

Product Information: 3M™ Scotch-Weld™ One-Part Epoxy Adhesives; Metal Primers

Product (Color)	Features	Viscosity	Optimum Cure			Average T-Peel At 75°F (24°C)	Overlap Shear Strength ⁽²⁾ PSI					
			Time (Min.)	Temp (°F/°C)	Pressure (PSI)		-67°F (-55°C)	75°F (24°C)	180°F (82°C)	250°F (121°C)	350°F (177°C)	
One-Part Epoxy Adhesives	1386 Cream	A 350°F (177°C) curing epoxy for metal to metal bonding provides exceptionally high strength, impact resistant bonds. Meets requirements of MMM-A-134 Type III.	150,000 cps	60	350/177	10	10 (Alum.)	3000	5500	4500	2500	400
	1469 Cream	A 350°F (177°C) curing epoxy with excellent performance at elevated temperatures. Meets requirements of MMM-A-132 Type II, Class 3, Group 4.	60,000 cps	120	350/177	10	2 (Alum.)	3150	3700	3700	3600	1000
	2086 Gray	A 350°F (177°C) curing epoxy similar to 1386 Adhesive but filled to provide excellent flow control.	Paste	60	350/177	10	5 (Alum.)	3000	5000	5000	2200	500
	2214 Regular Gray	Aluminum filled heat curing (250°F, 121°C) structural adhesive of paste consistency. Can bond metals, glass and many plastics.	Paste	60	250/121	10	5 (Alum.) 50 (Steel)	3000	4500	4500	1500	400
	2214 Hi-Density Gray	Similar to 2214 regular adhesive but deaerated and formulated to provide dense, void-free bond lines.	Paste	60	250/121	10	5 (Alum.) 50 (Steel)	3000	4500	4500	1700	400
	2214 Hi-Temp Original Gray	Formulated to provide outstanding performance at elevated temperatures and excellent sag control.	Paste	60	250/121	10	2 (Alum.) 5 (Steel)	2000	2000	3000	2500	900
	2214 Hi-Temp New Formula Gray	A version of 2214 Hi-Temp Adhesive with exceptional performance at elevated temperatures and excellent performance under high temperature and high humidity conditions. Resists attack by hot ethylene glycol.	Paste	60	250/121	10	5 (Alum.) 5 (Steel)	2800	2800	2500	2000	1200
	2214 Hi-Flex Gray	Similar to 2214 Regular Adhesive but deaerated and formulated to provide bonds featuring outstanding shock resistance.	Paste	60	250/121	10	10 (Alum.) 65 (Steel)	2500	4000	2000	450	250
	2214 Non-Metallic Filled Cream	A cream colored non-metallic version of 2214 Regular Adhesive suggested for electrical applications where insulating qualities are desired.	Paste	60	250/121	10	7 (Alum.) 12 (Steel)	3000	4000	4500	1500	400
	2290 Amber	A 21% solids liquid epoxy. B-stageable. Can be used in laminating steel cores for motor stators and rotors. Excellent for many thin metal stack laminations such as those used in magnetic tape heads.	60 cps	30	350/177	50	10 (Alum.)	5000	5000	3500	1200	200
Metal Primers	Product Color	Features	Viscosity	Comments								
	3901 Red	<ul style="list-style-type: none"> Adhesion promoter Organo-silane base Brush or spray application 	5 CPS	A primer for film and liquid adhesives in those applications where it is desired to obtain improved metal and glass adhesion or improved resistance to environmental exposure with epoxy and urethane adhesives. It can help simplify production scheduling by protecting the cleaned surfaces until the bonding operations can be completed and imparts improved corrosion protection to metal.								
	1945 B/A Green	<ul style="list-style-type: none"> 1:1 mix ratio 2-part epoxy primer 8 hour potlife Brush, spray or dip application 	500 CPS	It is a two-part chemically curing, corrosion resistant primer to improve adhesion of urethanes and epoxies to many metals as well as offering increased corrosion protection. It cures at room temperature and has excellent adhesion to many metals.								

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

(1) Tested per ASTM D 1876-61T.

(2) Tested per ASTM D 1002-64.