

3M Scotch-Weld™ DP125 Translucent Epoxy Adhesive

Category : Polymer , Thermoset , Epoxy , Epoxy Adhesive

Material Notes:

3M™ Scotch-Weld™ Epoxy Adhesive DP125 Translucent is a faster curing version of 3M Scotch-Weld Epoxy Adhesive 2216 Translucent B/A. The worklife and cure time has been reduced from hours and days for the Scotch-Weld epoxy adhesive 2216 Translucent B/A to minutes and hours. Final shear and peel strengths remain similar or even slightly improved compared to the Scotch-Weld epoxy adhesive 2216 Translucent. Information provided by 3M

Order this product through the following link:

http://www.lookpolymers.com/polymer_3M-Scotch-Weld-DP125-Translucent-Epoxy-Adhesive.php

Physical Properties	Metric	English	Comments
Brookfield Viscosity	2000 - 8000 cP	2000 - 8000 cP	Base, RVF #7 spindle, 20 rpm @ 27°C
	22000 - 33000 cP	22000 - 33000 cP	Accelerator, RVF #7 spindle, 20 rpm @ 27°C

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	55	55	ASTM D2240
Tensile Strength at Break	17.2 MPa	2490 psi	ASTM D882
Elongation at Break	150 %	150 %	ASTM D882
Shear Strength	0.172 MPa	25.0 psi	Overlap, Polypropylene
	1.38 MPa	200 psi	Overlap, +3M Primer 3901
	1.72 MPa	250 psi	Overlap, Glass, Borosilicate
	2.90 MPa	420 psi	Overlap, Acrylic
	3.17 MPa	460 psi	Overlap, ABS
	3.45 MPa	500 psi	Overlap, PVC
	4.83 MPa	700 psi	Overlap, Wood, Fir
	4.83 MPa	700 psi	Overlap, Polycarbonate
	8.27 MPa	1200 psi	Overlap, Fiberglass
	9.65 MPa	1400 psi	Overlap, Sanded Aluminum
10.3 MPa	1500 psi	Overlap, Cold Rolled Steel	
17.2 MPa	2500 psi	Overlap, Etched Aluminum	
1.03 MPa	150 psi		

Mechanical Properties	Metric @ Temperature 82.0 °C	English @ Temperature 180 °F	Overlap Comments
	1.31 MPa	190 psi	Overlap
	@Temperature 66.0 °C	@Temperature 151 °F	
	2.76 MPa	400 psi	Overlap
	@Temperature 49.0 °C	@Temperature 120 °F	
	17.2 MPa	2500 psi	Overlap
	@Temperature 21.0 °C	@Temperature 69.8 °F	
	27.6 MPa	4000 psi	Overlap
	@Temperature -55.0 °C	@Temperature -67.0 °F	
Peel Strength	0.351 kN/m	2.00 pli	180°
	0.526 kN/m	3.00 pli	180°
	0.526 kN/m	3.00 pli	180°
	1.75 kN/m	10.0 pli	180°
	6.14 kN/m	35.0 pli	180°

Thermal Properties	Metric	English	Comments
CTE, linear	112 $\mu\text{m}/\text{m}\cdot\text{°C}$	62.2 $\mu\text{in}/\text{in}\cdot\text{°F}$	Below Tg
	@Temperature 5.00 - 20.0 °C	@Temperature 41.0 - 68.0 °F	
	190 $\mu\text{m}/\text{m}\cdot\text{°C}$	106 $\mu\text{in}/\text{in}\cdot\text{°F}$	Above Tg
	@Temperature 65.0 - 140 °C	@Temperature 149 - 284 °F	
Thermal Conductivity	0.154 W/m-K	1.07 BTU-in/hr-ft ² -°F	
	@Thickness 6.35 mm, Temperature 44.3 °C	@Thickness 0.250 in, Temperature 112 °F	
Glass Transition Temp, Tg	3.00 °C	37.4 °F	Onset
	15.0 °C	59.0 °F	Mid-Point

Electrical Properties	Metric	English	Comments
Volume Resistivity	1.20e+11 ohm-cm	1.20e+11 ohm-cm	ASTM D257
Dielectric Constant	6.3	6.3	ASTM D150
	@Frequency 1000 Hz	@Frequency 1000 Hz	

Electrical Properties	30.1 kV/mm Metric	765 kV/in English	Comments
	@Thickness 0.762 mm	@Thickness 0.0300 in	

Processing Properties	Metric	English	Comments
Cure Time	120 min	2.00 hour	Tack-free
	150 min	2.50 hour	Time to Handling Strength
	420 min	7.00 hour	Full

Descriptive Properties	Value	Comments
Appearance	Amber	Accelerator
	Clear	Base
	Translucent	

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