

# 3M™ Scotch-Weld™ Structural Adhesive "Lead" Products

| Product (Color)             | Key Features  | Mix Ratio (Volume) B:A | Approximate Viscosity at 75°F (24°C) (cp)   | Open Time (Work Life) | Set Time      | Approximate Time to Handling Strength at 75°F (24°C) | Floating Roller (Ball Peel) at 75°F (24°C) | Overlap Shear (psi) |   |  | Long Term Temperature Range  | Size  | UPC   | Stock #  |
|-----------------------------|---|------------------------|---|-----------------------|---------------|--|--|---------------------|---|--|--|---|---|--|
|                             |   |                        |   |                       |               |  |  | -67°F (-55°C)       | 75°F (24°C)   | 180°F (82°C)   |  |   |   |  |
| DP100 Plus 100 Plus (Clear) | Flexible bonds<br>Colorless   | 1:1                    | 8,500                                       | 4 minutes             | N/A           | 20 minute  | 55   | 3,000               | 3,500   | 200  | -67F - 325F  | 50ml<br>200ml<br>400ml<br>5 gal. pail B<br>5 gal. pail A  | 00-021200-87195-5<br>00-021200-87266-2<br>00-021200-87267-9<br>00-021200-87197-9<br>00-021200-87198-6   | 62-3272-1435-9<br>62-3272-3830-9<br>62-3272-3530-5<br>62-3272-8530-0<br>62-3372-8530-8                                     |
| DP125 125 (Gray)            | High performance<br>Flexible bonds  | 1:1                    | 52,500                                      | 25 minutes            | N/A           | 2.5 hours  | 85   | 3,400               | 4,300   | 400  | -67F - 325F  | 50ml<br>200ml<br>400ml<br>5 gal. pail B<br>5 gal. pail A  | 00-002100-87211-2<br>00-002100-87842-8<br>00-002100-87843-5<br>00-002100-87217-4<br>00-002100-87218-1   | 63-3291-1435-9<br>62-3291-3830-9<br>62-3291-3530-5<br>62-3293-8530-6<br>62-3393-8530-4                                     |
| DP420NS 420NS (Black)       | Tough durable bonds<br>Non-sag  | 2:1                    | 180,000                                     | 20 minutes            | N/A           | 2 hours  | 60   | 4,500               | 4,500   | 1,250  | -67F - 350F  | 37ml<br>200ml<br>400ml<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B<br>55 gal. drum A                                    | 00-021200-39285-6<br>00-021200-39286-3<br>00-021200-39287-0<br>00-021200-56587-8<br>00-021200-31309-7<br>00-048011-58132-3<br>00-048011-58133-0 | 62-3299-1435-2<br>62-3299-3832-8<br>62-3299-3532-4<br>62-3299-8535-2<br>62-3399-8530-1<br>62-3299-9530-2<br>62-3399-9530-0 |
| DP8010 8010 Blue            | Bonds polyolefins and low surface energy materials  | 10:1                   | 20,000                                      | 10 minutes            | N/A           | 1 hour   |  | 2,700               | 2,700   | 500  | -67F - 250F  | 45ml<br>490ml<br>1 gallon A<br>5 gal. pail B<br>5 gal. pail A<br>55 gal. drum B   | 00-051115-71600-3<br>00-051115-71601-0<br>00-021200-49113-9<br>00-051115-71669-0<br>00-021200-49115-3<br>00-051115-81460-0                      | 62-2863-1445-5<br>62-2863-3630-0<br>62-2883-7530-6<br>62-2863-8530-7<br>62-2883-8530-5<br>62-2863-9530-6                   |
| DP8805NS 8805NS (Green)     | Low odor<br>Fast rate of strength build   | 10:1                   | 80,000                                      | 5 minutes             | N/A           | 10 minutes   | 30   |                     | 3,600   | 900  | -20F - 280F  | 45ml<br>490ml<br>5 gal. pail of Part B<br>55 gal. drum of Part B<br>A3-2 Accelerator 1 gal. can<br>A3-2 Accelerator 5 gal. pail | 00-051115-68958-1<br>00-051115-68959-8<br>00-051115-68979-6<br>00-051115-68984-0<br>00-051115-81415-0<br>00-051115-81414-3                      | 62-2852-1445-8<br>62-2852-3630-3<br>62-2852-8530-0<br>62-2852-9530-9<br>62-2962-7530-8<br>62-2962-8530-7                   |
| DP8410NS 8410NS (Green)     | High impact<br>Adhesion to most plastics  | 10:1                   | 70,000                                      | 10 minutes            | N/A           | 25 minutes   | 50   |                     | 4,100   | 800  | -40F - 280F  | 45ml<br>490ml<br>5 gal. pail of Part B<br>55 gal. drum of Part B<br>A3-1 Accelerator 1 gal. can<br>A3-1 Accelerator 5 gal. pail | 00-051115-70994-4<br>00-051115-70995-1<br>00-051115-70997-5<br>00-051115-71101-5<br>00-051115-68981-9<br>00-051115-68980-2                      | 62-2860-1445-1<br>62-2860-3630-6<br>62-2860-8530-3<br>62-2860-9530-2<br>62-2952-7530-9<br>62-2952-8530-8                   |
| PR100 (Clear)               | General purpose, low viscosity plastic and rubber bonder  | N/A                    | 100   | N/A                   | 10-30 seconds | N/A  | N/A  |                     |   |  | -65F - 180F (-54 - 82C)  | 20 gram bottle<br>500 gram bottle<br>1 lb. bottle<br>2 kilo bottle  | 00-051115-25214-3<br>00-051115-25939-5<br>00-051115-25213-6<br>00-051111-07176-2  | 62-6164-0360-6<br>62-6164-3865-1<br>62-6164-3860-2<br>62-6164-6860-9   |
| Product (Color)             | Key Features  | Mix Ratio (Volume) B:A | Approximate Viscosity at 250°F (121°C) (cp) | Open Time (Work Life) | Set Time      | Durometer (Shore D)                                  | Tensile Strength                           | Elongation          | Size  | UPC  | Stock #  |   |   |  |
| TS230 (Off White)           | Sprayable/extrudable with long set time. Bonds a variety of plastics including polystyrene, aluminum, glass and wood. | N/A                    | 9,000                                       | 4 minutes             | 150 seconds   | 45   | 3,300 psi                                  | 700%                | 1/10 of gal. cart.<br>2 kilo bag (4.4 lbs)<br>5 gal. pail<br>55 gal. drum | 0-00-51115-25165-8<br>0-00-48011-53271-4<br>0-00-21200-83640-4<br>0-00-21200-83639-8 | 62-3870-5238-4<br>62-3870-6839-8<br>62-3870-8530-1<br>62-3870-9530-0 |   |   |  |

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