

## 3M Scotch-Weld™ DP640 Structural Adhesive

Category : Polymer , Adhesive

### Material Notes:

3M™ Scotch-Weld™ Urethane Adhesives are two-part, non-sag urethane adhesives. They feature tough, flexible bonds with good adhesion to a wide variety of substrates especially wood and many properly abraded and cleaned plastics. Good adhesion can also be obtained on etched aluminum as well as primed aluminum, steel glass. For maximum bond durability under moisture conditions, priming of glass and metal substrates is required. Information provided by 3M

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_3M-Scotch-Weld-DP640-Structural-Adhesive.php](http://www.lookpolymers.com/polymer_3M-Scotch-Weld-DP640-Structural-Adhesive.php)

Physical Properties	Metric	English	Comments
Viscosity	25000 cP	25000 cP	
Brookfield Viscosity	10000 - 40000 cP	10000 - 40000 cP	Base, RVF #6 sp @ 10 rpm
	15000 - 55000 cP	15000 - 55000 cP	Accelerator, RVF #5 sp @ 10 rpm

Mechanical Properties	Metric	English	Comments
Hardness, Shore A	70 - 80	70 - 80	ASTM D2240
Elongation at Break	100 %	100 %	ASTM D882
Shear Strength	13.8 MPa	2000 psi	

Electrical Properties	Metric	English	Comments
Volume Resistivity	2.60e+12 ohm-cm	2.60e+12 ohm-cm	ASTM D257
Dielectric Constant	5.9	5.9	ASTM D150
	@Frequency 1000 Hz	@Frequency 1000 Hz	
Dielectric Strength	18.5 kV/mm	470 kV/in	ASTM D149
Dissipation Factor	0.12	0.12	ASTM D150
	@Frequency 1000 Hz	@Frequency 1000 Hz	

Processing Properties	Metric	English	Comments
Cure Time	360 - 480 min	6.00 - 8.00 hour	Time to Handling Strength
	10100 min	168 hour	Full Cure

Descriptive Properties	Value	Comments
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Appearance

Descriptive Properties	Brown Value	Comments
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## Contact Songhan Plastic Technology Co.,Ltd.

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