

The 3M logo is displayed in a bold, red, sans-serif font.

**Scotch-Weld™**  
Structural Adhesive

The background of the advertisement shows a blurred image of a man in a black shirt working on an aircraft fuselage in a factory setting. A large, bright orange triangle is overlaid on the bottom right of the image, containing the main text.

# 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.



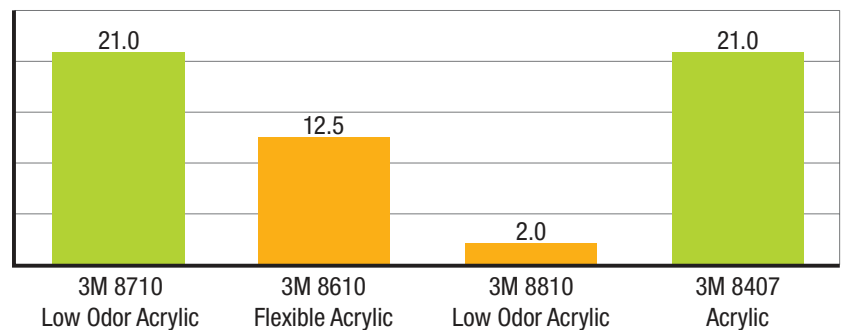
## Higher Impact Resistance

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





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.

Low odor. High strength.

Improved formulation for enhanced workplace safety and productivity.

The 3M™ Scotch-Weld™

## 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.

### Faster Cure

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

### Higher Impact Resistance

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

### Nylon and LSE bonding

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

### No Refrigeration &

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	IPC	Stock #
							-40°F (-40°C)			
							75°F (24°C)			
							180°F (82°C)			

**Industrial Adhesives  
& Tapes Division**

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