



Scotch-Weld™
Structural Adhesive

Structural Acrylic Adhesives

Enhance Productivity
and Performance

3M™ Scotch-Weld™ Structural Acrylic Adhesives

Solving the challenges of speed, strength, shelf life, odor, and high and low temperature performance.

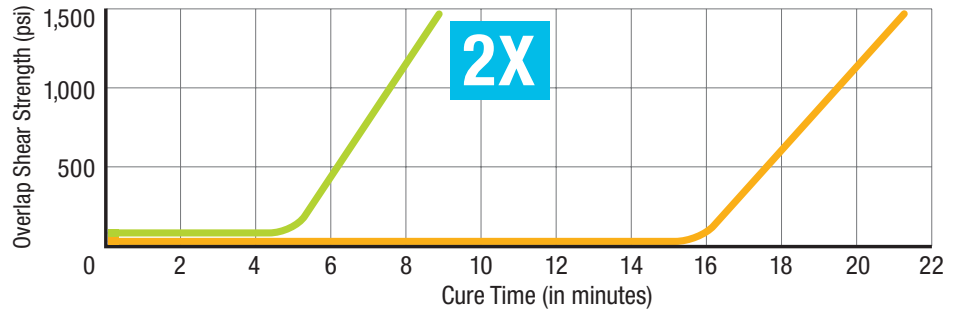


Enhanced Productivity

With minimal surface prep, quick cure rates and fast rate of strength builds, DP8705NS can reach over 1,000 psi of overlap shear strength in less than nine minutes. Its rate of strength build is twice as fast as ordinary acrylic adhesives.

The advantage: higher throughput and increased productivity.

Aluminum overlap shear bond; room temperature



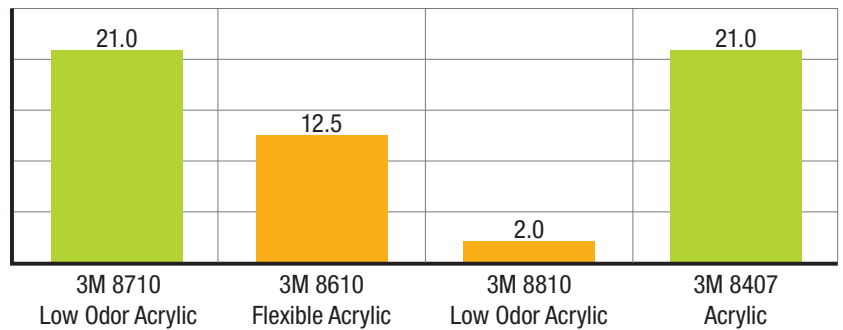
Higher Impact Resistance

DP8710NS and DP8407NS have over ten times the side impact strength of other acrylic adhesives. Higher impact resistance makes them ideal for many industrial applications, helping build stronger products for challenging applications.

The advantage: improved impact resistance helps make your products more durable.

Side Impact Strength (Joules)

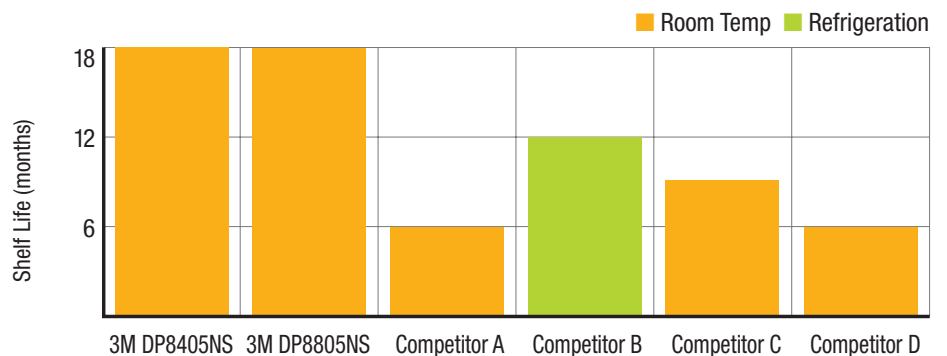
Aluminum, ASTM D6110



Longer Shelf Life and Easier Storage

3M's Structural Acrylic Adhesives do not require refrigeration, making them easier to store. Formulations also have a 12-18 month shelf life, more than double that of conventional acrylic adhesives, which can help to reduce scrap and disposal costs due to expired inventory.

The advantage: reduced costs and improved logistics.



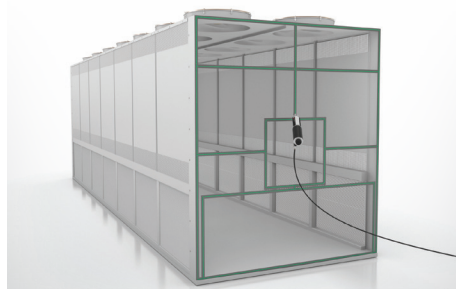
Enhancing Processes and Improving Products

Structural Acrylic Adhesives from 3M are ideal for many applications, providing you the opportunity to improve both products and processes. Their faster set times allow you to enhance productivity, while their higher impact resistance and performance features can help improve your products. Markets and applications include:



Signage

- Panel to frame bonding
- Trim attachment
- Letter bonding
- Seam sealing
- Frame assembly



HVAC

- Floor panel and drain pan to frame
- Side wall panel attachment to frame
- Stiffener to panel



Transportation

- Metal skin to metal frame
- Composite cab assembly
- Frame assembly
- Floor and exterior panel bonding
- EV battery bonding
- Roof bonding

3M Structural Acrylic Adhesives Features & Benefits*

Feature:

- Non-flammable classification and low odor formulation
- Limits bond line read-through
- Structurally bonds to nylon (polyamides) without plasma or flame treatment surface preparation
- Flexible like a sealant
- Bonds powder coats and slightly oily surfaces
- High peel strength
- Elevated, extreme temperature performance
- Low chlorine / bromine / low halogen
- Colored pigment in accelerator
- Glass beads for controlled bond line thickness
- Longer nozzle life

Benefit:

- Helps improve the working environment
- Helps thin, flat surfaces maintain their aesthetic appearance
- Helps reduce costs and production time
- For greater impact resistance
- Structural bonds to difficult-to-bond materials
- Reduce product failure
- Maintains structural strength from -40°F (-40°C) to 180°F (82°C)
- Fewer halogens means a better EHS profile and ideal for electronics
- Visual confirmation of mix ratio ensures correct adhesive curing
- Structural bonds with consistent quality
- Fewer nozzle changeovers saves money

*These features/benefits do not apply to all individual acrylics.

3M™ Scotch-Weld™ Flexible Acrylic Adhesive 8600 Series



The strength of a structural acrylic. The flexibility of a sealant.

Offering a unique set of benefits, 3M™ Scotch-Weld™ Flexible Acrylic Adhesive 8600 Series provides the flexibility of a sealant combined with the strength and cure speed of an acrylic adhesive, allowing you to be more flexible in your design.

**Limits bond line read-through:**

Helps thin, flat surfaces maintain their aesthetic appearance.

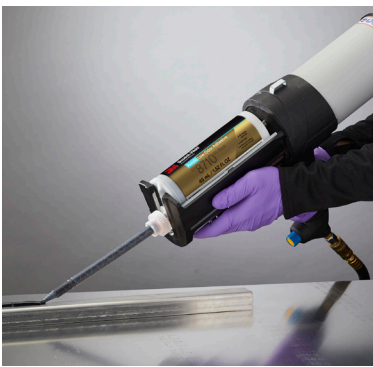


Flexible like a sealant: For greater impact resistance.

**High elongation up to 200%:**

Withstands stresses between dissimilar materials.

3M™ Scotch-Weld™ Low Odor Acrylic Adhesive 8700 Series



Low odor. High strength. Improved formulation for enhanced workplace safety and productivity.

The 3M™ Scotch-Weld™ Low Odor Acrylic Adhesive 8700 Series is formulated to work better, including in cold temperatures. These structural adhesives, with improved GHS classifications*, have a low odor formulation and non-flammable classification to help improve the working environment.

**Non-flammable classification and low odor formulation:**

to help improve the working environment.



Reliable cold temperature performance: Now rated to -40°C.

**Excellent structural strength, peel and impact resistance:**

Components stay bonded even under severe stress.

**Compared to competitive acrylic adhesives.*

3M™ Scotch-Weld™ Nylon Bonder Structural Adhesive DP8910NS



Easier bonding to nylon opens up new possibilities.

Bonding nylon requires an adhesive that can withstand the heat of your applications, and does not require flame treatment surface prep. 3M™ Scotch-Weld™ Nylon Bonder Structural Adhesive DP8910NS is the high temperature bonding solution that can take the heat and requires minimal surface prep prior to bonding.

**Structurally bonds to nylon (polyamides) without plasma or flame treatment surface preparation:**

Helps reduce costs and production time.

**Ideal for high temperature and high humidity applications:**

Adhesive is high temperature and humidity resistant.

**Bond nylon to dissimilar materials such as aluminum and stainless steel:**

Better compatibility gives you more options.



The Advantage of Acrylic Adhesives

Manufacturers around the world rely on acrylic adhesives to design and produce innovative new products. Acrylic adhesives improve aesthetics, bond to plastics and metals, and even deliver a secure bond between oily or contaminated surfaces. Despite improving many aspects of the assembly process, traditional acrylic adhesives have been challenged by:

- High levels of odors that can cause Environmental, Health & Safety concerns
- Lower impact resistance that result in brittle bonds
- Limited shelf life and refrigeration required

Structural Adhesive Advancements

The 3M™ Scotch-Weld™ Structural Adhesives product development team focused on solving these challenges in their ongoing improvement of structural acrylic adhesive products. Key features of these new acrylic adhesives include:



Low Odor Formulation and Non-Flammable Classification

The 8600, 8700 and 8800 family of products features a low odor, non-flammable formulation that your entire team will appreciate.



High & Low Temperature Performance

DP8910NS is the high temperature bonding solution that doesn't require surface prep prior to bonding. DP8710NS has reliable cold temperature performance, now rated to -40 degrees C.



Faster Cure

DP8705NS and DP8805NS cure almost twice as fast as ordinary acrylic adhesives with the same work life.



Nylon and LSE bonding

High strength bonding of multiple substrates like LSE plastics (DP8010) and nylon (DP8910).



Higher Impact Resistance

DP8610NS, DP8710NS and DP8405NS have over three times the impact strength of conventional acrylic adhesives.



No Refrigeration & 12-18 Month Shelf Life

Easier storage and longer shelf life can help to reduce scrap and disposal costs due to expired inventory.

Designed for innovation, 3M™ Scotch-Weld™ Structural Acrylic Adhesives will help you improve both productivity and performance and help enhance workplace safety.

3M™ Scotch-Weld™ Structural Acrylic Adhesives

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cp)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-40°F (-40°C)	75°F (24°C)	180°F (82°C)			
LOW ODOR												
DP8805NS (Green)	Low odor Fast rate of strength build	10:1	45,000	5 minutes	10 minutes	30	800	3,900	900	45ml 490ml 1 gal. can A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-076308-98433-5 00-076308-98439-7 00-051115-81415-0 00-076308-98440-3 00-051115-81414-3 00-076308-98441-0	62-2852-1446-6 62-2852-3631-1 62-2962-7530-8 62-2852-8531-8 62-2962-8530-7 62-2852-9531-7
DP8810NS (Green)	Low odor Fast rate of strength build	10:1	45,000	10 minutes	20 minutes	30	900	3,600	900	45ml 490ml 1 gal. can A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-68960-4 00-051115-68962-8 00-051115-81415-0 00-051115-68982-6 00-051115-81414-3 00-051115-68981-9	62-2854-1446-2 62-2854-3631-7 62-2962-7530-8 62-2854-8531-4 62-2962-8530-7 62-2954-9531-3
DP8810NS (Gray)	Low odor Fast rate of strength build	10:1	45,000	10 minutes	20 minutes	30	900	3,600	900	45ml 490ml	00-076308-86152-0 00-076308-98485-4	62-2858-1450-5 62-2858-3631-8
DP8825NS (Green)	Low odor Fast rate of strength build	10:1	40,000	25 minutes	50 minutes	20	1,000	3,100	700	45ml 490ml 1 gal. can A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-81288-0 00-051115-81289-7 00-051115-81415-0 00-051115-81290-3 00-051115-81414-3 00-051115-81291-0	62-2866-1445-8 62-2866-3630-3 62-2962-7530-8 62-2866-8530-0 62-2962-8530-7 62-2866-9530-9
DP8705NS 8705NS (Black)	Low odor Low temperature performance	10:1	80,000	5 minutes	6 minutes	60	4,500	2,000	650	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40963-3 00-638060-40964-0 00-638060-40862-9 00-638060-40863-6 00-638060-40965-7 00-638060-40966-4	7100245036 7100245039 7100233358 7100234571 7100245037 7100245038
DP8710NS 8710NS (Black)	Low odor Low temperature performance	10:1	80,000	10 minutes	13 minutes	60	4,500	2,000	650	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40865-0 00-638060-40866-7 00-638060-40862-9 00-638060-40863-6 00-638060-40867-4 00-638060-40868-1	7100233349 7100233348 7100233358 7100234571 7100234572 7100233166
DP8725NS 8725NS (Black)	Low odor Low temperature performance	10:1	80,000	23 minutes	25 minutes	60	4,500	2,000	650	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40967-1 00-638060-40968-8 00-638060-40862-9 00-638060-40863-6 00-638060-40969-5 00-638060-40971-8	7100244858 7100244480 7100233358 7100234571 7100244861 7100244862
FLEXIBLE ACRYLICS												
DP8610NS 8610NS (Black)	Very flexible and no read through on thin metals	10:1	130,000	10 minutes	18 minutes	100	3,500	1,000	250	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40836-0 00-638060-40837-7 00-638060-40862-9 00-638060-40863-6 00-638060-40838-4 00-638060-40839-1	7100233359 7100232802 7100233358 7100234571 7100234673 7100234570
DP8625NS 8625NS (Black)	Very flexible and no read through on thin metals	10:1	130,000	23 minutes	28 minutes	100	3,500	1,000	250	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40972-5 00-638060-40973-2 00-638060-40862-9 00-638060-40863-6 00-638060-40974-9 00-638060-40975-6	7100244478 7100244477 7100233358 7100234571 7100244476 7100244859

LEAD PRODUCT

3M™ Scotch-Weld™ Structural Acrylic Adhesives

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cp)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-40°F (-40°C)	75°F (24°C)	180°F (82°C)			
MMA												
DP8405NS (Green)	High impact Adhesion to most plastics	10:1	60,000	5 minutes	15 minutes	50	2,600	4,400	1,300	45ml 490ml 1 gal. can A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-68963-5 00-051115-68964-2 00-051115-68981-9 00-051115-68986-4 00-051115-68980-2 00-051115-68987-1	62-2856-1445-9 62-2856-3630-4 62-2952-7530-9 62-2856-8530-1 62-2952-8530-8 62-2856-9530-0
DP8410NS (Green)	High impact Adhesion to most plastics	10:1	60,000	10 minutes	25 minutes	50	3,600	3,900	1,250	45ml 490ml 1 gal. can A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-70994-4 00-051115-70995-1 00-051115-68981-9 00-051115-70997-5 00-051115-68980-2 00-051115-71101-0	62-2860-1445-1 62-2860-3630-6 62-2952-7530-9 62-2853-9530-7 62-2952-8530-8 62-2860-9530-2
DP8425NS (Green)	High impact Adhesion to most plastics	10:1	85,000	25 minutes	50 minutes	50	3,800	3,800	1,450	45ml 490ml 1 gal. can A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-81303-0 00-051115-81302-3 00-051115-68981-9 00-051115-81298-9 00-051115-68980-2 00-051115-68980-2	62-2862-1445-7 62-2862-3630-2 62-2952-7530-9 62-2862-8530-9 62-2952-8530-8 62-2862-9530-8
DP8407NS (Gray)	High impact Adhesion to most metals	10:1	20,000	7 minutes	24 minutes	50	3,400	4,500	1,400	45 ml 490 ml 1 gal. can A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-076308-86273-2 00-076308-86285-5 00-076308-86366-1 00-076308-86306-7 00-076308-86367-8 00-076308-98878-4	62-2853-1445-6 62-2853-3630-1 62-2953-7530-7 62-2853-8530-8 62-2953-8530-6 62-2853-9530-7
NYLON BONDER												
DP8910NS 8910NS (Black)	Bonds nylon and metal	10:1	45,000	10 minutes	16 minutes	18	2,600	3,700	1,500	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40976-3 00-638060-40977-0 00-638060-40862-9 00-638060-40863-6 00-638060-40979-4 00-638060-40982-4	7100246046 7100246043 7100233358 7100234571 7100246044 7100246045

LEAD PRODUCT

Hardware

PRODUCT	SIZE	UNITS/CASE	UPC	STOCK #
EPX Plus II Applicator	45 mL	10	00-021200-50004-6	62-9170-9930-1
Plunger 10:1	45 mL	10	00-051115-69044-0	62-9160-9910-4
Square Orange Nozzle	45 mL	36	00-051115-69043-3	62-9154-9136-9
Dual Drive Pneumatic Applicator 10:1	490 mL	1	00-638060-40919-0	62-9152-9931-7
Dual Drive Manual Applicator 1:1/2:1	490 mL	1	00-638060-40914-5	62-9182-9931-4
Helical Orange Nozzle	490 mL	36	00-051115-69042-6	62-9158-9136-0
Square Green Nozzle	490 mL	36	00-051115-81619-2	62-9184-9490-7



Industrial Adhesives & Tapes Division

3M Center
Building 225-3S-06
St. Paul, MN 55144-1000
1-800-362-3550
www.3M.com/structuralacrylics

3M and Scotch-Weld, are trademarks of 3M Company.
Please recycle. Printed in USA.
© 2021 3M. All rights reserved.
78-9236-7264-2

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed. **Product Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application. **Warranty, Limited Remedy, and Disclaimer:** Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. **3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE.** If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price. **Limitation of Liability:** Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.