



Scotch-Weld™

Low Odor Acrylic Adhesives

DP8805NS Green • DP8810NS Green

Technical Data Sheet

February 2014

Product Description

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives are high performance, two-part acrylic adhesives with lower odor than most acrylic adhesives. These toughened products offer excellent shear, peel, and impact performance. They provide improved adhesion to many plastics and metals, including those with slightly oily surfaces. These durable products feature an exceptionally fast rate of strength build, providing structural strength in minutes.

UL Certification QQW2.MH17478

Features

- Toughened
- Excellent shear strength
- High peel and impact strength
- 10:1 mix ratio
- Work life of approximately 4 or 10 minutes
- Structural strength in about 9 or 21 minutes
- Increased cure speed with applied heat
- Contain glass beads (0.010” diameter) to control bond line thickness

Note: Unless otherwise indicated, all properties measured at 72°F (22°C).

Typical Uncured Physical Properties

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

Property		3M™ Scotch-Weld™ Low Odor Acrylic Adhesive	
		DP8805NS Green	DP8810NS Green
Color	Base (B) Accelerator (A)	Off-white Blue	Off-white Blue
Viscosity ¹	Base (B) Accelerator (A)	90,000 cP 35,000 cP	
Density ²	Base (B) Accelerator (A)	1.08 g/cm ³ 1.08 g/cm ³	
Mix ratio	By volume	10 Parts B : 1 Part A	
	By weight	10 Parts B : 1 Part A	
Note: Cure times are approximate and depend on adhesive temperature.			
Work life ³		3-5 minutes	8-12 minutes
Open time ⁴		4-6 minutes	8-12 minutes
Time to handling strength ⁵		6-8 minutes	16-20 minutes
Time to structural strength ⁶		8-10 minutes	19-23 minutes

1. Viscosity measured using cone-and-plate viscometer; reported viscosity at 4 sec⁻¹ shear rate.

2. Density measured using pycnometer.

3. Maximum time that adhesive can remain in a static mixing nozzle and still be expelled without undue force on the applicator.

4. Maximum time allowed after applying adhesive to one substrate before bond must be closed and fixed in place.

5. Minimum time required to achieve 50 psi of overlap shear strength.

6. Minimum time required to achieve 1,000 psi of overlap shear strength.

3M™ Scotch-Weld™

Low Odor Acrylic Adhesives

DP8805NS Green • DP8810NS Green

Typical Mixed Physical Properties

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

Property	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive	
	DP8805NS Green	DP8810NS Green
Color	Blue-green	
Full cure time	24 hours	
Viscosity	90,000 cP	
Density	1.08 g/cm ³	

Typical Cured Physical Properties

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

Overlap Shear (psi)⁷

Substrate	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive	
	DP8805NS Green	DP8810NS Green
Aluminum	3,500 CF	3,400 CF
Stainless steel	3,300 CF	3,200 CF
PVC	1,800 SF	1,800 SF
ABS	1,200 SF	1,300 SF
Acrylic	1,000 SF	1,100 SF
Polycarbonate	850 CF	850 CF
Polystyrene	500 AF	550 AF
Polyester (fiber-reinforced)	700 AF	800 AF
Epoxy resin (fiber-reinforced)	3,000 CF	3,300 CF
Aluminum (tested at 180°F)	650 CF	750 CF

7. Overlap shear values measured using ASTM D1002; 1 min open time; adhesive allowed to cure for 24 hours at room temperature; 1/2" overlap; 0.010" bond line thickness; samples pulled at 0.1 in/min for metals and 2 in/min for plastics; all surfaces prepared with light abrasion and solvent clean; substrates used were 1/16" thick metals and 1/8" thick plastics; failure modes:

AF: adhesive failure CF: cohesive failure SF: substrate failure

Note: Environmental aging tests have shown that these adhesives may accelerate the corrosion of certain metals (such as bare steel, copper, brass, and bronze), leading to low bond strength values and early bond failure. These adhesives also have relatively low adhesion to low surface energy plastics (such as polypropylene, polyethylene, TPO, and PTFE). Applications involving any of these materials should be carefully evaluated by the end user for suitability.

Mechanical Properties⁸

Property	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive	
	DP8805NS Green	DP8810NS Green
Tensile modulus (psi)	140,000	125,000
Tensile strength (psi)	1,800	1,650
Tensile strain at break (%)	8.5	6.5

8. Tensile properties measured using ASTM D638; adhesives allowed to cure for 2 weeks at room temperature; 1/8" thick Type I test specimens; samples pulled at 0.2 in/min.

3M™ Scotch-Weld™

Low Odor Acrylic Adhesives

DP8805NS Green • DP8810NS Green

Typical Cured
Physical Properties
(continued)

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

Environmental Resistance⁹

Condition	Substrate	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive	
		DP8805NS Green	DP8810NS Green
300°F (149°C)	Aluminum	100%	90%
120°F (49°C) + 80% relative humidity		70%	60%
185°F (85°C) + 85% relative humidity		40%	40%
Water		90%	NT
Salt water (5 wt% in water)		100%	NT
Diesel fuel		100%	90%
Motor oil		100%	90%
Antifreeze (50 wt% in water)		90%	90%
Isopropyl alcohol		50%	25%
Bleach (10 wt% in water)		65%	60%
120°F (49°C) + 80% relative humidity		PVC	100%
Water	100%		NT
Salt water (5 wt% in water)	100%		NT
Sulfuric acid (16 wt% in water)	100%		95%
Sodium hydroxide (10 wt% in water)	90%		65%

9. Values indicate overlap shear test performance retained after 1,000 hours of continuous exposure relative to a control sample left at room temperature; samples conditioned for 24 hours at room temperature and 50% relative humidity prior to tests; "NT" = not tested yet.

Note: Fully-cured structural adhesives can withstand short-term incidental contact with almost any solvent, chemical, or environmental condition. However, long-term continuous exposure of these Low Odor Acrylic Adhesives to the following liquids should be avoided:

1. Elevated temperature (>100°F) water
2. Ketone-type solvents (acetone, MEK)
3. Gasoline and similar liquids

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives DP8805NS Green • DP8810NS Green

**Typical Cured
Physical Properties**
(continued)

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

Floating Roller Peel (lb/inch width)¹⁰

Substrate	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive	
	DP8805NS Green	DP8810NS Green
Aluminum	25 CF	30 CF

10. Floating roller peel values measured using ASTM D3167; adhesives allowed to cure for 24 hours at room temperature; 1" wide samples; 0.017" bond line thickness; samples pulled at 6 in/min; aluminum surfaces etched; substrates used were 1/16" thick and 0.020" thick aluminum; failure modes:

AF: adhesive failure CF: cohesive failure SF: substrate failure

Note: The data in this sheet were generated using the 3M™ EPX™ Applicator System equipped with an EPX static mixer, according to manufacturer's directions. Thorough hand-mixing will afford comparable results.

Directions for Use

- To obtain the highest strength structural bonds, paint, oxide films, oils, dust, mold release agents, and all other surface contaminants must be completely removed. The amount of surface preparation depends on the required bond strength and environmental aging resistance desired by user. For suggested surface preparations on common substrates, see the section on surface preparation.
- Mixing

For Duo-Pak Cartridges

Store cartridges with cap end up to allow any air bubbles to rise towards the tip. To use, simply insert the cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. Then remove the cap and expel a small amount of adhesive to ensure material flows freely from both sides of cartridge. For automatic mixing, attach an EPX mixing nozzle to the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after obtaining a uniform color.

For Bulk Containers

Mix thoroughly by weight or volume in the proportion specified on the product label or in the typical uncured properties section. Mix approximately 15 seconds after obtaining a uniform color.
- Apply adhesive and join surfaces within the open time listed for the specific product. Larger quantities and/or higher temperatures will reduce this working time.
- Allow adhesive to cure at 60°F (16°C) or above until completely firm. Applying heat up to 150°F (66°C) will increase cure speed.
- Keep parts from moving during cure. Apply contact pressure or fixture in place if necessary. Optimum bond line thickness ranges from 0.005 to 0.020 inch; shear strength will be maximized with thinner bond lines, while peel strength reaches a maximum with thicker bond lines.
- Excess uncured adhesive can be cleaned up with ketone-type solvents.*

***Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.**

3M™ Scotch-Weld™

Low Odor Acrylic Adhesives

DP8805NS Green • DP8810NS Green

Surface Preparation

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives are designed to be used on painted or coated metals, most plastics, glass, and some bare metals. The following cleaning methods are suggested for common surfaces:

Painted/coated metals:

1. Wipe surface free of dust and dirt with clean cloth and pure isopropyl alcohol.*
2. Sandblast or lightly abrade using clean fine grit abrasives. Do not completely remove the paint layer or coating down to bare steel.
3. Wipe again with clean cloth and pure isopropyl alcohol to remove loose particles.*

Aluminum/stainless steel:

1. Wipe surface free of dust and dirt with clean cloth and pure acetone.*
2. Sandblast or lightly abrade using clean fine grit abrasives.
3. Wipe again with clean cloth and pure acetone to remove loose particles.*

Plastics:

1. Wipe surface free of dust and dirt with clean cloth and pure isopropyl alcohol.*
2. Lightly abrade using fine grit abrasives.
3. Wipe again with clean cloth and pure isopropyl alcohol to remove loose particles.*

Glass:

1. Wipe surface free of dust and dirt with clean cloth and pure acetone.*
2. Apply a thin coating of silane adhesion promoter to the glass surface and allow to dry completely before adhesive bonding.

***Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.**

Storage

Store product at 80°F (27°C) or below. Refrigeration at 40°F (4°C) will help extend shelf life. Do not freeze. Allow product to reach room temperature prior to use.

Shelf Life

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives have a shelf life of 18 months in unopened original containers kept at recommended storage conditions.

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives DP8805NS Green • DP8810NS Green

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

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.



This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

**Industrial Adhesives and Tapes Division**

3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/StructuralAcrylics

3M, Scotch-Weld and EPX are trademarks of 3M Company.
Printed in U.S.A.
©3M 2014