



# Dispensing Guide for 3M™ Scotch-Weld™ Two-Part Epoxy Adhesive DP100

Technical Bulletin

March 2022

## Uncured Properties

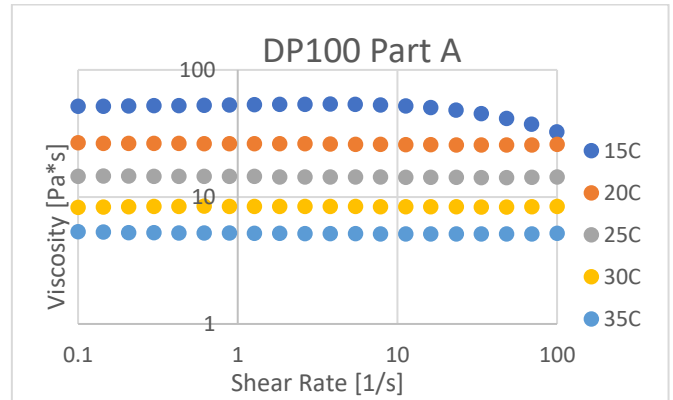
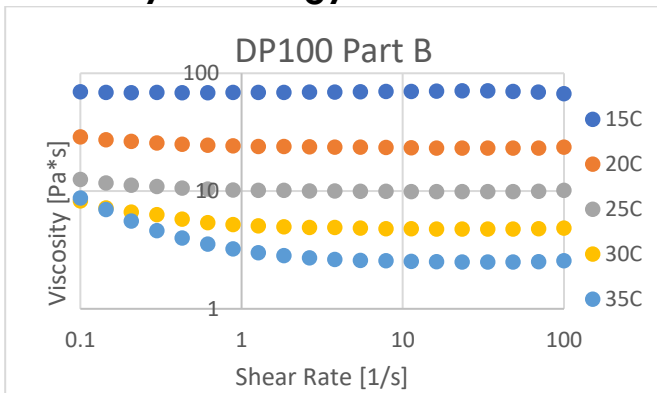
| DP100             | B Base  | A Accelerator |
|-------------------|---------|---------------|
| Color             | Clear   | Clear         |
| Ratio by volume   | 1       | 1             |
| Ratio by weight   | 1       | 0.98          |
| Density (lb/gal)  | 9.5-9.9 | 9.2-9.6       |
| Thixotropic Index | 1.02    | 1.01          |

## Packaging

|               | Description                                   |
|---------------|---|
| 45-50ml       | Mixpac B system                               |
| 200*/400ml    | Mixpac C system                               |
| 5-gallon pail | Straight sided<br>I.D. of 341.31mm x 285.75mm |

\*where available

## Viscosity/Rheology



\*Note: Viscosity measurements done by cone and plate

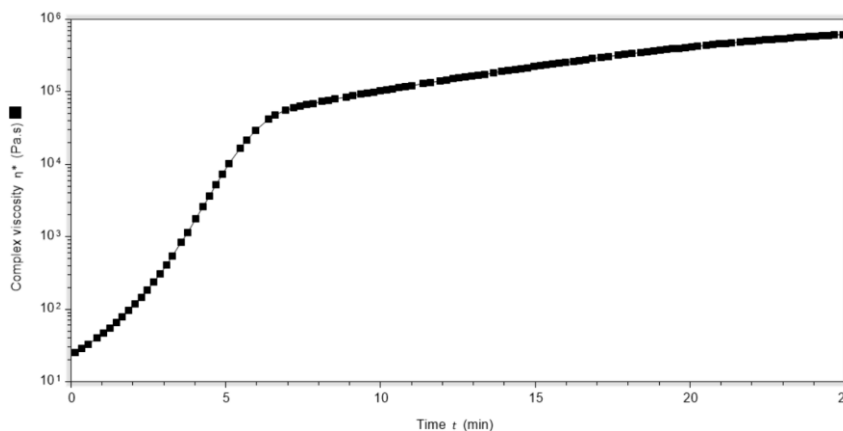
## Cartridge Startup

When dispensing from a cartridge level the A&B pistons at initial set up. Material should be purged from the static mixer until a homogenous mix between parts A&B is achieved.

## Purge Recommendation

For short purge times between runs the graph below shows the mixed viscosity of DP100 over time, based on static mixer and purge volume use this graph for a recommended purge time. For a one component purge using bulk dispensers, purge with DP100 Part B.

## DP100 Mixed Viscosity vs. Time







# Technical Bulletin

## Dispensing Guide for 3M™ Scotch-Weld™ Two-Part Epoxy Adhesive DP100

\*Note: Viscosity vs. time taken at 25°C

### Mixing Nozzles

| 50ml   | 200/400ml  |  |   |
|--|--|--|---|
| Quadro<br>Mix Elements:16<br>Length (mm):85<br>Volume (ml):1.88<br> | Helical<br>Mix Elements:24<br>Length (mm): 185<br>Volume (ml): 4.20<br> | Quad<br>Mix Elements: 20<br>Length (mm):126.9<br>Volume (ml): 5.4<br> | Helical<br>Mix Elements: 24<br>Length (mm) 277<br>Volume (ml): 14.60<br> |
| sku:7100148765   | sku:7000046633   | sku:7000028616   | sku: 7000043674   |

### Cleaning of Equipment

Excess uncured adhesive can be cleaned with methyl ethyl ketone (MEK). Follow equipment manufacturing procedures for cleaning of their equipment.

### Abrasives

No abrasive fillers are used in this material.

**Technical Information:** The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

**Product Selection and Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

**Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then 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 stated 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 (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

**Disclaimer:** 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit [www.3M.com](http://www.3M.com).



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

3M and Scotch-Weld are registered trademark of 3M Company.  
 © 3M 2022.