



Heat Accelerated Cure of 3M™ Scotch-Weld™ Structural Adhesives

Technical Bulletin

October 2016

These charts are intended as a reference guide for accelerated cure. It is important that the temperature in the bondline reach the specified temperature as increasing the temperature will speed up the cure of the products. If you put the parts into an oven, remember to allow time for the parts to come up to temperature.

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Room Temperature Cured Epoxies	75°F (24°C) RT	120°F (49°C)	150°F (66°C)	200°F (93°C)
3M™ Scotch-Weld™ DP100, 3M™ Scotch-Weld™ DP100 NS, 3M™ Scotch-Weld™ DP100 FR, 3M™ Scotch-Weld™ DP100+ (Plus) 3M™ Scotch-Weld™ DP105	24 hours	30 min	8-10 min	3 min
3M™ Scotch-Weld™ DP110 Gray, 3M™ Scotch-Weld™ DP110 Trans	48 hours	2 hours	45 min	15 min
3M™ Scotch-Weld™ DP125 Gray, 3M™ Scotch-Weld™ DP125 Trans	7 days	3 hours	1 hour	20 min
3M™ Scotch-Weld™ DP190 Gray, 3M™ Scotch-Weld™ 2216 B/A Gray	7 days	6 hours	2 hours	30 min
3M™ Scotch-Weld™ DP190 Trans, 3M™ Scotch-Weld™ 2216 B/A Trans	14 days	12 hours	4 hours	1 hour
3M™ Scotch-Weld™ DP270 Black, 3M™ Scotch-Weld™ DP270 Trans	48 hours	4 hours	1-1.5 hours	30-45 min
3M™ Scotch-Weld™ DP405 Black	24 hours	30 min	15 min	10 min
3M™ Scotch-Weld™ DP420, 3M™ Scotch-Weld™ DP420 Black, 3M™ Scotch-Weld™ DP420 LH, 3M™ Scotch-Weld™ DP420 NS	24 hours	1 hour	30 min	10 min
3M™ Scotch-Weld™ DP460, 3M™ Scotch-Weld™ DP460 NS	48 hours	3 hours	1 hour	20 min
3M™ Scotch-Weld™ DP920	24 hours	3 hours	1 hour	20 min
3M™ Scotch-Weld™ 1838 B/A Green, 3M™ Scotch-Weld™ 1838 B/A Tan, 3M™ Scotch-Weld™ 1838 B/A Trans	7 days	6 hours	2 hours	30 min

Heat Cured Epoxies	175°F (77°C)	200°F (93°C)	225°F (107°C)	250°F (121°C)	300°F (149°C)	350°F (177°C)
3M™ Scotch-Weld™ 2214 Reg, 3M™ Scotch-Weld™ 2214 HF, 3M™ Scotch-Weld™ 2214 HT (Old), 3M™ Scotch-Weld™ 2214 NMF	7 hours	3 hours	90 min	40 min	10 min	5 min
3M™ Scotch-Weld™ 2214 HTNF	Don't even try it			60 min	15 min	not recommended

Notes:

- 1) Curing not recommend at any temperatures higher than what is listed on this chart. It may work but there is a much greater potential for problems.
- 2) These are times for full cure; time to handling strength will be less.
- 3) Cure times at 40°F (4°C) will be at least three to four times longer than room temperature cure.

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Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Urethanes	75°F (24°C) RT	120°F (49°C)	150°F (66°C)	200°F (93°C)
3M™ Scotch-Weld™ DP604	24 hours	1 hour	20 min	15 min
3M™ Scotch-Weld™ DP605	48 hours	2 hours	1 hour	30 min
3M™ Scotch-Weld™ DP608	48 hours	4 hours	1 hour	20 min
3M™ Scotch-Weld™ DP620	4 days	4 hours	2 hours	30 min
3M™ Scotch-Weld™ DP640, 3M™ Scotch-Weld™ 3549 B/A	7 days	8 hours	5 hours	2 hours
3M™ Scotch-Weld™ DP6310NS	24 hours	4 hours	2 hours	20 min
3M™ Scotch-Weld™ DP6330NS	48 hours	6 hours	3 hours	45 min
3M™ Scotch-Weld™ 3532 B/A	24 hours	2 hours	1 hour	30 min
3M™ Scotch-Weld™ 3535 B/A	3 hours	1.5 hours	45 min	–

Acrylics	75°F (24°C) RT	120°F (49°C)	150°F (66°C)
3M™ Scotch-Weld™ DP810, 3M™ Scotch-Weld™ DP810 Black, 3M™ Scotch-Weld™ DP810 NS	24 hours	30 min	10 min
3M™ Scotch-Weld™ DP805	24 hours	30 min	10 min
3M™ Scotch-Weld™ DP807	24 hours	45 min	30 min
3M™ Scotch-Weld™ DP812	24 hours	45 min	30 min
3M™ Scotch-Weld™ DP820	48 hours	1 hour	20 min
3M™ Scotch-Weld™ DP825	24 hours	90 min	60 min
3M™ Scotch-Weld™ DP8005, 3M™ Scotch-Weld™ DP8005 Black	24 hours	4 hours	1 hour
3M™ Scotch-Weld™ DP8010 Blue, 3M™ Scotch-Weld™ DP8010 NS Blue (Tested on HDPE)	4 hours	1 hour*	30 min*

*A 10 minute dwell at room temperature is recommended before heat curing.

Notes:

- 1) Curing not recommend at any temperatures higher than what is listed on this chart. It may work but there is a much greater potential for problems.
- 2) These are times for full cure; time to handling strength will be less.
- 3) Cure times at 40°F (4°C) will be at least three to four times longer than room temperature cure.

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Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

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