



Adhesives and Tapes

Adhesives Selection Guide

Metal to:	Structural Adhesives: Each adhesive has high cohesive strength to bond high strength materials and potentially replace mechanical fasteners		Solvent and Water Based Spray Adhesives	
	3M™ Scotch-Weld™ Epoxy, Acrylic Adhesives	3M™ Scotch-Weld™ Instant Adhesives	3M™ Solvent and Water Based Adhesives	3M™ Aerosol Adhesives
Metal	Acrylics, Epoxies	CA40H	1357, 1099 (All), 1300	80, 90
EPDM Rubber	—	CA40H	4799	—
Rubber (except EPDM)	Flexible 2-part Epoxies	CA40H	1300, 847	80, 90*
Glass and Ceramics	Flexible 2-part Epoxies	—	1357	80, 90
Leather	Flexible 2-part Epoxies	—	847	80
Plastics (Polyolefins)	DP8005	—	—	90
Plastics (ABS, PVC, Acrylic, etc.)	DP8005	CA40H	1357	77, 80, 90
Plastics (High Performance Nylon)	DP460	CA40H	1099 (All)	77, 80, 90
Plastics (Flexible Vinyl)	Flexible 2-part Epoxies	CA40H	1099 (All)	80
Paper and Cardboard	2-part Epoxies	—	10	77
Fabric, Felt, Cork and Fibrous Glass	2-part Epoxies	—	—	74, 77, 80, 90
Flexible Foam (Latex, Urethane)	—	—	—	74, 90
Rigid Foam (Beadboard, Styrene)	Flexible 2-part Epoxies	—	—	—
Rigid Foam (Urethane)	Flexible 2-part Epoxies	CA40H	1357, 5, 10	74, 80

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes. Final product selection should be made only after consideration of a variety of factors and evaluations of sample bonds.


*Produces a temporary bond on these materials. (1) Adhesives must be force dried and bonded while warm. (2) For best results, preheat the substrate to a minimum of 120°F (49°C). (3) Evaluate usage surface activator.




3M™ Scotch-Weld™ Epoxy and Acrylic Adhesives

Product/Color ¹	Description/UPC	Mix Ratio (Vol) B:A	Approx ² Viscosity at 75°F (24°C) (CPS)	Approx ³ Worklife at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear Strength ⁵ (PSI)			Size	Qty/Case
						-20°F (-29°C)	75°F (24°C)	180°F (82°C)		


3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP810

	<ul style="list-style-type: none"> Acrylic bonds many metals and plastics without surface prep Fast strength buildup Fully cured in 8 hours Low odor High peel and shear strength on slightly oily steel, aluminum, glass and painted surfaces 									
	638060-08967-5 (Black)	1:1	20,000	10 min	30	1,200	3,600	500	48.5mL	12
	638060-08986-6 (Tan)									12

3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP810NS Tan


	<ul style="list-style-type: none"> Non-sag version of DP810 10-15 minute handling strength 									
	021200-49082-8	1:1	95,000	10 min	20	1,200	4,000	500	48.5mL	12

3M™ Scotch-Weld™ Structural Plastic Adhesive DP8005


	<ul style="list-style-type: none"> 2-part acrylic adhesive bonds to polyethylene and polypropylene with no surface preparation Tough bond strength to resist vibration and impact Bonds most difficult-to-bond LSE (low surface energy) plastics 									
	051128-99349-1 (Off-White)	10:1	25,000	3 min	N/A	750	2,200	500	45mL	12
	051128-99352-1 (Black)					875	2,000	475		12

Product/Color ¹	Description/UPC	Mix Ratio (Vol) B:A	Approx Mixed Viscosity at 72°F (22°C)	Approx Work Life at 72°F (22°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (PSI)			Size	Qty/Case
						-20°F (-29°C)	72°F (22°C)	180°F (82°C)		


3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP8810NS Green

	<ul style="list-style-type: none"> 10 minute work life Low odor Fast rate of strength build up 									
	051128-99432-0	10:1	80,000	10 min	30 min	900	3,600	800	45mL	12
	051128-99431-3								490mL	6


3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP8805NS Green

	<ul style="list-style-type: none"> 5 minute work life Low odor Fast rate of strength build-up 									
	076308-98433-5	10:1	80,000	5 min	30 min	800	3,600	900	45mL	12
	076308-98439-7								490mL	6

3M™ Scotch-Weld™ Acrylic Adhesive DP8405NS Green

	<ul style="list-style-type: none"> 5 minute work life High impact resistance Minimal surface prep 									
	051115-68963-5	10:1	70,000	5 min	50 min	2,600	4,100	900	45mL	12
	051115-68964-2								490mL	6

3M™ Scotch-Weld™ Metal Bonder Acrylic Adhesive DP8407NS

	<ul style="list-style-type: none"> 7 minute work life Withstands powder coat and paint bake cycles High shear, peel and impact strength 									
	638060-14631-6	10:1	20,000	7 min	50 min	3,400	4,500	1,400	45mL	12
	638060-14643-9								490mL	6

1 Color is mixed if two-part product
 2 Brookfield viscometer viscosity values are typical values for the mixed product
 3 The time during which an adhesive will adequately wet-out on a substrate
 4 80° peel tested on .030" aluminum per ASTM D 1876-61T
 5 Tested per ASTM D 1002-64

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