



# Technical Data Sheet

## 3M™ Scotch-Weld™ Structural Plastic Adhesive DP8005 Black



[Product Details](#)



[Regulatory Info/SDS](#)

### Product Description

3M™ Scotch-Weld™ Structural Plastic Adhesive DP8005 is a two-part acrylic- based adhesive (10:1 ratio by volume) that can bond many low surface energy plastics, including many grades of polypropylene, polyethylene, and TPO’s without special surface preparation.

3M™ Scotch-Weld Adhesive DP8005 can replace screws, rivets, plastic welding, and two-step processes which include chemical etchants, priming or surface treatments in many applications.

### Product Features

- Ability to Bond Dissimilar Substrates
- Ability to Structurally Bond Polyolefins
- Room Temperature Cure
- Excellent Water and Humidity Resistance
- Very Good Chemical Resistance
- One Step Process - No Pre-Treatment of the Substrates Needed
- Solvent-free Adhesive System
- Convenient Hand-Held Applicator System
- Contains 0.008” glass beads for bondline thickness control
- Available in Bulk

### Technical Information Note

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

### Typical Uncured Physical Properties

Attribute Name	Value
Mix Ratio by Weight (B:A)	9.16:1
Mix Ratio by Volume (B:A)	10:1

Attribute Name	Temperature	Value
Base Color		Black
Accelerator Color		White
Base Resin		Methacrylate
Accelerator Resin		Amine
Base Net Weight		8 — 8.4 lb/gal
Accelerator Net Weight		8.7 — 9.15 lb/gal
Base Viscosity	23 °C (73 °F)	15000 — 30000 cP <sup>1</sup>
Accelerator Viscosity	23 °C (73 °F)	35000 — 55000 cP <sup>2</sup>

<sup>1</sup> Viscosity obtained by Brookfield, DV-II, #7 Spindle, 20 rpm

<sup>2</sup> Viscosity obtained by Brookfield, DV-II, #7 Spindle, 20 rpm.

## Typical Mixed Physical Properties

Temperature: 23 °C (73 °F)

Attribute Name	Value
Worklife	2.5 — 3 min
Time to Handling Strength	2 — 3 h <sup>1</sup>

<sup>1</sup> Minimum time required to achieve 0.3 MPa (50 psi) of overlap shear strength. Cure times are approximate and depend on adhesive temperature.

## Typical Physical Properties

Attribute Name	Value
Cured Color	Black

## Typical Cured Characteristics

Attribute Name	Test Method	Temperature	Value
Modulus at 1% Strain		23 °C (73 °F)	58,782 lb/in <sup>2</sup> <sup>1</sup>
Strain at Peak Load			4.5 % <sup>1</sup>
Peak Stress			1,692 lb/in <sup>2</sup> <sup>1</sup>
Shore D Hardness	ASTM D2240	23 °C (73 °F)	60

<sup>1</sup> Mechanical properties obtained using a Sintech 5GL Mechanical Tester. Approximate dimensions of the test specimen was 38 x 13 x 7.6 mm (1.5 x 0.5 x 0.3 in). Elongation was determined by crosshead displacement. The crosshead velocity was 13 mm/min (0.5 in/min).

## Typical Performance Characteristics

Substrate: High Density Polyethylene (HDPE)

Attribute Name	Test Method	Value
T-Peel Adhesion	ASTM D1876	9 lb/in width (C sh) <sup>1</sup>

<sup>1</sup> Peel tests on 0.5 mm (0.02 in) thick HDPE, 0.4 mm (0.017 in) bondline thickness, 203 x 25 mm (8 x 1 in) in T-peel mode at a rate of 51 mm/min (2 in/min).  
SF = Substrate Failure/Break/Yield, C sh = Cohesive but shocky

## Electrical and Thermal Properties

### Coefficient of Thermal Expansion

Test Condition	Value
Below T <sub>g</sub>	125 ppm/°C <sup>1</sup>
Above T <sub>g</sub>	170 ppm/°C <sup>1</sup>

<sup>1</sup> T<sub>g</sub> and CTE determined by TMA -40 ~ 120 °C (-40 ~ 249 °F) at 5.5 °C/min (10 °F/min). (after 2 heat cycles).

## Handling/Application Information

### Directions for Use

**Important:** Use only the specified 3M™ EPX™ Plus II Applicator system or appropriate meter mix equipment to ensure the proper 10:1 mix ratio and mix. Hand mixing is not recommended and may result in unpredictable results.

1) Apply adhesive to clean, dry substrates, which are free of loose paint, oxide films, oils, dust, mold release agents and all other surface contaminants. See the Surface Preparation section for specific substrate preparation methods.

#### 45 ml Cartridge:

Place duo-pak cartridge in EPX applicator. Twist to remove cap. Dispense and discard a small amount of adhesive to assure even ratio and free flow. Clear orifice if necessary. Use only orange 10:1 mixing nozzle by: (a) aligning nozzle onto cartridge tip, and (b) twist the gray nut into place. Dispense and discard a small amount of adhesive through nozzle until the adhesive is mixed.

#### 490 ml Cartridge:

While holding duo-pak cartridge in an upright position, unscrew the plastic nut and remove and discard the cartridge plug. Place cartridge in a 10:1, 490 ml EPX applicator.

Clean orifice if clogged; dispense and discard a small amount of adhesive to even pistons. Attach 10:1 EPX mixing nozzle by:

(a) sliding the nozzle onto the cartridge orifice;

(b) screwing the plastic nut back onto the cartridge to secure the nozzle. Dispense and discard a small amount of adhesive until the mixed adhesive has a milky white appearance. If adhesive is clear, check the small orifice for debris or flow.

#### Meter-Mix Equipment:

Follow manufacturer's precautions, directions for use, and recommendations.

2) After the adhesive is applied, substrates must be mated within the worklife of the adhesive, 2-2.5 minutes or sooner for one-sided applications. Adhesive thickness less than .005" will yield unpredictable results. The joint design of the substrates should facilitate a .005" to .008" adhesive thickness at the bondline. Adhesive contains .008" micropheres for this purpose.

3) The bonded surfaces should be fixtured, or clamped, for at least 2 hours. The clamping pressure should be sufficient to keep the surfaces in contact during cure (typically 4-8 psi). Plastic parts can be designed to be self-fixturing, negating the need for external fixturing.

**Note:** Heating the bondline to 150-175°F (66-80°C) for 30 minutes will speed up curing. The parts should be dwelled for a minimum of 10 minutes at room temperature prior to heating to allow more adhesive penetration into the substrates before heat-accelerated cure.

4) Cured adhesive appearance: the adhesive will yellow with time; a rippling effect in the adhesive as it cures is normal and indicates that the adhesive is mixed properly and curing normally.

### Approximate Coverage – By Size of Container [Figures do not include nozzle waste]

Bead Size	Linear ft per 45 ml	Linear ft per 490 ml	Linear ft per mixed gallon
1/2"	2.4	26	196
3/8"	4.5	45	350
1/4"	10.5	102	785
1/8"	37.2	405	3,130
1/16"	147.7	1600	12,240

### Coverage in square feet – (.008" bond line) [Figures do not include nozzle waste]

Square ft per 45 ml	Square ft per 490 ml	Square ft per mixed gallon
2.5	49	200

## Surface Preparation

3M™ Scotch-Weld™ Structural Plastic Adhesive DP8005 can bond polypropylene, polyethylene and other thermoplastic polyolefins without special surface preparation. However, all substrates should be clean, dry and free of paint, oxide films, oils, dust, mold release agents and other surface contaminants. The amount of surface preparation directly depends on the bond strength and environmental resistance desired by the user.

The following cleaning methods are suggested for common surfaces.

### Steel and Aluminum

- 1) Wipe free of dust with oil-free solvent such as acetone or isopropyl alcohol.
- 2) Sandblast or abrade using clean fine grit abrasives (150 grit or finer).
- 3) Wipe again with solvent to remove loose particles.
- 4) If a primer is used, it should be applied within 4 hours after surface preparation (or see instructions pertinent to a specific primer).

**Note:**Aluminum may also be acid etched. Follow the manufacturer's precautions and directions for this procedure.

### Plastic/Rubber

- 1) Wipe with isopropyl alcohol.\*
- 2) Abrade using fine grit abrasives (150 grit or finer).
- 3) Remove residue by wiping again with isopropyl alcohol.\*
- 4) Allow solvent to evaporate before use.

### Thermoplastic Polyolefin (TPO)

- 1) Wipe with isopropyl alcohol.\*
- 2) Allow solvent to evaporate before use.

### Glass

- 1) Solvent wipe surface using acetone or isopropyl alcohol.\*
- 2) Allow solvent to evaporate before use.

**\*Note:**When using solvents, be sure to extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

## Storage and Shelf Life

Store product at 4°C (40°F) or below in the original, unopened packaging. For best performance, use this product within 18 months from date of manufacture.

## 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

## Automotive Disclaimer

### Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

## Information

**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).

## **ISO Statement**

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

3M™ Industrial Adhesives and Tapes Division  
3M Center, St. Paul, MN 55144-1000  
[3M.com/iatd](http://3M.com/iatd)

3M, Scotch-Weld and EPX are trademarks of 3M Company.  
©3M 2025 (2/25)