

3M Science.
Applied to Life.™

Apply, bond and go.

Introducing
3M™ Scotch-Weld™
EC-7202 B/A Bracket
Bonding Adhesive.



Meet your dream product. This revolutionary, two-part structural paste adhesive instantly holds parts in place with no sag, no mess and no installation fixtures required. You'll reduce waste, save money and increase productivity.

- ▶ Fast and easy to apply
- ▶ Cures within 90 minutes to handling strength
- ▶ Fewer steps — simplifies your process
- ▶ High mechanical strength
- ▶ Qualified to OEM specification





Strong.

Excellent shear and peel strength on substrates used in aircraft.



Fast.

Ideal for bonding fasteners, brackets and pins.



Neat.

Easy-to-use cartridges ensure precise, neat and consistent application.



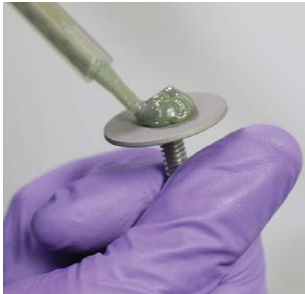
Safe.

Low-flow adhesive can be safely used in vertical and overhead applications.

Easy 2-Step Process:

STEP 1:

Apply adhesive to bracket



STEP 2:

Bond to desired surface



Go – no support needed

Product and Ordering Information:

Qualified to OEM specification

Properties	Part B	Part A	Test Method
Chemical Base	Modified epoxy	Modified amine	
Color	Yellow	Dark gray	
Consistency	Paste	Paste	
Density	1.10 g/cm ³	1.07 g/cm ³	ISO 2811
Mix Ratio by Volume	100	50	
Viscosity @ 73°F (23°C)	440 Pa-s	270 Pa-s	Rheometer (AITM 3-0004)
Cure Time to Handling	435 psi (3 MPa) after 90 min @ 73°F (23°C)		EN 2243-1
Shear Strength	up to 5,075 psi (35 MPa)		ISO 4587
Overlap Shear Strength*	60 min 43.5 psi (0.3 MPa) 90 min 470 psi (3.3 MPa) 104 min 2,132 psi (14.7 MPa) 120 min 2,944 psi (20.3 MPa) 150 min 4,409 psi (30.4 MPa)		EN 2243-1
Temperature Range	-67°F to 185°F (-55°C to 85°C)		
Color in Mixed State	Olive green		
Work Life	10 min @ 73°F (23°C)		Internal test method**
Extrudability [50 ml Cartridge, 73°F (23°C)]	20 min extrudable from mixing nozzle (EPX Quadro, Art. 300 346: 5.3/16)		
Available Packaging	50 ml duo-pack cartridge, others on request		

*Test conditions: Clad Al 2024 T3, thickness 1.6 mm, surface treatment: CAA + primer BR127, test speed: 10 mm/min.

**Time during which the adhesive can be applied properly.

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