

# 3M™ Scotch-Weld™ Structural Adhesives (cont.)



Product (Color)	Key Features	Mix Ratio (Vol.) B:A	Approx. Viscosity at 75°F (24°C) (cP)	Approx. Mixed Work Life at 75°F (24°C)	Approx. Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PLI (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
<b>3M™ Scotch-Weld™ Flexible Epoxies</b>												
<b>Key Product</b> DP100 Plus 100 Plus (Clear)	Very flexible, Colorless	1:1	8,500	4 min	20 min	55 (98)	3,000 (21)	3,500 (24)	200 (1)	48.5mL 200mL 400mL 5 gal pail A 5 gal pail B	00-638060-08976-7 00-021200-87266-2 00-021200-87267-9 00-021200-87198-6 00-021200-87197-9	7100148750 7100069498 7000121255 7100046020 7100084539
DP105 105 (Clear)	Very flexible, Colorless	1:1	6,500	5 min	20 min	50 (89)	3,500 (24)	2,000 (14)	150 (1)	48.5mL 200mL 400mL 5 gal pail A 5 gal pail B	00-638060-08981-1 00-021200-87270-9 00-021200-87271-6 00-021200-87206-8 00-021200-87205-1	7100148733 7010309884 7100076786 7000000856 7000000850
DP110 110 (Gray)	General purpose, Flexible bonds	1:1	55,000	8 min	20 min	40 (71)	2,700 (19)	3,500 (24)	250 (2)	48.5mL 200mL 400mL 5 gal pail A 5 gal pail B	00-638060-08990-3 00-021200-87274-7 00-021200-87275-4 00-021200-82472-2 00-021200-82471-5	7100148777 7000121312 7100009581 7010299362 7010299357
DP110 110 (Translucent)	General purpose, Flexible bonds	1:1	50,000	8 min	20 min	40 (71)	2,500 (17)	2,500 (17)	200 (1)	48.5mL 200mL 400mL 5 gal pail A 5 gal pail B	00-638060-08993-4 00-021200-87846-6 00-021200-87847-3 00-021200-82467-8 00-021200-82466-1	7100148762 7000148270 7000148269 7010366163 7010366143
<b>Key Product</b> DP125 125 (Gray)	High performance, Very flexible bonds	1:1	52,500	25 min	2.5 hr	90 (160)	3,400 (23)	4,300 (30)	400 (3)	48.5mL 200mL 400mL 5 gal pail A 5 gal pail B	00-638060-08985-9 00-021200-87844-2 00-021200-87845-9 00-021200-87218-1 00-021200-87217-4	7100148735 7000121264 7100076727 7100084588 7100084538
DP125 125 (Translucent)	High performance, Very flexible bonds	1:1	15,000	25 min	2.5 hr	85 (151)	4,000 (28)	2,500 (17)	150 (1)	48.5mL 200mL 400mL	00-638060-08983-5 00-021200-87842-8 00-021200-87843-5	7100148734 7100025419 7000121262
DP190 (Translucent)	High performance, Flexible bonds	1:1	10,000	80 min	6 hr	60 (107)	3,500 (24)	1,200 (8)	150 (1)	48.5mL 200mL 400mL	00-638060-08980-4 00-021200-87838-1 00-021200-87839-8	7100148752 7000121260 7010329707
<b>*</b> DP190 (Gray)	High performance, Slightly flexible bonds	1:1	80,000	90 min	10 hr	50 (89)	1,500 (10)	2,500 (17)	400 (3)	48.5mL 200mL 400mL	00-638060-08992-7 00-021200-87840-4 00-021200-87841-1	7010410438 7000121314 7100076722
<b>*</b> 2216 B/A (Gray)	High performance, Very flexible bonds	2:3	80,000	90 min	10 hr	50 (89)	3,000 (21)	3,200 (22)	400 (3)	43mL Duo-Pak 2 oz tube kit Pint kit Qt Kit Gal Kit 5 gal pail A 5 gal pail B 55 gal drum A 55 gal drum B	00-021200-56659-2 00-021200-20351-0 00-021200-20354-1 00-021200-20356-5 00-021200-20358-9 00-021200-20365-7 00-021200-20360-2 00-021200-20366-4 00-021200-20361-9	7000046357 7000000812 7000046358 7000000815 7000000816 7000046361 7000046360 7100166318 7100166319
2216 B/A (Translucent)	General purpose, Very flexible bonds	1:1	10,000	2 hr	14 hr	70 (125)	3,000 (21)	1,700 (12)	140 (1)	2 oz tube kit Pint kit Qt Kit Gal Kit 5 gal pail A 5 gal pail B 55 gal drum A 55 gal drum B	00-021200-20851-5 00-021200-20852-2 00-021200-20854-6 00-021200-20856-0 00-021200-64981-3 00-021200-64980-6 00-021200-20927-7 00-021200-20859-1	7000046479 7010310194 7000000861 7000046480 7000046494 7000121307 7010330240 7010367466
2216NS B/A (Tan)	High performance, Non-sag	2:3	350,000	2 hr	10 hr	50 (89)	2,000 (14)	2,500 (17)	400 (3)	5 gal pail A 5 gal pail B	00-021200-87180-1 00-021200-87179-5	7010367414 7010309882

For lead times on bulk adhesives, please contact your 3M representative.

**Key Product** Denotes product to consider first in this category. **\*** After Key Products, consider these.

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