

3M Scotch-Weld™ DP812 Acrylic Adhesives

Category : Polymer , Adhesive

Material Notes:

3M™ Scotch-Weld™ Acrylic Adhesive DP812 is a two-part, 1:1 mix ratio, toughened acrylic structural adhesives. They exhibit excellent shear and peel strengths along with good impact, durability and bond well to many metals, ceramics, wood and most plastics with minimal surface preparation. Information provided by 3M

Order this product through the following link:

http://www.lookpolymers.com/polymer_3M-Scotch-Weld-DP812-Acrylic-Adhesives.php

Physical Properties	Metric	English	Comments
Viscosity	>= 3500 cP	>= 3500 cP	Base
	>= 7500 cP	>= 7500 cP	Accelerator

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	70	70	
Shear Strength	2.59 MPa	375 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Toulene
	6.55 MPa	950 psi	Overlap, Acrylic, Substrate Failure
	6.72 MPa	975 psi	Overlap, Etched Aluminum
	6.89 MPa	1000 psi	Overlap, PC, Substrate Failure
	7.24 MPa	1050 psi	Overlap, ABS, Substrate Failure
	7.412 MPa	1075 psi	Overlap, PVC, Substrate Failure
	14.65 MPa	2125 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 66°C tap water
	14.65 MPa	2125 psi	Overlap, Etched Aluminum
	17.06 MPa	2475 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 66°C and 80% RH
	17.06 MPa	2475 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Unleaded gasoline
	18.44 MPa	2675 psi	Overlap, Cold-Rolled Steel - slightly oily, Cohesive Failure
	18.79 MPa	2725 psi	Overlap, Etched Aluminum
19.0 MPa	2750 psi	Overlap, Green Fiberglass Reinforced Plastic, Adhesive Failure	

Mechanical Properties	Metric MPa	English	Comments
			Cold-Rolled Steel - solvent cleaned, Adhesive Failure
	26.37 MPa	3825 psi	Overlap, Aluminum - etched, Adhesive Failure
	26.37 MPa	3825 psi	Overlap, Aluminum - abraded, 150 grit sandpaper, Adhesive Failure
	27.75 MPa	4025 psi	Overlap, Stainless Steel, Adhesive Failure
	27.75 MPa	4025 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in IPA
	27.9 MPa	4050 psi	Overlap, Aluminum - bare, Adhesive Failure
	30.51 MPa	4425 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Diesel fuel
	33.1 MPa	4800 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 20% bleach solution
	33.27 MPa	4825 psi	Overlap, Etched Aluminum
	37.40 MPa	5425 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 50% Anitfreeze
	37.9 MPa	5500 psi	Overlap, Etched Aluminum cured for 7 days @ RT
Peel Strength	5.26 kN/m	30.0 pli	Etched Al/Etched Al after 1 week at RT cure

Processing Properties	Metric	English	Comments
Cure Time	240 - 1440 min	4.00 - 24.0 hour	Full cure

Descriptive Properties	Value	Comments
Appearance	Off-white	Base
	Pale yellow	
	Yellow	Accelerator

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