7100141986 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 1.6 Liter Kit  | 7100141727 | ★ |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | Pint kit       | 7000046358 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | Quart kit      | 7000000815 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail A  | 7000046361 | ★ |
| 5 gal. pail B                                    | 7000046360                                  | ★                      |                           |                                 |   |                                   |                    |      |               |                |            |   |
| 2216 B/A<br>(Translucent)                        | General purpose<br>Very flexible bonds      | 1:1                    | 10,000                    | 2 hours                         | 14 hours                                  | 125                               | 21                 | 12   | 1             | 2 oz. tube kit | 7000046479 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | Quart kit      | 7000000861 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | Gallon kit     | 7000046480 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail A  | 7000046494 |   |
|  |   |                        |                           |                                 |   |                                   |                    |      |               | 5 gal. pail B  | 7000121307 |   |
| 7838 B/A<br>(Tan)                                | General purpose<br>Flexible bonds           | 10:12                  | 160,000                   | 180 minutes                     | 12 hours                                  | 27                                | 18                 | 23   | 6             | 2 kg kit       | 7100185187 | ★ |


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# 3M™ Scotch-Weld™ Toughened Epoxies

| Product (Color)  | Key Features   | Mix Ratio (Volume) B:A | Approx. Viscosity at 24°C | Approx. Mixed Work Life at 24°C | Approx. Time to Handling Strength at 24°C | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |      | Size           | Stock #    |   |
|--|--|------------------------|---------------------------|---------------------------------|---|-----------------------------------|--------------------|------|------|----------------|------------|---|
|  |  |                        |                           |                                 |   |                                   | -55°C              | 24°C | 82°C |                |            |   |
| DP410 (Off-White)  | Tough durable bonds<br>High impact resistance                  | 2:1                    | 70,000                    | 12 minutes                      | 80 minutes                                | 96                                | 28                 | 38   | 8    | 50mL           | 7100200494 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7100200495 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A  | 7100055705 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B  | 7100055833 | ★ |
| DP410 (Black)  | Tough durable bonds<br>High impact resistance                  | 2:1                    | 70,000                    | 12 minutes                      | 80 minutes                                | 96                                | 28                 | 38   | 8    | 5 gal. pail A  | 7100055704 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B  | 7100055833 | ★ |
| DP420 420 (Black)  | Tough durable bonds<br>High impact resistance                  | 2:1                    | 30,000                    | 20 minutes                      | 2 hours                                   | 133                               | 31                 | 31   | 9    | 50mL           | 7100148731 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 200mL          | 7100007956 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7100077148 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | Gallon Kit     | 7000046381 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A  | 7000000834 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B  | 7000000827 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 55 gal. drum A | 7010365967 |   |
| 55 gal. drum B   | 7010309750   |                        |                           |                                 |   |                                   |                    |      |      |                |            |   |
| DP420 (Off-White)  | Tough durable bonds<br>High impact resistance                  | 2:1                    | 30,000                    | 20 minutes                      | 2 hours                                   | 125                               | 31                 | 31   | 9    | 50mL           | 7100148736 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 200mL          | 7100077136 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7100002516 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A  | 7100001144 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B  | 7100001145 |   |
| KEY PRODUCT<br>DP420NS 420NS (Black)   | Tough durable bonds<br>Non-sag                                 | 2:1                    | 180,000                   | 20 minutes                      | 2 hours                                   | 107                               | 31                 | 31   | 9    | 50mL           | 7100148758 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7100010680 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A  | 7000000857 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B  | 7000000853 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 43 gal. drum A | 7100084536 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 43 gal. drum B | 7100084537 |   |
| DP460 460 (Off-White)  | Tough durable bonds  | 2:1                    | 30,000                    | 60 minutes                      | 4 hours                                   | 142                               | 31                 | 31   | 5    | 50mL           | 7100200496 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7100200498 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 60 Liter Kit   | 7000079870 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A  | 7000000876 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B  | 7000000875 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 55 gal. drum A | 7010366165 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 55 gal. drum B | 7100153215 |   |
| KEY PRODUCT<br>DP490 (Black)   | Tough durable bonds  | 2:1                    | 90,000                    | 90 minutes                      | 4 hours                                   | 60                                | 25                 | 31   | 14   | 50mL           | 7100200499 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7100200501 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 54 Liter Kit   | 7000079900 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 160 Liter A    | 7100199149 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 160 Liter B    | 7100199097 |   |
| DP760  | Tough durable bonds Non-sag<br>Resistance to high temperatures | 2:1                    | 200,000                   | 60 minutes                      | 6 hours                                   | 150                               | 20                 | 30   | 24   | 50mL           | 7100200504 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7100200506 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 60 Liter Kit   | 7100057461 |   |
| 7240  | Tough durable bonds  | 2:1                    | 120,000                   | 45 Min                          | 6 hours                                   | 92                                | 18                 | 27   | 12   | 400mL          | 7100042087 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 54 Liter Kit   | 7100042123 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 200 Liter A    | 7100217241 |   |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 200 Liter B    | 7100217165 |   |
| 7260 FC<br>7260 NS<br>7260 FC NS   | Tough durable bonds with high shear and peel strength          | 2:1                    | 280,000                   | 100 minutes                     | 7 hours                                   | 48                                | 24                 | 33   | 10   | 200mL          | 7100018776 |   |
|  |  |                        | 700,000                   | 400 minutes                     | 18 hours                                  |                                   |                    |      |      | 400mL          | 7000033763 | ★ |
|  |  |                        | 700,000                   | 100 minutes                     | 7 hours                                   |                                   |                    |      |      | 400mL          | 7000080008 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 400mL          | 7000080037 | ★ |
|  |  |                        |                           |                                 |   |                                   |                    |      |      | 54 Liter Kit   | 7000080132 | ★ |
| 7271   | Tough durable bonds Non-sag<br>High gap-filling                | 1:1                    | 170,000                   | 12 minutes                      | 60 minutes                                | 24                                | 23                 | 14   | 4    | 400mL          | 7100075748 | ★ |

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

| Product (Color)                 | Key Features  | Approx. Viscosity at 24°C | Cure Conditions |         | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |      |       | Size        | Stock #    |   |
|---------------------------------|---|---------------------------|-----------------|---------|-----------------------------------|--------------------|------|------|-------|-------------|------------|---|
|                                 |   |                           | Time (min.)     | Temp. C |                                   | -55°C              | 24°C | 82°C | 121°C |             |            |   |
| 2214 Hi-Temp New Formula (Gray) | High temperature strength<br>Environmental resistance | Paste                     | 60              | 121     | 4                                 | 19                 | 19   | 19   | 17    | 6 oz. cart. | 7000046474 | ★ |
|                                 |   |                           |                 |         |                                   |                    |      |      |       | 310 ml      | 7000080325 | ★ |
|                                 |   |                           |                 |         |                                   |                    |      |      |       | 1 Liter     | 7000079791 | ★ |
| 5 gal. pail                     | 7010330200  |                           |                 |         |                                   |                    |      |      |       |             |            |   |
| 2214 Regular (Gray)             | High temperature strength<br>Low temp curing          | Paste                     | 40              | 121     | 9                                 | 21                 | 31   | 31   | 10    | 6 oz. cart. | 7000000811 | ★ |
|                                 |   |                           |                 |         |                                   |                    |      |      |       | 1 quart     | 7000046356 |   |
|                                 |   |                           |                 |         |                                   |                    |      |      |       | 5 gal. pail | 7100111206 |   |

## 3M™ Scotch-Weld™ Primer

| Product (Color)   | Key Features   | Viscosity | Color | Dry time (24°C-33°C) | Dry time (88°C) | Size     | Stock #    |   |
|-------------------|--|-----------|-------|----------------------|-----------------|----------|------------|---|
| Metal Primer 3901 | Improves metal and glass adhesion and increases environmental resistance | 5         | Red   | 1 hour               | 30 minutes      | 1/2 pint | 7000000907 | ★ |

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### 3M™ Scotch-Weld™ Threadlockers

3M's Threadlocker Adhesives offer a range of products including temporary, permanent and high temperature resistance. These adhesives conform to most industry recognized standards for torque and strength. **TL70, TL42, TL43 and TL77**



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

3M™ Scotch-Weld Epoxy Adhesive DP100 Plus is a very flexible, fast-setting, two-part epoxy adhesive that cures clear and colorless. It provides a strong, permanent bond, even under vibration and impact and is flexible when cured, making it a good choice for bonding dissimilar surfaces.



## 3M™ Scotch-Weld™ Standard MMA Acrylics

| Product (Color)                              | Key Features                          | Mix Ratio (Volume) B:A | Approx. Viscosity at 24°C | Approx. Mixed Work Life at 24°C | Approx. Time to Handling Strength at 24°C | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |      | Size          | Stock #    |   |
|--|---------------------------------------|------------------------|---------------------------|---------------------------------|---|-----------------------------------|--------------------|------|------|---------------|------------|---|
|  |                                       |                        |                           |                                 |   |                                   | -29°C              | 24°C | 82°C |               |            |   |
| DP8405NS<br>8405NS<br>(Green)                | High impact Adhesion to most plastics | 10:1                   | 70,000                    | 5 minutes                       | 15 minutes                                | 89                                | 18                 | 28   | 6    | 45mL          | 7100009688 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 490mL         | 7100011056 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 1 gal. pail A | 7100102180 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B | 7100027430 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A | 7100101506 | * |
| 55 gal. drum B                               | 7100084534                            | *                      |                           |                                 |   |                                   |                    |      |      |               |            |   |
| KEY PRODUCT<br>DP8407NS<br>8407NS<br>(Gray)  | High impact Adhesion to most plastics | 10:1                   | 20,000                    | 7 minutes                       | 24 minutes                                | 89                                | 23                 | 31   | 10   | 45mL          | 7100179482 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 490mL         | 7100179480 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 1 gal. pail A | 7100179264 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B | 7100105384 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A | 7100179442 | * |
| 55 gal. drum B                               | 7100104987                            | *                      |                           |                                 |   |                                   |                    |      |      |               |            |   |
| KEY PRODUCT<br>DP8410NS<br>8410NS<br>(Green) | High impact Adhesion to most plastics | 10:1                   | 70,000                    | 10 minutes                      | 25 minutes                                | 89                                | 25                 | 28   | 6    | 45mL          | 7100024055 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 490mL         | 7100024045 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 1 gal. pail A | 7100102180 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B | 7100084532 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A | 7100101506 | * |
| 55 gal. drum B                               | 7100084535                            | *                      |                           |                                 |   |                                   |                    |      |      |               |            |   |
| KEY PRODUCT<br>DP8425NS<br>8425NS<br>(Green) | High impact Adhesion to most plastics | 10:1                   | 70,000                    | 25 minutes                      | 50 minutes                                | 89                                | 26                 | 26   | 6    | 45mL          | 7100078165 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 490mL         | 7100078166 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 1 gal. pail A | 7100102180 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail B | 7010415048 | * |
|  |                                       |                        |                           |                                 |   |                                   |                    |      |      | 5 gal. pail A | 7100101506 | * |
| 55 gal. drum B                               | 7100084535                            | *                      |                           |                                 |   |                                   |                    |      |      |               |            |   |

## 3M™ Scotch-Weld™ Low Odor Acrylics

|  |   |      |        |            |            |    |   |    |   |               |            |   |
|--|---|------|--------|------------|------------|----|---|----|---|---------------|------------|---|
| KEY PRODUCT<br>DP810<br>810<br>(Tan)         | Tough durable bonds<br>High impact resistance | 1:1  | 20,000 | 10 minutes | 20 minutes | 53 | 8 | 25 | 3 | 48.5mL        | 7100200509 | * |
|  |   |      |        |            |            |    |   |    |   | 400mL         | 7100200483 | * |
|  |   |      |        |            |            |    |   |    |   | 10 Liter Kit  | 7000079966 | * |
| KEY PRODUCT<br>DP8805NS<br>8805NS<br>(Green) | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 5 minutes  | 10 minutes | 53 | 5 | 25 | 6 | 45mL          | 7100098631 | * |
|  |   |      |        |            |            |    |   |    |   | 490mL         | 7100097636 | * |
|  |   |      |        |            |            |    |   |    |   | 1 gal. pail A | 7100102180 | * |
|  |   |      |        |            |            |    |   |    |   | 5 gal. pail B | 7100097693 | * |
|  |   |      |        |            |            |    |   |    |   | 5 gal. pail A | 7100101506 | * |
| 55 gal. drum B                               | 7100097673                                    | *    |        |            |            |    |   |    |   |               |            |   |
| KEY PRODUCT<br>DP8810NS<br>8810NS<br>(Green) | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 10 minutes | 20 minutes | 53 | 6 | 25 | 6 | 45mL          | 7100097574 | * |
|  |   |      |        |            |            |    |   |    |   | 490mL         | 7100075409 | * |
|  |   |      |        |            |            |    |   |    |   | 1 gal. pail A | 7100102180 | * |
|  |   |      |        |            |            |    |   |    |   | 5 gal. pail B | 7100097704 | * |
|  |   |      |        |            |            |    |   |    |   | 5 gal. pail A | 7100101506 | * |
| 55 gal. drum B                               | 7100097626                                    | *    |        |            |            |    |   |    |   |               |            |   |
| KEY PRODUCT<br>DP8810NS<br>(Gray)            | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 10 minutes | 20 minutes | 53 | 6 | 25 | 6 | 45mL          | 7100097474 | * |
| KEY PRODUCT<br>DP8825NS<br>8825NS<br>(Green) | Low odor<br>Fast rate of strength build       | 10:1 | 80,000 | 25 minutes | 50 minutes | 36 | 7 | 21 | 6 | 45mL          | 7100067297 | * |
|  |   |      |        |            |            |    |   |    |   | 490mL         | 7100068120 | * |
|  |   |      |        |            |            |    |   |    |   | 1 gal. pail A | 7100102180 | * |
|  |   |      |        |            |            |    |   |    |   | 5 gal. pail B | 7100067291 | * |
|  |   |      |        |            |            |    |   |    |   | 5 gal. pail A | 7100101506 | * |
| 55 gal. drum B                               | 7100084533                                    | *    |        |            |            |    |   |    |   |               |            |   |

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\* These products are in stock

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

| Product (Color)        | Key Features  | Mix Ratio (Volume) B:A | Approx. Viscosity at 24°C | Approx. Mixed Work Life at 24°C | Approx. Time to Handling Strength at 24°C | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |      | Size   | Stock #  |                  |
|------------------------|---|------------------------|---------------------------|---------------------------------|---|-----------------------------------|--------------------|------|------|--|--|------------------|
|                        |   |                        |                           |                                 |   |                                   | -29°C              | 24°C | 66°C |  |  |                  |
| DP8005 (Black)         | Bonds polyolefins and low surface energy materials            | 10:1                   | 25,000                    | 3 minutes                       | 3 hours                                   | N/A                               | 6                  | 14   | 3    | 45mL<br>490mL                                      | 7100089475<br>7100089476                             | *<br>*           |
| DP8005 (Off-White)     | Bonds polyolefins and low surface energy materials            | 10:1                   | 25,000                    | 3 minutes                       | 3 hours                                   | N/A                               | 5                  | 15   | 3    | 38mL<br>265mL<br>10 Liter pail B<br>2 Liter pail A | 7000080088<br>7000079932<br>7000080038<br>7000080039 | *<br>*<br>*<br>* |
| DP8010 8010 (Blue)     | Bonds polyolefins and low surface energy materials            | 10:1                   | 20,000                    | 10 minutes                      | 1 hour                                    | N/A                               | 19                 | 19   | 3    | 45mL<br>490mL                                      | 7100036717<br>7100036719                             | *<br>*           |
| DP8010NS 8010NS (Blue) | Bonds polyolefins and low surface energy materials<br>Non-sag | 10:1                   | 65,000                    | 10 minutes                      | 1 hour                                    | N/A                               | 19                 | 19   | 3    | 45mL<br>490mL                                      | 7100036721<br>7100036723                             |                  |

KEY PRODUCT

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

| Product (Color)      | Key Features  | Mix Ratio (Volume) B:A | Approx. Viscosity at 24°C | Approx. Mixed Work Life at 24°C | Approx. Time to Handling Strength at 24°C | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |      | Size  | Stock #  |        |
|----------------------|---|------------------------|---------------------------|---------------------------------|---|-----------------------------------|--------------------|------|------|---|--|--------|
|                      |   |                        |                           |                                 |   |                                   | -40°C              | 24°C | 82°C |   |  |        |
| DP6310NS (Green)     | Multi-purpose Energy absorbing<br> | 1:1                    | Non-sag paste             | 9 minutes                       | 45 minutes                                | 36                                | 24                 | 25   | 6    | 48.5mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>50 gal. drum A<br>50 gal. drum B | 7100109829<br>7100109830<br>7100143960<br>7100143915<br>7010415316<br>7010412199 | *<br>* |
| DP6330NS (Green)     | Multi-purpose Energy absorbing<br> | 1:1                    | Non-sag paste             | 30 minutes                      | 2 hours                                   | 36                                | 25                 | 25   | 7    | 48.5mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>50 gal. drum A<br>50 gal. drum B | 7100109828<br>7100109827<br>7100143961<br>7100143701<br>7010409611<br>7010366145 | *<br>* |
| 3535 B/A (Off-White) | Multi-purpose Semi-rigid bonds  | 1:1                    | 30,000                    | 3 minutes                       | 30 minutes                                | 44                                | 17                 | 14   | 2    | 2 oz. kit<br>5 gal. pail A<br>5 gal. pail B   | 7000046483<br>7010366160<br>7010330223   | *      |

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## 3M™ Scotch-Weld™ Flexible Urethanes

| Product (Color)             | Key Features             | Mix Ratio (Volume) B:A | Approx. Viscosity at 24°C | Approx. Mixed Work Life at 24°C | Approx. Time to Handling Strength at 24°C | Floating Roller Peel N/cm at 24°C | Overlap Shear: MPa |      |      | Size  | Stock #  |        |
|-----------------------------|--------------------------|------------------------|---------------------------|---------------------------------|---|-----------------------------------|--------------------|------|------|---|--|--------|
|                             |                          |                        |                           |                                 |   |                                   | -40°C              | 24°C | 82°C |   |  |        |
| DP604NS<br>604NS<br>(Black) | Flexible<br>Non-sag      | 1:1                    | Paste                     | 4 minutes                       | 20 minutes                                | 53                                | 10                 | 4    | 2    | 48.5mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B | 7100148738<br>7100069452<br>7010365926<br>7010367265<br>7010329538<br>7010412243 | ★      |
| DP610                       | Flexible                 | 1:1                    | 30,000                    | 10 minutes                      | 2 hours                                   | 195                               | 34                 | 23   | 3    | 48.5mL  | 7100200503   | ★      |
| DP620NS<br>620NS<br>(Black) | Semi-flexible<br>Non-sag | 1:1                    | Paste                     | 20 minutes                      | 4 hours                                   | 71                                | 21                 | 17   | 3    | 48.5mL<br>400mL<br>5 gal. pail A<br>5 gal. pail B<br>55 gal. drum A<br>55 gal. drum B | 7100148737<br>7000046372<br>7010329537<br>7010367262<br>7010301034<br>7010309744 | ★<br>★ |
| DP609 (Tan)                 | Flexible                 | 1:1                    | 30,000                    | 7 minutes                       | 45 minutes                                | 70                                | 17                 | 14   | 2    | 48.5mL<br>400mL   | 7100200502<br>7000080396   | ★<br>★ |
| 3549<br>(Brown)             | Tough flexible<br>bonds  | 1:1                    | 25,000                    | 60 minutes                      | 8 hours                                   | 107                               | 21                 | 14   | 3    | 2 oz. kit<br>5 gal. pail A<br>5 gal. pail B   | 7000046484<br>7100041738<br>7100041737   |        |

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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™ Epoxy Adhesive

3M's Epoxy Adhesives can replace mechanical fasteners, screws, rivets and spot welds in many applications. **DP420 NS**



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

| Product (Color)   | Key Features  | Viscosity @ 121°C | Approximate Open Time at 24°C | Approximate Time to Handling Strength at 24°C | Shore D | Elongation % | Size                                | Stock #                                |   |
|-------------------|---|-------------------|-------------------------------|---|---------|--------------|-------------------------------------|--|---|
| TE030 (Off-White) | Fast set time<br>High viscosity                     | 16,000            | 1 minute                      | 30 seconds                                    | 60      | 725          | 1/10 gal.<br>5 gal.<br>55 gal. drum | 7000046536<br>7010310236<br>7010367598 |   |
| TE100 (Off-White) | Medium set time<br>Thin bond lines                  | 7,000             | 2 minutes                     | 60 seconds                                    | 61      | 675          | 1/10 gal.<br>5 gal.                 | 7000028590<br>7010295326               | * |
| TE200 (Off-White) | Medium set time<br>Low viscosity<br>Thin bond lines | 3,000             | 4 minutes                     | 120 seconds                                   | 60      | 625          | 1/10 gal.<br>2 kilo                 | 7000000905<br>7000046540               | * |

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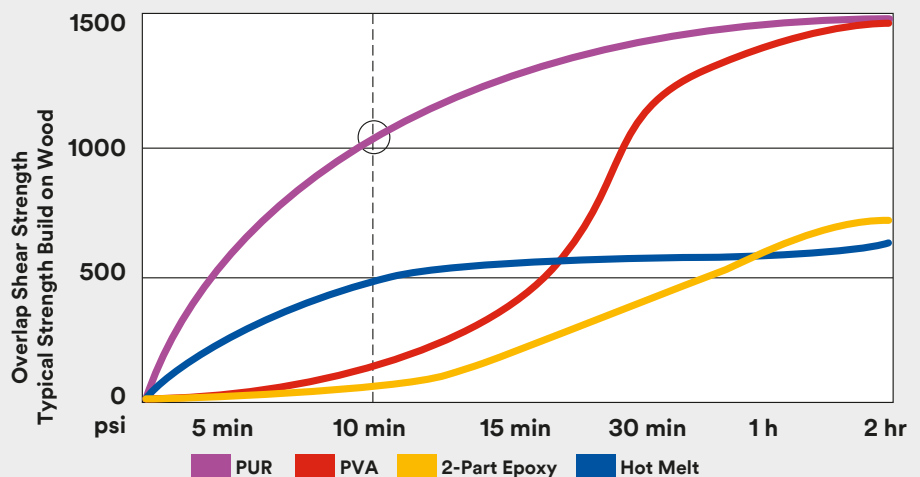
\* These products are in stock

3M™ Scotch-Weld™  
PUR Easy 250  
Applicator



### 3M™ Scotch-Weld™ PUR Adhesives

PUR Adhesives enhance productivity with fast green strength. Shorter clamp times and reduced need for third-hand mechanical fasteners help speed up your production process without sacrificing ultimate strength.



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

| Product (Color)                  | Key Features   | Viscosity @ 121°C | Approximate Open Time at 24°C | Approximate Time to Handling Strength at 24°C | Shore D | Elongation % | Size  | Stock #   |             |
|----------------------------------|--|-------------------|-------------------------------|---|---------|--------------|---|---|-------------|
| TE031 (Black)                    | Fast set time, bonds a wide variety of plastics                            | 13,000            | 2 minutes                     | 30 seconds                                    | 50      | 725          | 1/10 gal.<br>5 gal.                           | 700000903<br>7100031123                             | *           |
| TE031 (Off-White)                | Fast set time, bonds a wide variety of plastics                            | 13,000            | 2 minutes                     | 30 seconds                                    | 50      | 725          | 1/10 gal.<br>2 kilo<br>5 gal.                 | 700000902<br>7000028589<br>7100096731               | *<br>*      |
| TS230 (Black)                    | Extrudable/sprayable, long open time, bonds plastics to metal, glass, wood | 9,000             | 4 minutes                     | 150 seconds                                   | 45      | 700          | 1/10 gal.<br>2 kilo<br>5 gal.<br>55 gal. drum | 700000906<br>7000046541<br>7000121361<br>7100179521 | *           |
| KEY PRODUCT<br>TS230 (Off-White) | Extrudable/sprayable long open time, bonds plastics to metal, glass, wood  | 9,000             | 4 minutes                     | 150 seconds                                   | 45      | 700          | 1/10 gal.<br>2 kilo<br>18 kg<br>55 gal. drum  | 700000898<br>7000046534<br>7000080044<br>7100104259 | *<br>*<br>* |

## 3M™ Scotch-Weld™ PUR Applicator/Hardware

| Product  | Description  | Stock #  |                         |
|--|--|--|-------------------------|
| Applicator   | PUR Easy 250 Applicator, pneumatically dispenses 1/10 gal. cartridges  | EU: 7000028622<br>UK: 7000046655   | *<br>*                  |
| Cartridge Nozzle   | High Temperature Nozzles for PUR 1/10 gal. cartridges (Sample, 5/bag)  | 7000031234   |                         |
| Repair Kits and Replacement Parts                              | Adhesive Applicator Housing/Shroud Assembly Kit<br>Applicator Nozzle Shroud<br>Applicator Air Valve Kit<br>Applicator Swivel Connector<br>Applicator End Cap   | 7000028623<br>7000148288<br>7000046652<br>7000046653<br>7000046666               |                         |
| Alternate Nozzle System<br>not for use with disposable nozzles | Applicator Main Nozzle Assembly (includes nozzle, tip, tip cap and valve)<br>Applicator Main Nozzle<br>Applicator Extension Tip, .072 in orifice<br>Applicator Tip, .063 in orifice<br>Applicator Tip Cap<br>Applicator Valve Assembly | 7000027561<br>7000046672<br>7000046669<br>7000046670<br>7100005819<br>7000046650 | *<br>*<br><br><br><br>* |

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

| Product (Color)              | Key Features                                    | Typical Viscosity | Temperature Range | Time to Handling | Full Cure (Hours) | Size                              | Stock #                  |        |
|------------------------------|---|-------------------|-------------------|------------------|-------------------|-----------------------------------|--------------------------|--------|
| PR20                         | General purpose, low viscosity plastic bonder   | 20                | -54° to 82°C      | 10-20 sec.       | 24                | 20 gram bottle                    | 7100033988               | ★      |
| KEY PRODUCT<br>PR100 (Clear) | General purpose, low viscosity plastic bonder   | 100               | -54° to 82°C      | 10-20 sec.       | 24                | 20 gram bottle                    | 7100033657               | ★      |
|                              |   |                   |                   |                  |                   | 50 gram bottle                    | 7100033726               | ★      |
|                              |   |                   |                   |                  |                   | 500 gram bottle                   | 7100033708               | ★      |
| PR1500 (Clear)               | General purpose, high viscosity for gap filling | 1,500             | -54° to 82°C      | 20-60 sec.       | 24                | 50 gram bottle<br>500 gram bottle | 7100034078<br>7100034071 | ★<br>★ |

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

| Product (Color) | Key Features                                 | Typical Viscosity | Temperature Range | Time to Handling | Full Cure (Hours) | Size                             | Stock #                  |        |
|-----------------|--|-------------------|-------------------|------------------|-------------------|----------------------------------|--------------------------|--------|
| SI Gel (Clear)  | Fast cure, gel viscosity for max gap filling | Gel               | -54° to 82°C      | 20-60 sec.       | 24                | 20 gram bottle<br>300 gram cart. | 7100034061<br>7100027510 | ★<br>★ |
| SI100 (Clear)   | Low viscosity for medium gaps                | 100               | -54° to 82°C      | 3-20 sec.        | 24                | 20 gram bottle                   | 7100034075               | ★      |
| SI1500 (Clear)  | High viscosity for gap filling               | 1,500             | -54° to 82°C      | 5-60 sec.        | 24                | 20 gram bottle                   | 7100040836               | ★      |

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

| Product (Color) | Key Features   | Typical Viscosity | Temperature Range | Time to Handling | Full Cure (Hours) | Size  | Stock #                                |             |
|-----------------|--|-------------------|-------------------|------------------|-------------------|---|--|-------------|
| SF20 (Clear)    | Fast cure<br>Optimum performance on wide range of rubbers and plastics | 20                | -54° to 82°C      | 4-30 sec.        | 24                | 20 gram bottle                                      | 7100034279                             | ★           |
|                 |  |                   |                   |                  |                   | 500 gram bottle                                     | 7100040837                             | ★           |
| SF100 (Clear)   | Fast cure, high strength with EPDM and other elastomers                | 100               | -54° to 82°C      | 4-30 sec.        | 24                | 20 gram bottle<br>50 gram bottle<br>500 gram bottle | 7100034060<br>7100034525<br>7100033985 | ★<br>★<br>★ |

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

| Product (Color) | Key Features  | Typical Viscosity | Time to Handling | Full Cure (Hours) | Size           | Stock #    |   |
|-----------------|---|-------------------|------------------|-------------------|----------------|------------|---|
| AC77            | Instant adhesive primer for bonding of difficult-to-bond plastics such as polyethylene, polypropylene and polyacetal  | <3                | 1-5 sec.         | 24                | 20 ml bottle   | 7100027600 | ★ |
|                 |   |                   |                  |                   | 1 Liter bottle | 7100027284 | ★ |
| AC11            | Suitable for use with slower curing, high viscosity grades, and with porous substrates where the adhesive must cure before being absorbed into the substrate. | 1                 | 10-30 sec.       | 24                | 200 ml aerosol | 7100027507 | ★ |

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

| Product (Color) | Key Features   | Typical Viscosity | Temperature Range | Time to Handling | Full Cure (Hours) | Size                                       | Stock #                                |             |
|-----------------|--|-------------------|-------------------|------------------|-------------------|--|--|-------------|
| TL42 (Blue)     | Nutlock - medium strength, general purpose                               | 1,200             | -54° to 149°C     | < 30 minutes     | 24                | 10mL bottle<br>50mL bottle<br>250mL bottle | 7100034098<br>7100033986<br>7100034072 | *<br>*<br>* |
| TL43 (Blue)     | Oil tolerant, medium strength, general purpose                           | 3,300             | -54° to 149°C     | < 30 minutes     | 24                | 50mL bottle<br>250mL bottle                | 7100034008<br>7100034865               | *<br>*      |
| TL70            | High Strength Threadlocker   | 500               | -54° to 149°C     | < 30 minutes     | 24                | 50mL bottle<br>250mL bottle                | 7100034948<br>7100034849               | *<br>*      |
| TL77 (Red)      | Heavy duty permanent for fasteners up to 1.5" (38mm) with coarse threads | 7,000             | -54° to 149°C     | < 30 minutes     | 24                | 50mL bottle                                | 7100038708                             | *           |

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

|               |   |        |               |            |    |           |            |   |
|---------------|---|--------|---------------|------------|----|-----------|------------|---|
| PS77 (Yellow) | Fast curing pipe sealant with medium-high viscosity | 18,000 | -54° to 204°C | 15-30 mins | 24 | 50mL tube | 7100034142 | * |
|---------------|---|--------|---------------|------------|----|-----------|------------|---|

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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. Just a single drop per square inch bonds several thousand pounds of holding power. They provide proven, world record strength with a hold of 8 metric tons. PR20, PR100 and PR1500












## Applicators

| Product  | Stock #    | Product Features  |   |
|--|------------|---|---|
| Manual Applicator for 35 ml/38 ml/45 ml/48,5 ml/50 ml cartridges | 7100205939 | <ul style="list-style-type: none"> <li>• Lightweight and mobile handset</li> <li>• Suitable for smaller and medium volumes</li> </ul> |  |
| Manual Applicator for 200 ml/250 ml cartridges                   | 7000046634 | <ul style="list-style-type: none"> <li>• Mobile handset</li> </ul>  |  |
| Manual Applicator for 400 ml cartridges                          | 7000043081 | <ul style="list-style-type: none"> <li>• Suitable for big volumes</li> </ul>  |  |
| Pneumatic Applicator for 50 ml cartridges (for 2:1 and 1:1)      | 7000070273 | <ul style="list-style-type: none"> <li>• Allows precise and fatigue-free work</li> </ul>  |  |
| Pneumatic Applicator for 400 ml cartridges                       | 7000110542 | <ul style="list-style-type: none"> <li>• Allows precise and fatigue-free work</li> </ul>  |  |
| Pneumatic Applicator for 490 ml cartridges                       | 7000062908 | <ul style="list-style-type: none"> <li>• Allows precise and fatigue-free work</li> </ul>  |  |

## Plungers

| Product                 | Stock #    |   |
|-------------------------|------------|---|
| Plunger for 2:3         | 7010309947 |  |
| Plunger for 10:1        | 7000062909 |  |
| Plunger for 1:1 and 2:1 | 7000006768 |  |

## Nozzles

| Product   | Stock #    | approx. length in mm |   |
|---|------------|----------------------|---|
| Quadro mixing nozzle for 45 ml cartridges             | 7100202930 | 90                   |  |
| Quadro mixing nozzle for 48,5 ml or 50 ml cartridges  | 7100104991 | 85                   |  |
| Helical mixing nozzle for 48,5 ml or 50 ml cartridges | 7100148766 | 157                  |  |
| Quadro mixing nozzle for 400 ml cartridges (for 7172) | 7000062444 | 145                  |  |
| Quadro mixing nozzle for 490 ml cartridges            | 7100015959 | 240                  |  |
| Mixing nozzle for 38 ml cartridges (for DP8005)       | 7000034634 | 105                  |  |
| Mixing nozzle for 265 ml cartridges (for DP8005)      | 7000087692 | 185                  |  |
| Mixing nozzle for 200 ml or 400 ml cartridges         | 7000043674 | 275                  |  |
| Mixing nozzle for 400 ml cartridges (for DP6310/6330) | 7000028616 | 127                  |  |

# Surface Preparation Tips

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

## METALS

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

## PLASTICS AND RUBBERS

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

## GLASS

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



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