



Dispensing Guide for 3M™ Scotch-Weld™ Two-Part Epoxy Adhesive DP125

Technical Bulletin

March 2022

Uncured Properties

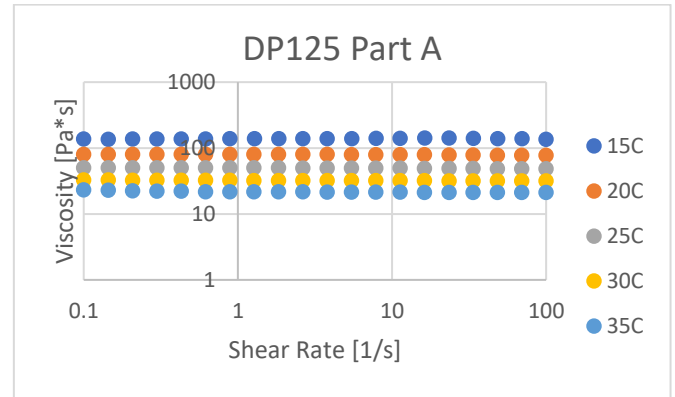
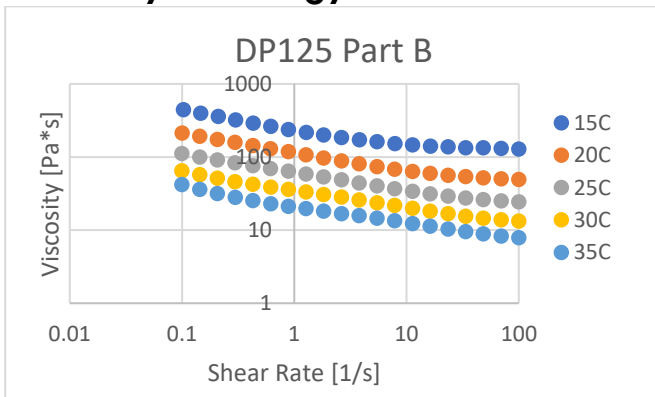
DP125	B Base	A Accelerator
Color	Grey	Amber
Ratio by volume	1	1
Ratio by weight	1.2	1
Density (lb/gal)	10.3-10.7	8.5-8.9
Thixotropic Index	1.7	1.01

Packaging

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

*where available

Viscosity/Rheology



*Note: Viscosity measurements done by cone and plate

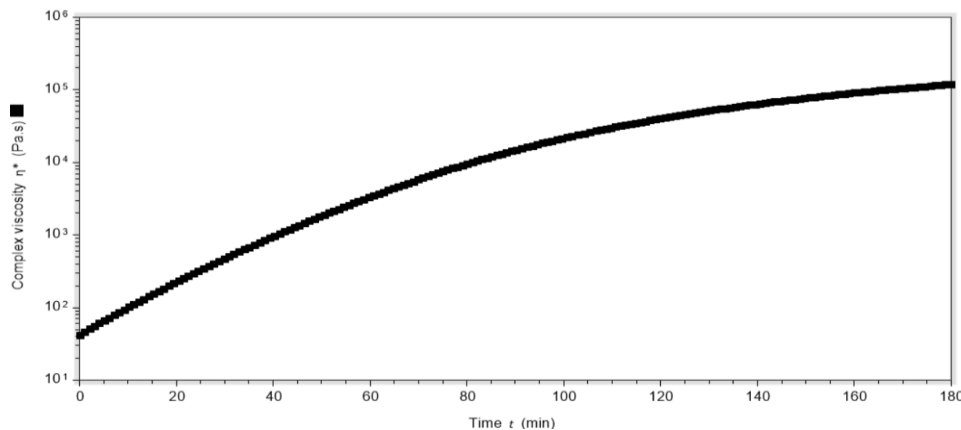
Cartridge Startup

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 DP125 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 DP125 Part B.

DP125 Mixed Viscosity vs. Time







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

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Mixing Nozzles

50ml	200/400ml		
Quadro Mix Elements:16 Length (mm):85 Volume (ml):1.88 	Helical Mix Elements:24 Length (mm): 185 Volume (ml): 4.20 	Quad Mix Elements: 20 Length (mm):126.9 Volume (ml): 5.4 	Helical Mix Elements: 24 Length (mm) 277 Volume (ml): 14.60 
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.

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