



**Scotch-Weld™**  
Structural Adhesive



## 3M™ Scotch-Weld™ Flexible Acrylic Adhesive 8600 Series

# The strength of a structural acrylic. The flexibility of a sealant.

Offering a unique set of benefits, 3M™ Scotch-Weld™ Flexible Acrylic Adhesive 8600 Series provides the flexibility of a sealant combined with the strength and cure speed of an acrylic adhesive, allowing you to be more flexible in your design.



**Limits bond line read-through:** Helps thin, flat surfaces maintain their aesthetic appearance.



**Flexible like a sealant:** For greater impact resistance.



**High elongation up to 200%:** Withstands stresses between dissimilar materials.



**Fast, strong cure:** For assembly speed and productivity.



**Offers new opportunities for design:** Expands what's possible.



**Non-flammable classification and low odor formulation:** to help improve the working environment.

# 3M™ Scotch-Weld™ Flexible Acrylic Adhesive 8600 Series

Designed to help you remake how you make things, our expanded range of fast and easy-to-use acrylic adhesives will free you to create new designs. They'll also help enhance productivity as you build better assemblies in a low odor environment.

**Markets include:** Transportation, Rail, Signage & Architectural Panel

**Applications include:** Panel-to-frame bonding

Product (Color)	Key Features	Shelf Life	Size	UPC	Stock #
<b>3M™ Scotch-Weld™ Flexible Acrylic Adhesive DP8610NS (Black)</b>	10 minute work life; 18 minute time to handling strength	12 months*	45 mL	00-638060-40836-0	7100233359
			490 mL	00-638060-40837-7	7100232802
			5 gal. drum B	00-638060-40838-4	7100234673
			50 gal. drum B	00-638060-40839-1	7100234570
<b>3M™ Scotch-Weld™ Flexible Acrylic Adhesive DP8625NS (Black)</b>	23 minute work life; 28 minute time to handling strength	12 months*	45 mL	00-638060-40972-5	7100244478
			490 mL	00-638060-40973-2	7100244477
			5 gal. drum B	00-638060-40974-9	7100244476
			50 gal. drum B	00-638060-40975-6	7100244859
<b>3M™ Scotch-Weld™ Acrylic Adhesive Accelerator A3-2</b>	Used to mix with 5 & 55 gal. 8600 Series products	24 months*	1 gal. pail A	00-638060-40862-9	7100233358
			5 gal. pail A	00-638060-40863-6	7100234571

\* From date of manufacture in unopened original containers kept at recommended storage conditions.

**For more information on 3M™ Scotch-Weld™ Acrylic Adhesives, visit: [3M.com/acrylicadhesives](http://3M.com/acrylicadhesives) or call 1-800-362-3550.**



**Industrial Adhesives & Tapes Division**  
 3M Center  
 Building 225-3S-06  
 St. Paul, MN 55144-1000  
 1-800-362-3550  
[www.3M.com/acrylicadhesives](http://www.3M.com/acrylicadhesives)

**Warranty and Limited Remedy:** 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER EXPRESS OR IMPLIED WARRANTIES OR CONDITIONS, INCLUDING ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. If a 3M product does not conform to this warranty, the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price. **Limitation of Liability:** Except for the limited remedy above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential, regardless of the legal or equitable theory asserted.

3M and Scotch-Weld are trademarks of 3M Company.

© 2021 3M. All rights reserved. Feb 2021

70-0716-1699-2