

Simple solutions to complex challenges.

3M™ Scotch-Weld™ One-Part Epoxy Adhesive 6000 Series

Getting electronics products to market quickly and efficiently is key to profitability, but design challenges can get in the way. One-part epoxies from 3M can help overcome complex geometries and meet your needs for chemical, water, and heat resistance.



One-part simplicity

with no mixing required.



Easy application

with low viscosity for gap filling and shear thinning for precision dispensing.



Liquid stability

with a work life of up to 4 weeks and 18-month shelf life when stored cold.



Easy curing

with low-temperature heat application.

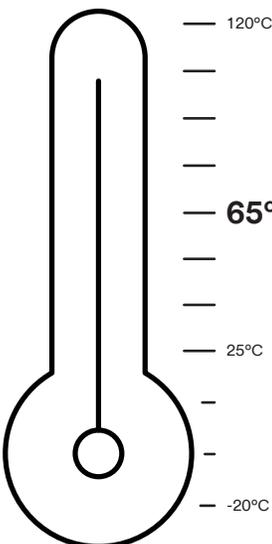


Durable bonds

with a variety of substrates.

Benefits of low-temperature cure.

3M™ Scotch-Weld™ One-Part Epoxy Adhesives 6000 Series cure at 65°C — unlike traditional one-part epoxies, which require ≥120°C to cure.



Bond and cure near heat-sensitive materials.

- Thin plastics
- Batteries
- Display materials
- Aesthetic surfaces



3M™ Scotch-Weld™ One-Part Epoxy Adhesive 6000 Series adhesives are flexible and toughened to **minimize cure stress**.

Simulated cure stress test: adhesive channel-cured on thin glass substrate



6000 Series

Minimizes stress on glass

Traditional 1K Epoxy

More stress on glass

3M™ Scotch-Weld™ One-Part Epoxy Adhesive 6000 Series properties

Multiple rheology options allow you to choose based on your product design and desired dispensing method.

6102 Black (Shear Thinning)

6104 Black (Flowable)



Product		6102 Black (*6101 Off-White)	6104 Black (*6104 White)	6011LV White (*6011 ULV White)	6100LV Black (*6100LV Off-White)
Viscosity 1Hz, 25C (Pa.s)		160	19	6	2
Cure Time		20 min./65°C 3 min./90°C	20 min./65°C	15 min./65°C 2.5 min./90°C	20 min./65°C 3 min./90°C
Overlap Shear Adhesion (MPa)	SUS	35	23	34	8
	Al	39	26	32	8
	PA	5	12	8	5
	PC/ABS	8	>11	9	10
	PC	5	8	8	6
	PBT	6	13	7	5
Strain at Break (%)		71	120	30	93
T _g (°C)		35	42	45	7
Modulus 1 Hz, 25°C (MPa)		2,000	1,100	3,000	26
Notched Izod (J/m)		97	140	25	197
Key Features		Impact resistance, adhesion	Very tough	Low viscosity, high shear strength	Low viscosity, low modulus

*Alternative products have properties like represented adhesive. See TDS for more test details.

Contact your 3M representative or visit [3M.com/electronics1k-epoxy](https://www.3m.com/electronics1k-epoxy) to learn more.



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