



## 3M™ Structural Adhesives

### 2K Epoxies for Body-in-White and Chassis Applications

#### Selection Guide

3M™ Structural Adhesives offer versatile solutions which are easily implemented into existing processes. By bonding effectively to a variety of different surfaces, they expand the range of body-in-white and chassis materials to help you meet – or exceed – impact resistance, lightweighting, bond strength and emission reduction goals. These adhesives can replace welding, riveting, nuts and bolts and other mechanical fasteners for reduced weight and streamlined processing, all while providing fast handling strength.

	SA9816AOV	SA9820	SA9844	SA9860
<b>Chemistry</b>	2K Epoxy	2K Epoxy	2K Epoxy	2K Epoxy
<b>Applications</b>	Hem Bonding	Primary Structure EV Battery Bonding	Primary Structure Chassis Injection Joining	Primary Structure Chassis EV Battery Bonding
<b>Impact Resistant</b>	----	High	High	High
<b>Compatible Substrates</b>	Aluminum and Galvanized Steel	Aluminum, Composite, and Magnesium	Aluminum and Composite	Aluminum and Composite
<b>Oil Compatibility</b>	Draw lube and dry lube compatible	Wet and dry lube compatible	No	No
<b>Curing Temperature</b>	Final cure at elevated temperature <sup>1</sup>	>115°C for high impact resistance <sup>1</sup>	Room temperature. For faster curing elevated temperatures (60°C - 80°C) can be used. <sup>2</sup>	Room temperature <sup>2</sup>
<b>Rheology</b>	Non-sag performance	Non-sag performance	Easy flowable for injection bonding purposes	Non-sag performance
<b>Induction Process</b>	Thermal induction required	Thermal induction optional based on application requirements	Spot curing induction optional	Thermal induction <u>not required</u>

<sup>1</sup> Does not require surface preparation

<sup>2</sup> Requires surface preparation

**Note:** The technical information and data provided above are for reference only and should not be used for specification purposes. It is the responsibility of the customer to evaluate feasibility for their specific application. Our experts are happy to help you determine the right structural adhesive solution for your specific needs, including automated applications.

### Contact Information

The information provided in this technical document is intended as a guide for this product. For more information or help in selecting a 3M product for an application, please contact your 3M application engineering representative or [connect with a 3M expert](#).

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