December, 2009

3M™ Scotch-Weld™ Epoxy Adhesive DP125 Gray

Product Description

Scotch-Weld epoxy adhesive DP125 Gray is a filled, pigmented version of the Scotch-Weld epoxy adhesive DP125 Translucent and has similar performance and flexibility properties.
Available in bulk containers as 3M™ Scotch-Weld™ Epoxy Adhesive 125 B/A Gray.

Product Features

- 25 minute worklife
- Flexible
- Gray
- High peel and shear strength
- Controlled flow
- 1:1 mix ratio
- Recognized as meeting UL 94 HB

3M™ Scotch-Weld™ Epoxy Adhesive DP125 Gray

Technical Information Note

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

Typical Uncured Physical Properties

Property	Values	Method	Temp C	Temp F	Notes
Base Color	Gray				
Accelerator Color	Amber				
Base Viscosity	35,000-75,000 cP	3M C1d	27C	80F	Procedure involves Brookfield RVF, #7 spindle, 20 rpm. Measurement taken after 1 minute rotation.
Accelerator Viscosity	45,000-65,000 cP	3M C1d	27C	80F	Procedure involves Brookfield RVF, #7 spindle, 20 rpm. Measurement taken after 1 minute rotation.
Base Resin	Epoxy/Amine				
Base Net Weight	10.3 to 10.7 lb/gal				
Accelerator Net Weight	8.5 to 8.9 lb/gal				
Mix Ratio by Volume (B:A)	1:1				
Mix Ratio by Weight (B:A)	1.2:1				

Typical Performance Characteristics

Additional Test notes

The following product performance data was obtained in the 3M laboratory under the conditions specified. The following data show typical results obtained with the 3M™ Scotch-Weld™ Adhesives when applied to properly prepared substrates, cured, and tested according to the specifications indicated. The data was generated using the 3M™ EPX™ Applicator System equipped with an EPX applicator static mixer, according to manufacturer's directions. Thorough hand mixing should afford comparable results.
Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Performance Characteristics (continued)

Property	Values	Method	Dwell/Cure Time	Notes	Test Name	Temp C	Temp F	Substrate	Substrate Notes	Environmental Condition
Elongation	120 %	ASTM D882	2 hr Room Temperature, plus 2 hr @ 160°F(71°C)	Samples were 2 in. dumbbells with 0.125 in. neck and .030 in. sample thickness. Separation rate was 2 inches per minute.						
T-Peel Adhesion -55C Etched Aluminum	3 lb/in width	ASTM D1876		T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.	T-Peel Adhesion	-55C	-67F	Etched Aluminum	0.005-0.008in bondline	
T-Peel Adhesion 23C Etched Aluminum	35 lb/in width	ASTM D1876		T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.	T-Peel Adhesion	23C	73F	Etched Aluminum	0.005-0.008in bondline	
T-Peel Adhesion 49C Etched Aluminum	18 lb/in width	ASTM D1876		T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.	T-Peel Adhesion	49C	120F	Etched Aluminum	0.005-0.008in bondline	
T-Peel Adhesion 66C Etched Aluminum	3 lb/in width	ASTM D1876		T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.	T-Peel Adhesion	66C	150F	Etched Aluminum	0.005-0.008in bondline	
T-Peel Adhesion 82C Etched Aluminum	2 lb/in width	ASTM D1876		T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.	T-Peel Adhesion	82C	180F	Etched Aluminum	0.005-0.008in bondline	

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Typical Performance Characteristics (continued)

Property	Values	Method	Dwell/Cure Time	Notes	Test Name	Temp C	Temp F	Substrate	Substrate Notes	Environmental Condition
Solvent Resistance Acetone 1hr	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Acetone 1hr
Solvent Resistance Acetone 1month	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Acetone 1month
Solvent Resistance Isopropyl Alcohol 1hr	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Isopropyl Alcohol 1hr

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Typical Performance Characteristics (continued)

Property	Values	Method	Dwell/Cure Time	Notes	Test Name	Temp C	Temp F	Substrate	Substrate Notes	Environmental Condition
Solvent Resistance Isopropyl Alcohol 1month	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Isopropyl Alcohol 1month
Solvent Resistance Freon TF 1hr	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Freon TF 1hr
Solvent Resistance Freon TF 1month	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Freon TF 1month

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Typical Performance Characteristics (continued)

Property	Values	Method	Dwell/Cure Time	Notes	Test Name	Temp C	Temp F	Substrate	Substrate Notes	Environmental Condition
Solvent Resistance Freon TMC 1hr	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Freon TMC 1hr
Solvent Resistance Freon TMC 1month	B		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						Freon TMC 1month
Solvent Resistance 1, 1, 1 - Trichloroethane 1hour	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						1, 1, 1 - Trichloroethane 1hour

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Typical Performance Characteristics (continued)

Property	Values	Method	Dwell/Cure Time	Notes	Test Name	Temp C	Temp F	Substrate	Substrate Notes	Environmental Condition
Solvent Resistance 1, 1, 1 - Trichloroethane 1month	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						1, 1, 1 - Trichloroethane 1month
Solvent Resistance RMA Flux 1hr	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						RMA Flux 1hr
Solvent Resistance RMA Flux 1month	A		24hr @ RT + 2hr @ 160F(71C)	Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed n the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.						RMA Flux 1month

Typical Mixed Physical Properties

Property	Values	Method	Temp C	Temp F	Notes	Test Name	Dwell/Cure Time	Dwell Time Units	Substrate	Substrate Notes

No data available in table

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Typical Mixed Physical Properties (continued)

Property	Values	Method	Temp C	Temp F	Notes	Test Name	Dwell/Cure Time	Dwell Time Units	Substrate	Substrate Notes
Worklife, 2g mixed	25 min	3M C3180	23C	73F	Procedure involves periodically measuring a 2 gram mixed mass for self leveling and wetting properties. This time will also approximate the usable worklife in an 3M™ EPX™ Applicator mixing nozzle.					
Worklife, 20g mixed	15 min	3M C3180	23C	73F	Procedure involves periodically measuring a 2 gram mixed mass for self leveling and wetting properties. This time will also approximate the usable worklife in an 3M™ EPX™ Applicator mixing nozzle.					
Tack Free Time	≈2 hr	3M C3173			Involves dispensing 0.5 gram amount of adhesive onto substrate and testing periodically for no adhesive transfer to metal spatula.					
Time to Full Cure	7 day				The cure time is defined as that time required for the adhesive to achieve a minimum of 80% of the ultimate strength as measured by aluminum-aluminum OLS.					
Time to Full Cure	2.5 hr		23C	73F	The cure time is defined as that time required for the adhesive to achieve a minimum of 80% of the ultimate strength as measured by aluminum-aluminum OLS.					
Rate of Strength Buildup 6hr	500 lb/in²	ASTM D1002	23C	72F	Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate. The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubber, 0.125 in.; plastics, 0.125 in.	Overlap Shear Strength	6	hr	Etched Aluminum	0.005-0.008in bondline

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Typical Mixed Physical Properties (continued)

Property	Values	Method	Temp C	Temp F	Notes	Test Name	Dwell/Cure Time	Dwell Time Units	Substrate	Substrate Notes
Rate of Strength Buildup 1day	1700 lb/in²	ASTM D1002	23C	72F	Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate. The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubber, 0.125 in.; plastics, 0.125 in.	Overlap Shear Strength	1	day	Etched Aluminum	0.005-0.008in bondline
Rate of Strength Buildup 7day	2300 lb/in²	ASTM D1002	23C	72F	Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate. The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubber, 0.125 in.; plastics, 0.125 in.	Overlap Shear Strength	7	day	Etched Aluminum	0.005-0.008in bondline
Rate of Strength Buildup 1month	3300 lb/in²	ASTM D1002	23C	72F	Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate. The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubber, 0.125 in.; plastics, 0.125 in.	Overlap Shear Strength	1	month	Etched Aluminum	0.005-0.008in bondline
Rate of Strength Buildup	250 lb/in²	ASTM D1002	23C	72F	Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate. The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubber, 0.125 in.; plastics, 0.125 in.	Overlap Shear Strength	3	hr	Etched Aluminum	0.005-0.008in bondline

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Typical Mixed Physical Properties (continued)

Property	Values	Method	Temp C	Temp F	Notes	Test Name	Dwell/Cure Time	Dwell Time Units	Substrate	Substrate Notes
Open Time	25 min				Maximum time allowed after applying adhesive to one substrate before bond must be closed and fixed in place. Cure times are approximate and depend on adhesive temperature. For hotmelts: The approximate bonding range of a 1/8" bead of molten adhesive on a non-metallic surface.					
Time to Handling Strength	≈2.5 hr		23C	73F	Minimum time required to achieve 50 psi of overlap shear strength. Cure times are approximate and depend on adhesive temperature.					

Typical Cured Characteristics

Property	Values	Method	Dwell/Cure Time	Notes	Test Condition	Temp C	Temp F
Tensile Strength	3300 lb/in²	ASTM D882	2 hr Room Temperature, plus 2 hr @ 160°F(71°C)	Samples were 2 in. dumbbells with 0.125 in. neck and .030 in. sample thickness. Separation rate was 2 inches per minute.			
Thermal Shock Resistance	Pass 5 cycles without cracking	3M C3174		Involves potting a metal washer into a 2 in. x 0.5 in. thick section and cycling this test specimen to colder and colder temperatures.	Potted Washer Olyphant Test, 100°C [air] to -50°C [liquid]		
Shore D Hardness	70	ASTM D2240				23C	73F

Weight Loss by Thermal Gravimetric Analysis (TGA)		
1 %	303 °C	577 F

Property: Weight Loss by Thermal Gravimetric Analysis (TGA)
Method: ASTM E1131
Temp C: 176C
Temp F: 349F
notes: Weight loss by Thermal Gravimetric Analysis reported as that temperature at which 5% weight loss occurs by TGA in air at 5°C (9°F) rise per minute.

Electrical and Thermal Properties

Glass Transition Temperature (Tg)		Test Condition
23 °C	73 °F	Mid-Point
12 °C	54 °F	Onset

Property: Glass Transition Temperature (Tg)
notes: Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 68°F (20°C) per minute. Second heat values given.

Thermal Conductivity		
0.36 × 10^-3 Cal/s/cm/°C	15.1 W/m/K	0.087 (btu-ft)/(h-ft²-°F)

Property: Thermal Conductivity
Method: C177
Temp F: 110F
notes: Thermal conductivity determined using C-matic Instrument using 2 in. diameter samples.

Property	Values	Method	Temp C	Temp F	Test Condition	Notes
Dielectric Constant 1KHz	6.3	ASTM D150	23C	72F	1 KHz	
Dielectric Constant 1MHz	0.13	ASTM D150	23C	72F	1MHz	
Volume Resistivity	1.0 × 10^11 Ω-cm	ASTM D257	23C	73F		
Coefficient of Thermal Expansion	98 m/m/°C				Below Tg (5-20°C range)	TCE determined using TMA Analyzer using a heating rate of 10°C per minute. Second heat values given.
Coefficient of Thermal Expansion	187 m/m/°C				Above Tg (65-140°C range)	TCE determined using TMA Analyzer using a heating rate of 10°C per minute. Second heat values given.

Handling/Application Information

Application Equipment

For small or intermittent applications the 3M™ EPX™ Applicator System is a convenient method of application.
For larger applications these products may be applied by use of flow equipment.
Two part meter/mixing/proportioning/dispensing equipment is available for intermittent or production line use. These systems may be desirable because of their variable shot size and flow rate characteristics and are adaptable to many applications.

Handling/Application Information (continued)

Directions for Use

1. For high strength structural bonds, paints, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user. For specific surface preparations on common substrates, see the section on surface preparation.
2. Use gloves to minimize skin contact. Do not use solvents for cleaning hands.
3. Mixing.
For Duo Pak Cartridges
3M™ Scotch-Weld™ Epoxy Adhesives DP125 Translucent and Gray are supplied in a dual syringe plastic duo-pak cartridge as part of the 3M™ EPX™ Applicator System. To use, simply insert the duo-pak cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. Next, remove the duopak cartridge cap and expel a small amount of adhesive to be sure both sides of the duo-pak cartridge are flowing evenly and freely. If automatic mixing of Part A and Part B is desired, attach the EPX applicator mixing nozzle to the duo-pak cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.
For Bulk Containers
Mix thoroughly by weight or volume in the proportions specified in the typical uncured properties section. Mix approximately 15 seconds after uniform color is obtained.
4. For maximum bond strength, apply adhesive evenly to both surfaces to be joined.
5. Application to the substrates should be made within 20 minutes. Larger quantities and/or higher temperatures will reduce this working time.
6. Join the adhesive coated surfaces and allow to cure at 60°F (16°C) or above until completely firm. Heat up to 200°F (93°C), will speed curing. These products will cure in 7 days @ 75°F (24°C).
7. Keep parts from moving during cure. Contact pressure necessary. Maximum shear strength is obtained with a 3-5 mil bond line.
8. Excess uncured adhesive can be cleaned up with ketone type solvents.*
*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow manufacturer's precautions and directions for use.
Adhesive Coverage (typical): A 0.005 in. thick bondline will yield a coverage of 320 sqft/gallon.

Handling/Application Information (continued)

Surface Preparation

For high strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user.
The following cleaning methods are suggested for common surfaces:
Steel:
1. Wipe free of dust with oil-free solvent such as acetone, isopropyl or alcohol solvents.*
2. Sandblast or abrade using clean fine grit abrasives.
3. Wipe again with solvent to remove loose particles.*
4. If a primer is used, it should be applied within 4 hours after surface preparation.
Aluminum:
1. Alkaline Degrease: Oakite 164 solution (9-11 oz./gallon water) at 190°F ± 10°F for 10-20 minutes. Rinse immediately in large quantities of cold running water.
2. Acid Etch: Place panels in the following solution for 10 minutes at 150°F ± 5°F .

Sodium Dichromate	4.1 - 4.9 oz./gallon
Sulfuric Acid, 66°Be	38.5 - 41.5 oz./gallon
2024-T3 aluminum (dissolved)	0.2 oz./gallon minimum
Tap water as needed to balance	

3. Rinse: Rinse panels in clear running tap water.
4. Dry: Air dry 15 minutes; force dry 10 minutes at 150°F ± 10°F.
5. If primer is to be used, it should be applied within 4 hours after surface preparation.
Note: Read and follow supplier's environmental, health, and safety documentation for these chemicals prior to preparation of this solution.
Plastics/Rubber:
1. Wipe with isopropyl alcohol.*
2. Abrade using fine grit abrasives.
3. Wipe with isopropyl alcohol.*
Glass:
1. Solvent wipe surface using acetone or MEK.*
2. Apply a thin coating (0.0001 in. or less) of primer such as 3M™ Scotch-Weld™ Metal Primer EC3901 to the glass surfaces to be bonded and allow the primer to dry before bonding.
*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow manufacturer's precautions and directions for use.

Storage and Shelf Life

Store products at 60-80°F (16-27°C) for maximum shelf life.
These products have a shelf life of 24 months from date of manufacture in their unopened original containers.

Industry Specifications

UL 94 HB

Trademarks

3M, Scotch-Weld and EPX are trademarks of 3M Company.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Scotch-Weld-Epoxy-Adhesive-DP125/?N=5002385+3293242443&rt=rud
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=DP125 Gray

3M™ Scotch-Weld™ Epoxy Adhesive DP125 Gray

Typical Physical Properties

Property	Values	Test Name
Color	Gray	Mixed
Color	Gray	Cured

Family Group

	DP125 Translucent	DP125 Gray
Color Test Name: Mixed	Translucent	Gray
Color Test Name: Cured	Translucent	Gray
Open Time (min)	25	25

ISO Statement

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

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.

Information

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