

## Product Information: 3M™ Scotch-Weld™ Adhesives in Duo-Pak Cartridges (cont.)

Duo-Pak Cartridges	Product (Color) <sup>(1)</sup>	Features	Mix Ratio (Volume) B:A	Approximate Viscosity 75°F (24°C) (CPS) <sup>(2)</sup>	Approximate Worklife At 75°F (24°C) <sup>(3)</sup>	Average T-Peel At 75°F (24°C) PIW <sup>(4)</sup>	Overlap Shear Strength <sup>(5)</sup> PSI			
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)	250°F (121°C)
	DP-8005 Off-White, Black	<ul style="list-style-type: none"> <li>Structurally bonds polyolefins without surface preparation</li> <li>Excellent environmental resistance</li> <li>2-3 hour handling strength</li> </ul>	10:1	27,500	2.5-3 Min.	16	–	2000	340	–

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## Product Information: 3M™ Scotch-Weld™ Two-Part Structural Adhesives

	Product (Color) <sup>(1)</sup>	Features	Mix Ratio (Volume) B:A	Approximate Viscosity 75°F (24°C) (CPS) <sup>(2)</sup>	Approximate Worklife At 75°F (24°C) <sup>(3)</sup>	Average T-Peel At 75°F (24°C) PIW <sup>(4)</sup>	Overlap Shear Strength <sup>(5)</sup> PSI			
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)	250°F (121°C)
Two-Part Epoxy Adhesives	1751 B/A Gray	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Rigid epoxy</li> <li>8-12 hrs. handling strength</li> <li>Excellent void filler and machinable for many "Body Solder" applications</li> </ul>	3:2	700,000	45 Min.	4	1400	2000	500	300
	1838 B/A Green	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Rigid epoxy</li> <li>8-12 hrs. handling strength</li> <li>Meets MIL-A-23941A</li> <li>Excellent Environmental Resistance</li> </ul>	4:5	400,000	60 Min.	4	1500	3000	500	300
	1838 B/A Tan	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Rigid epoxy</li> <li>8-12 hrs. handling strength</li> <li>Tan version of B/A 1838 Green Adhesive</li> </ul>	6:5	250,000	60 Min.	5	1500	3000	500	300
	1838-L B/A Translucent	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Rigid epoxy</li> <li>8-12 hrs. handling strength</li> <li>Translucent, low viscosity version of 1838 B/A Green Adhesive</li> </ul>	1:1	10,000	60 Min.	5	2000	3000	400	200
	2158 B/A Gray	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Rigid epoxy</li> <li>8-12 hrs. handling strength</li> <li>General purpose product</li> </ul>	1:1	375,000	120 Min.	4	1700	2000	400	300
	2216 B/A Gray	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Flexible epoxy</li> <li>8-12 hrs. handling strength</li> <li>Can bond plastic, metal and other dissimilar materials</li> </ul>	2:3	80,000	90 Min.	25	2000	2500	400	200
	2216 B/A Tan Non sag	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Flexible epoxy</li> <li>8-12 hrs. handling strength</li> <li>Tan version of 2216 B/A Gray Adhesive</li> </ul>	2:3	350,000	90 Min.	25	2000	2500	400	200
	2216 B/A Translucent	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>Flexible epoxy</li> <li>16-20 hrs. handling strength</li> <li>Translucent version of 2216 B/A Gray Adhesive</li> </ul>	1:1	10,000	120 Min.	25	3000	2000	200	100
Two-Part Urethane Adhesives	3501 B/A Gray	<ul style="list-style-type: none"> <li>Fast cure adhesive</li> <li>Rigid epoxy</li> <li>20-30 minutes handling strength</li> <li>Rapid room temperature curing material that can bond metal, wood, most plastics and masonry products</li> </ul>	1:1	500,000	7 Min.	5	1500	2400	300	200
	3532 B/A Brown	<ul style="list-style-type: none"> <li>Fast cure adhesive</li> <li>20-30 min. handling strength</li> <li>Semi-rigid urethane</li> <li>Rapid cure for flexible bonds of many plastics, wood, and rubber</li> </ul>	1:1	30,000	7 Min.	25	2500	2000	300	150
	3535 B/A Off-White	<ul style="list-style-type: none"> <li>Very fast cure adhesive</li> <li>15-20 min. handling strength</li> <li>Semi-rigid urethane</li> <li>Faster setting version of 3532 B/A Adhesive</li> </ul>	1:1	30,000	3 Min.	25	2500	2000	300	150
	3549 B/A Brown	<ul style="list-style-type: none"> <li>Long worklife adhesive</li> <li>2-4 hrs. handling strength</li> <li>Semi-rigid urethane</li> <li>Longer worklife version of 3532 B/A Adhesive</li> </ul>	1:1	30,000	60 Min.	25	2500	2000	300	150

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

(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) 180° peel tested on .030" aluminum per ASTM D 1876-61T.

(5) Tested per ASTM D 1002-64.