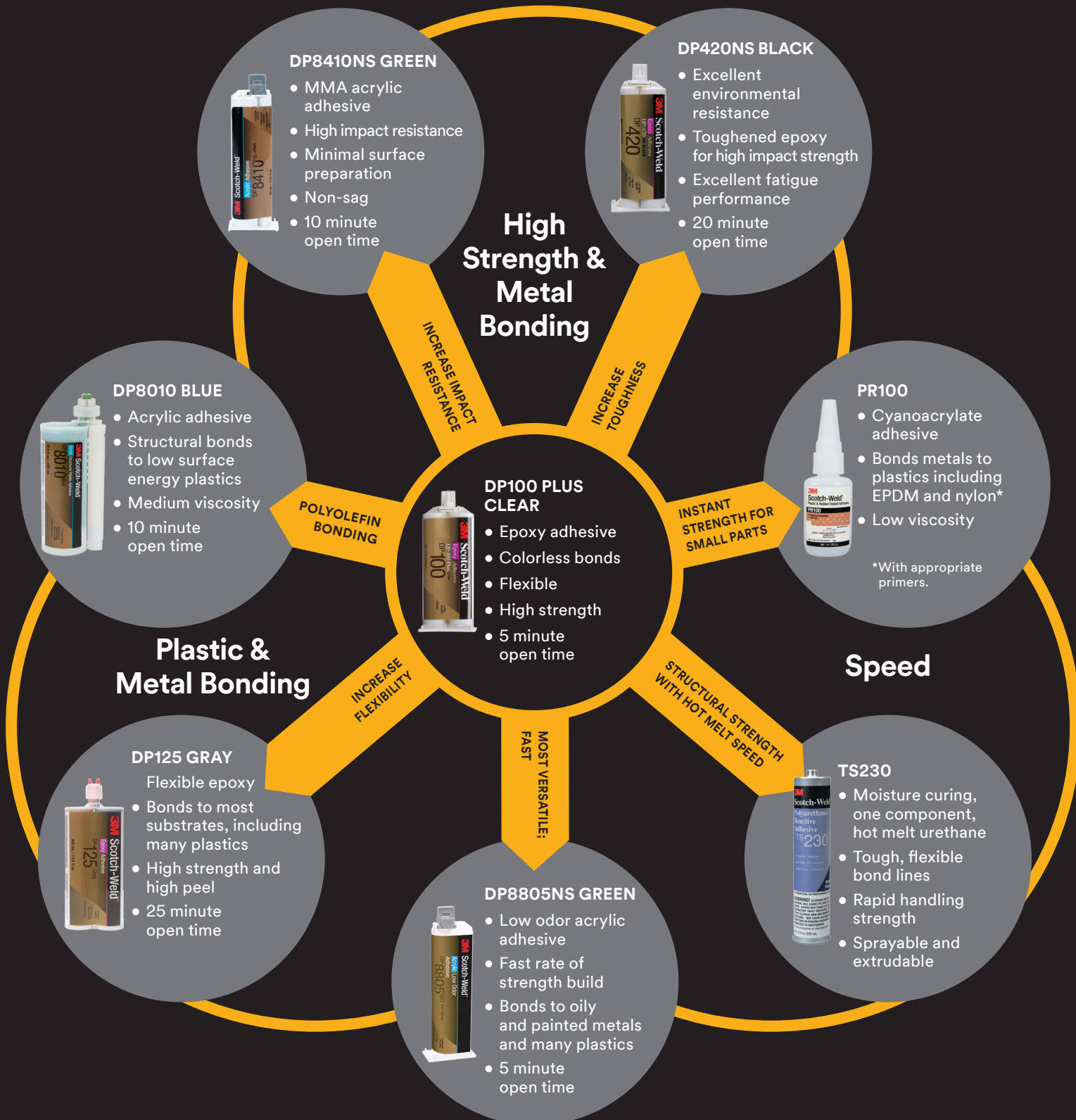


3M™ Scotch-Weld™ Structural Adhesives

Adhesive Science for Bonding Solutions



Design Solutions

Improve Aesthetics

- Replace rivets, welds and screws
- Invisible joints
- Create smoother bond lines

Producing a seamless appearance



Recommended 3M products:
DP100 PLUS & DP420NS

Lightweighting

- Eliminate the weight of mechanical fasteners
- Use thinner, lighter materials
- Build with composites and hard-to-bond plastics

Making products lighter and more efficient



Recommended 3M products:
DP8010 & DP420NS

Freedom to Design

- Adhere difficult-to-bond materials, such as HDPE/PP
- Bond multiple materials, such as metal to plastic
- Smaller joints take up less space

Extending your design latitude



Recommended 3M products:
DP8010 & DP8805NS

Performance Optimization



Stronger Bonds

- Eliminate stress concentrations
- Toughened adhesives absorb shock for durable bonds
- Bond and seal simultaneously

Providing solutions for high-strength applications

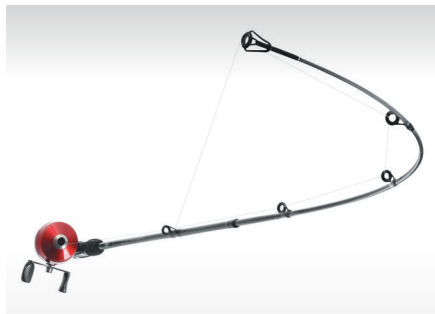
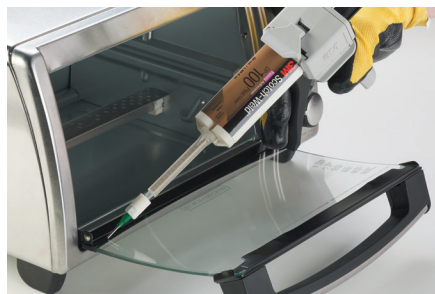


Recommended 3M products:
DP420NS & DP8410NS

Flexible Bonds

- Absorb vibration and CTE mismatch*
- Reduce NVH (noise vibration harshness)
- Resist material separation along edges and corners with high peel strength

Enhancing durability in tough environments



*Coefficient of thermal expansion.

Recommended 3M products:
DP125 & DP100PLUS

Quality & Durability

- Improve vibration and fatigue resistance
- Environmental and chemical resistance
- Eliminate galvanic corrosion

Bonds that last under harsh conditions



Recommended 3M products:
DP8410NS & DP8010 BLUE

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 Colorless	1:1	8,500	4 minutes	N/A	20 minute	55	3,000	3,500	200	-67F - 325F	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-021200-87195-5 00-021200-87266-2 00-021200-87267-9 00-021200-87197-9 00-021200-87198-6	62-3272-1435-9 62-3272-3830-9 62-3272-3530-5 62-3272-8530-0 62-3372-8530-8	
DP125 125 (Gray)	High performance Flexible bonds	1:1	52,500	25 minutes	N/A	2.5 hours	85	3,400	4,300	400	-67F - 325F	50ml 200ml 400ml 5 gal. pail B 5 gal. pail A	00-002100-87211-2 00-002100-87842-8 00-002100-87843-5 00-002100-87217-4 00-002100-87218-1	63-3291-1435-9 62-3291-3830-9 62-3291-3530-5 62-3293-8530-6 62-3393-8530-4	
DP420NS 420NS (Black)	Tough durable bonds Non-sag	2:1	180,000	20 minutes	N/A	2 hours	60	4,500	4,500	1,250	-67F - 350F	37ml 200ml 400ml 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-021200-39285-6 00-021200-39286-3 00-021200-39287-0 00-021200-56587-8 00-021200-31309-7 00-048011-58132-3 00-048011-58133-0	62-3299-1435-2 62-3299-3832-8 62-3299-3532-4 62-3299-8535-2 62-3399-8530-1 62-3299-9530-2 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 490ml 1 gallon A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-71600-3 00-051115-71601-0 00-021200-49113-9 00-051115-71669-0 00-021200-49115-3 00-051115-81460-0	62-2863-1445-5 62-2863-3630-0 62-2883-7530-6 62-2863-8530-7 62-2883-8530-5 62-2863-9530-6	
DP8805NS 8805NS (Green)	Low odor Fast rate of strength build	10:1	80,000	5 minutes	N/A	10 minutes	30		3,600	900	-20F - 280F	45ml 490ml 5 gal. pail of Part B 55 gal. drum of Part B A3-2 Accelerator 1 gal. can A3-2 Accelerator 5 gal. pail	00-051115-68958-1 00-051115-68959-8 00-051115-68979-6 00-051115-68984-0 00-051115-81415-0 00-051115-81414-3	62-2852-1445-8 62-2852-3630-3 62-2852-8530-0 62-2852-9530-9 62-2962-7530-8 62-2962-8530-7	
DP8410NS 8410NS (Green)	High impact Adhesion to most plastics	10:1	70,000	10 minutes	N/A	25 minutes	50		4,100	800	-40F - 280F	45ml 490ml 5 gal. pail of Part B 55 gal. drum of Part B A3-1 Accelerator 1 gal. can A3-1 Accelerator 5 gal. pail	00-051115-70994-4 00-051115-70995-1 00-051115-70997-5 00-051115-71101-5 00-051115-68981-9 00-051115-68980-2	62-2860-1445-1 62-2860-3630-6 62-2860-8530-3 62-2860-9530-2 62-2952-7530-9 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 500 gram bottle 1 lb. bottle 2 kilo bottle	00-051115-25214-3 00-051115-25939-5 00-051115-25213-6 00-051111-07176-2	62-6164-0360-6 62-6164-3865-1 62-6164-3860-2 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. 2 kilo bag (4.4 lbs) 5 gal. pail 55 gal. drum	0-00-51115-25165-8 0-00-48011-53271-4 0-00-21200-83640-4 0-00-21200-83639-8	62-3870-5238-4 62-3870-6839-8 62-3870-8530-1 62-3870-9530-0				

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