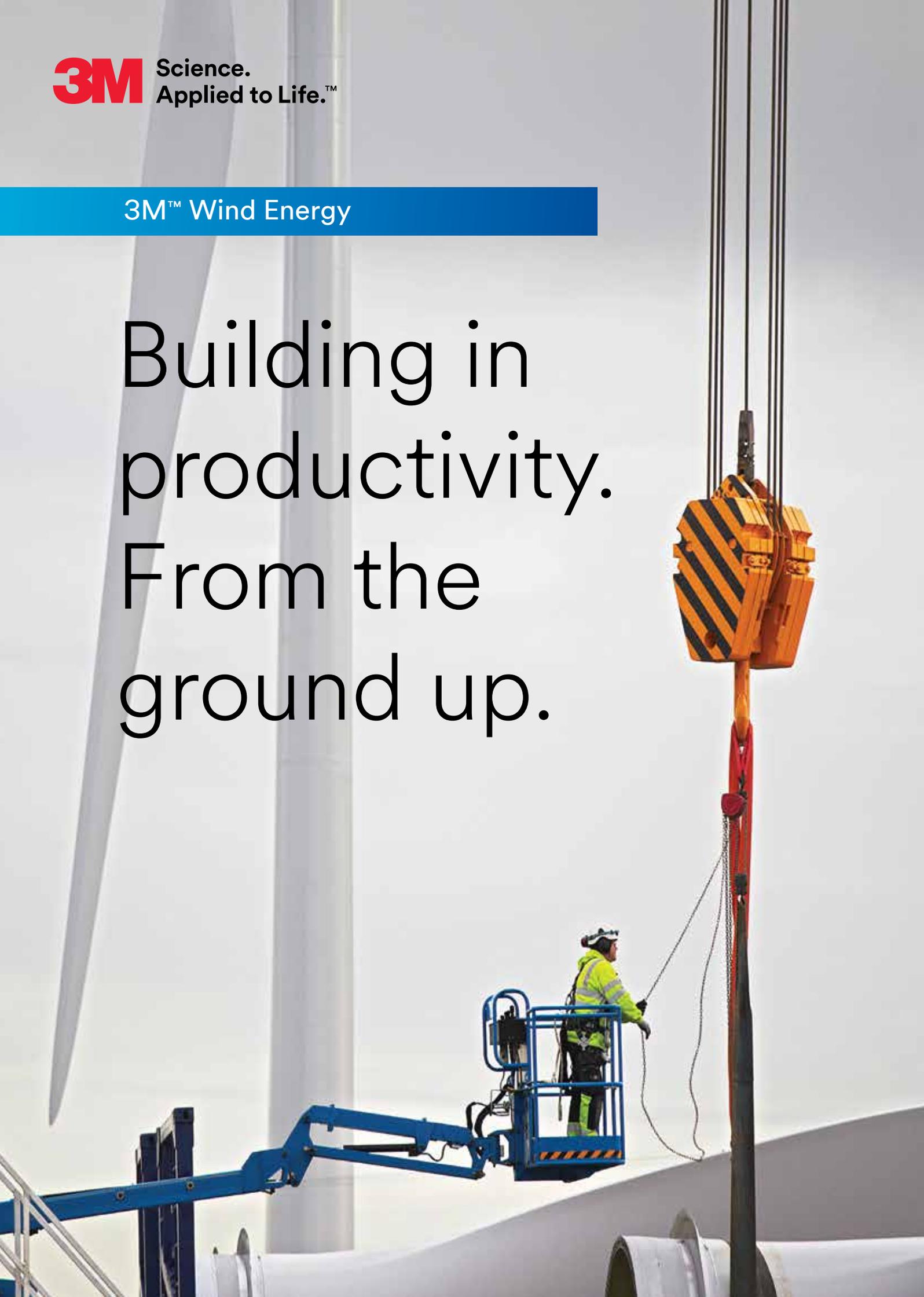


3M™ Wind Energy

Building in
productivity.
From the
ground up.





Energizing a more sustainable future.

Build. Protect. Enhance.
It all starts here.

Securing the place of wind as a viable energy source means making continual technological improvements to ensure more uptime. Improve reliability. Reduce costs. Increase efficiency. That's where 3M can help.

From design and manufacturing through day-to-day operations, 3M offers you a wide array of innovative technology solutions – all engineered to build more performance and profit into your system.

Collaborating for success.



Imagine if you could share knowledge and ideas with the top scientists and engineers in your industry. Then think how much easier it would be to overcome design problems. Find more efficient ways to boost performance. Enhance reliability. Provide protection against weathering and harsh environments. And more.

At 3M you'll find a team of experienced experts who are eager to help you develop new ways to take wind energy to the next level. Let our 100 years of technology, marketing and manufacturing experience help propel you into a sustainable and more profitable future.

▶ Operations & maintenance

- 3M™ Wind Protection Tapes
- 3M™ Wind Fillers
- 3M™ Acrylic Foam Tape
- 3M™ Clean Sanding System
- 3M™ Wind Blade Protection Coatings
- 3M™ Wind Vortex Generators

▶ Manufacturing & design

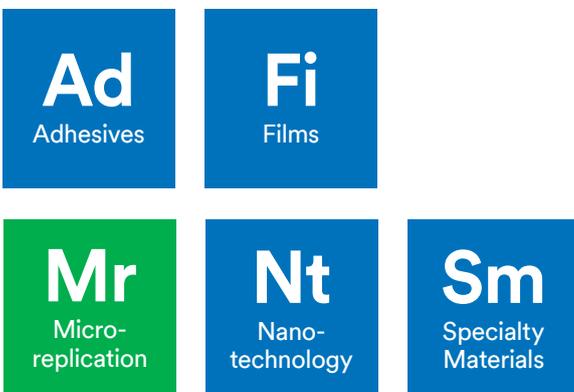
- 3M™ Wind Blade Protection Coatings
- 3M™ Wind Protection Tapes
- 3M™ Wind Blade Bonding Adhesive W1101
- 3M™ Wind Structural Adhesives
- 3M™ Wind Threadlockers
- 3M™ Dry Layup Adhesives
- 3M™ Wind Sealants
- 3M™ Acrylic Foam Tape
- 3M™ Diamond Cutoff Wheels
- 3M™ Wind Vortex Generators

▶ Installation

- 3M™ Cold Shrink Splices
- 3M™ Cold Shrink Terminations
- 3M™ and Scotch® Premium Electrical Tapes
- 3M™ Cable Grounding Kits
- 3M™ Wire Management and Marking Supplies
- Scotch® Detectable Buried Barricade Tapes
- 3M™ Locators and Markers

▶ Safety

- 3M™ Safety-Walk™ Materials
- 3M™ Filtering Facepiece Respirators
- 3M™ Half and Full Facepiece Respirators
- 3M™ Powered and Supplied Air Respirators
- 3M™ Hearing Protection
- 3M™ Eye Protection
- 3M™ Head and Face Protection
- 3M™ Peltor™ Communications
- 3M™ Fall Protection
- 3M™ Speedglas™ Auto-Darkening Filters and Helmets
- 3M™ Sorbents

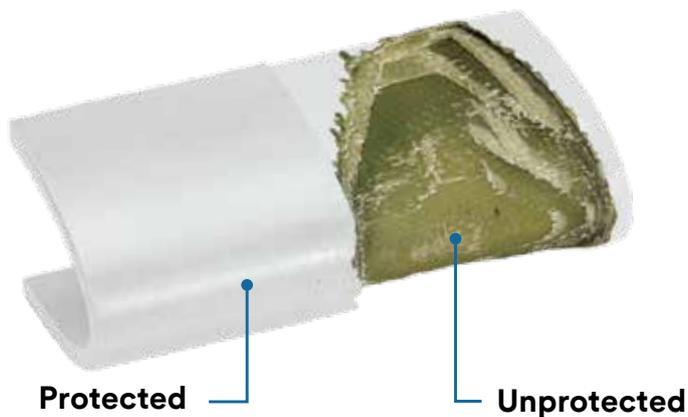


3M's technology portfolio is the foundation for thousands of unique and innovative products used in virtually every industry. In particular, 3M's expertise in adhesives, films, microreplication, nanotechnology and specialty materials is ideally suited to help you design and build the next generation of wind energy systems.

Extending equipment life.

Rotating up to 250 mph, wind blades are faced with erosion caused by rain, hail, salt spray and other debris. As a result, many blades can suffer pitting, gouging and delamination that can affect aerodynamic efficiency and even impact the integrity of the entire blade. Poor blade performance can also reduce annual energy production, and repair downtime is costly.

3M™ Wind Erosion Solutions offer an array of products to both repair and help prevent damage caused by minor impacts and erosion. These advanced 3M materials are designed to enhance reliability, improve performance and extend the life of your valuable equipment.



Sample tested in rainfall of one inch per hour at 500 mpg at the University of Dayton Research Institute Rain Erosion Test Facility.



3M™ Wind Blade Protection Coatings and Accessories

3M™ Wind Blade Protection Coating W4600 and W4601 are two-component polyurethane coatings. They each form a single durable layer designed to help protect the leading edges of wind blades from damage caused by sand and rain erosion, and minor impacts. Designed for easy brush or casting application.



Supplies

3M™ Wind Blade Protection Coating W4600
Part A & B, 250 mL Duo-Pack Cartridge, Part A, 18L Drum, Part B, 18L Drum

3M™ Wind Blade Protection Coating Brush

3M™ Wind Blade Protection Coating W4601
Part A & B, 385 mL Duo-Pack Cartridge, Part A, 18L Drum, Part B, 18L Drum

3M™ Wind Blade Protection Coating Manual Applicators – 250 mL – 1.5:1

3M™ Wind Blade Protection Coating Pneumatic Applicators – 250 mL – 1.5:1

3M™ Wind Blade Protection Coating Mixing Nozzles

3M™ Accessories: 3M™ Abrasives, 3M™ Random Orbital Sander, 3M™ Masking Tape

Other Supplies: Thickness gauge, dropcloth for floor, gloves, knife

3M™ Wind Protection Tapes

3M™ Wind Protection Tapes help shield leading edges and surfaces from pitting, wear and water ingress. Constructed from tough, abrasion-resistant polyurethane elastomers, 3M Wind Protection Tapes resist puncture, tearing, erosion and weathering. They are UV stable, solvent-free and conform to complex shapes to best protect your valuable equipment. They require no special application tools and are easily applied either in the factory or in the field via rope or platform access.

3M Wind Protection Tapes are based on the same dependable technology designed to protect helicopter blades and aircraft radomes for over 40 years. Applied to the leading edge of wind turbine blades, these high-performance polyurethane tapes have a proven ability to maintain turbine efficiency, reduce downtime and maintenance, and extend the useful life of blades – even in the harshest environments.

3M™ Wind Protection Tape Accessories

Technologies designed to ensure optimal results and improve production – while simplifying and speeding up installation and repair operations.



| Product Number | Color | Opacity | Thickness mils (mm) | Liner | Tensile Strength @ Break psi (MPa) | Elongation @ Break (%) |
|----------------|-----------|-------------|---------------------|-------|------------------------------------|------------------------|
| W8607 | Colorless | Transparent | 14 (0.36) | Poly | 5000 (35) | 500 |
| W8609 | Colorless | Transparent | 14 (0.36) | Poly | 5000 (35) | 500 |
| W8620 | White | Opaque | 14 (0.36) | Paper | 5000 (35) | 500 |
| W8640 | Gray | Opaque | 14 (0.36) | Poly | 5000 (35) | 500 |
| W8750 | Colorless | Translucent | 14 (0.36) | Poly | 2900 (20) | 600 |

Coming Summer 2016

3M™ Wind Protection Tapes are constructed from an exceptionally tough, abrasion and puncture-resistant polyurethane elastomer that stands up to sand, rain, hail and wind-borne debris.

| Product Number | Name | Size | Qty/Case | Additional Information |
|----------------|---|-------------------------------------|----------|--|
| W2600 | 3M™ Wind Protection Tape Edge Sealer W2600 | 1.7 oz. (50 mL) | 1 | A clear, non-yellowing, durable two-part urethane sealer system used to help smooth and protect the edges of 3M™ Wind Protection Tape. Provides excellent resistance to environmental exposure. |
| W9900 | 3M™ Wind Tape and Residue Remover (TARR) W9900 | 16 oz. (473 mL) | 6 | Removes 3M™ Wind Protection Tapes, tape residue and neoprene without damaging composite or metal surfaces. |
| | | 1 gal (3.785 L) | 4 | |
| W9910 | 3M™ Wind Tape Adhesion Promoter W9910 | 7 x 7 in. (17.8 x 17.8 cm) wipe | 5 | Designed to enhance initial adhesion of 3M™ Wind Protection Tapes in demanding situations. |
| | | 16 oz. (473 mL) | 12 | |
| 50004 | 3M™ Scotch-Weld™ EPX™ Plus II Applicator 50004 | 1.7 oz. (50 mL) | 10 | Handheld 50 mL applicator used to apply 3M™ Wind Protection Tape Edge Sealer W2600. Provides fast and easy manual dispensing. |
| 9176 | 3M™ Scotch-Weld™ EPX™ Square Gold Mixing Nozzle | 1.7 oz. (50 mL) | 72 | Mixing nozzle used with 50 mL 3M™ Scotch-Weld™ EPX™ Plus II Applicator 50004. |
| 23651 | Scotch-Brite™ High Performance Cleaning Cloth 23651, Yellow | 12.6 in. x 14.2 in. (32 cm x 36 cm) | 50 | Provides ultra cleaning power because of its knitted, interwoven design of water- and oil-absorbing microfibers that lift and trap liquids, grease, dust and dirt particles. |
| 471 | 3M™ Vinyl Tape 471, Red | 1 in. x 36 yd. (2.54 cm x 32.9 m) | 36 | Used for marking and guiding when applying 3M™ Wind Protection Tapes. Vinyl backing with rubber adhesive. Ideal for masking curved or irregular surfaces. |
| - | 3M™ Protective Tape Application Solution | 1 qt. (946 mL) | 1 | Pre-mixed, water-based application solution to accurately combine the materials in the preferred ratios for the desired cleaning, ease of application and performance of 3M™ Wind Protection Tape. |
| PA1 | 3M™ Hand Applicator PA1-B Blue | N/A | 25 | Reusable squeegee-type applicator – flexible and durable. |



3M™ Wind Epoxy and Polyurethane Fillers

3M offers a complete line of fillers, abrasives and accessories to repair minor damage on wind blade surfaces. 3M™ Wind Fillers are flexible, tough two-part epoxy or polyurethane fillers used to finish and smooth wind blade surfaces and leading edges during manufacture, and to repair minor damage on the wind blade surface quickly and reliably during maintenance operations. Multiple chemistries and performance times meet a variety of application needs, while innovative 3M™ Duo-Pak Cartridges and Applicators ensure accurate mixing, reduce waste and virtually eliminate messy and time-consuming hand mix operations. This allows for the flexibility to finish and repair blades at the manufacturing facility or during operations and maintenance repairs either on the ground or up tower.

| Product Number | Chemistry | Work Time | Sand Time | Color |
|----------------|--------------|-----------|-----------|-----------|
| W3120 | Epoxy | 10 min. | 30 min. | Blue |
| W3610 | Polyurethane | 8-10 min. | 30 min. | Dark Gray |

3M™ Wind Filler Accessories

| Product Number | Product Name | Size | Quantity/Case |
|----------------|---|----------------------------------|---------------|
| 08117 | MixPac® Manual Applicator Guns | 6.8 oz. (200 mL) | 1 |
| - | 3M™ Scotch-Weld™ EPX™ Pneumatic Applicator Guns | 6.8 oz. (200 mL) | 1 |
| - | 3M™ Scotch-Weld™ Square Gold Mixing Nozzles | 7 in. (177 mm) | 36 |
| 344 | Dynatron® Yellow Spreader | 3 in. × 4 in. (7.6 cm × 10.1 cm) | 144 |
| 354 | Dynatron® Yellow Spreader | 3 in. × 5 in. (7.6 cm × 12.7 cm) | 144 |
| 363 | Dynatron® Yellow Spreader | 3 in. × 6 in. (7.6 cm × 15.2 cm) | 36 |

3M™ Clean Sanding System

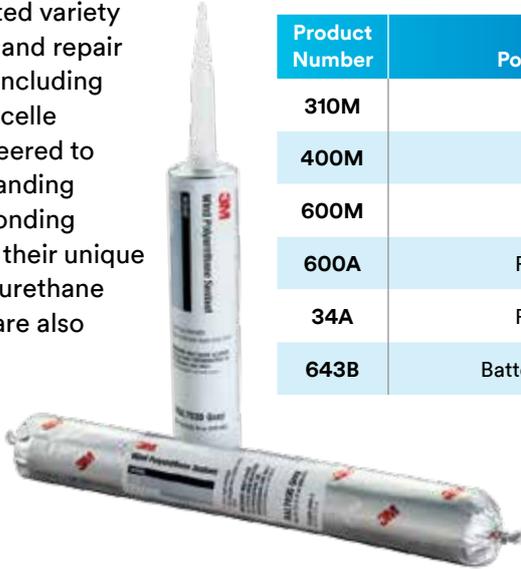
For dry-sanding composites, metal, coatings or almost any other substrate, almost nothing reduces dust more completely and efficiently than 3M™ Clean Sanding technology. Featuring a carefully-matched system of abrasives, random orbital tools, and accessories, these easy-to-use products work together to improve productivity – while delivering faster, more consistent finishing results.

The patented, precise multi-hole patterns of 3M Clean Sanding Discs and Sheets can evacuate dust better than 5 or 6-hole products – for improved faceside performance and dramatically longer disc life.



3M™ Wind Sealants and Accessories

3M offers a complete line of polyurethane and hybrid sealants. These products are ideal for sealing, component attachment, and an unlimited variety of fabrication and repair applications, including blades and nacelle covers. Engineered to provide outstanding sealing and bonding performance, their unique one-part polyurethane formulations are also easy to use.



| Product Number | Product Name | Skin Time | Rate of Cure per 24 hours | Shore A Hardness | Elongation @ Break (%) |
|----------------|--------------------------------|------------|---------------------------|------------------|------------------------|
| W2640 | 3M™ Polyurethane Sealant W2640 | 60 min. | 0.12 in. (3 mm) | 40 | >600% |
| W2660 | 3M™ Polyurethane Sealant W2660 | 50 min. | 0.16 in. (4 mm) | 55 | >600% |
| W2340 | 3M™ Hybrid Sealant W2340 | 40-60 min. | >0.12 in. (3 mm) | 30 | >300% |

| Product Number | Power Source | 10.5 oz. (310 mL) Cartridges | 20.3 oz. (600 mL) Sausage Packs |
|----------------|------------------|------------------------------|---------------------------------|
| 310M | Manual | ● | |
| 400M | Manual | ● | |
| 600M | Manual | ● | ● |
| 600A | Pneumatic | | ● |
| 34A | Pneumatic | ● | |
| 643B | Battery-Operated | ● | ● |

3M™ Acrylic Foam Tapes

3M™ Acrylic Foam Tapes can be used for a variety of surface bonding applications. The technology behind 3M Acrylic Foam Tapes has been used around the world since 1980 to replace liquid adhesives and mechanical fasteners in permanent bonding and sealing applications.



| Product Number | Thickness | | Density lb/ft³ (kg/m³) | Color |
|----------------|-----------|------|------------------------|-----------|
| | mil | mm | | |
| 4155 | 62 | 1.55 | 37 (592.7) | Black |
| 4110 | 45 | 1.10 | 37 (592.7) | |
| 4080 | 32 | 0.80 | 37 (592.7) | |
| 4063 | 25 | 0.63 | 37 (592.7) | |
| 2304 | 120 | 3.00 | 45 (720.8) | White |
| 2204 | 79 | 2.00 | 45 (720.8) | |
| 2155 | 62 | 1.55 | 52 (833) | Dark Gray |
| 2110 | 45 | 1.10 | 52 (833) | |
| 2063 | 25 | 0.63 | 52 (833) | |

3M™ Wind Vortex Generators

3M™ Wind Vortex Generators (VGs) are made of a highly durable thermoplastic with dimensional stability and strength which has a proven track record of superb weathering resistance. Our Vortex Generators are equipped with 3M™ Acrylic Foam Tape die-cuts that provide excellent long-term durability and holding power while treating the blade surface with care.



| Color | Plastic Type |
|-------|--|
| Gray | ABS-like Thermoplastic (Acrylester-Styrol-Acrylnitril) |

Enhancing productivity at every turn.

3M is a world leader in advanced adhesives, used by industries ranging from electronics and aerospace to woodworking and composites manufacturing. We offer thousands of structural and non-structural strength products in a wide range of formulations, cure times and dispensing systems.

For wind components manufacturing, 3M offers a line of innovative adhesive solutions – optimized to meet the unique needs of this dynamic industry for strength, durability, environmental resistance and efficiency.

3M™ Wind Structural Adhesives

A family of load-bearing, two-part epoxy or acrylic adhesives used for bonding composite wind blades, and for other general purpose applications. Adhesives cure at room temperature and are available in various formulations to provide the combination of bond strength, flexibility and other properties that meet your application needs.



3M™ Wind Blade Bonding Adhesive W1101

A tough, crack-resistant structural epoxy used for bonding composite wind blades. Enables faster throughput, resulting in more blades per mold.

W1101 is a two-part paste adhesive that combines outstanding shear and peel strength with excellent impact resistance and durability. It also provides faster cure speed, reduced exotherm and longer pot life than conventional epoxy wind blade adhesives, saving up to 6 hours in mold time per blade.

| Product Number | Color | Chemistry | Elasticity | Shear Strength psi (MPa) | Viscosity (cP) | Work Life | Set Time | Size* oz. (mL) | Quantity/ Case |
|----------------|-----------|-----------|------------|--------------------------|----------------|-----------|----------|----------------|----------------|
| W1115 | Off-White | Epoxy | Rigid | 3600-4000 (25-28) | 30,000 | 20 min. | 2.5 hr. | 1.7 (50) | 12 |
| | | | | | | | | 13.5 (400) | 6 |
| W1120 | Black | Epoxy | Rigid | 2200-3200 (15-22) | Non-Sag | 45 min. | 4 hr. | 1.7 (50) | 12 |
| | | | | | | | | 13.5 (400) | 6 |
| W1125 | Black | Epoxy | Rigid | 2500-3600 (17-25) | 600,000 | 1.5 hr. | 8 hr. | 1.7 (50) | 12 |
| | | | | | | | | 13.5 (400) | 6 |
| W1210 | Off-White | Acrylic | Rigid | 2600-3000 (18-21) | Non-Sag | 10 min. | 20 min. | 1.7 (50) | 12 |
| | | | | | | | | 13.5 (400) | 6 |

* Also available in bulk packaging.

3M™ Wind Structural Adhesives Accessories

| Product | Quantity/Case |
|--|---------------|
| 3M™ Scotch-Weld™ EPX™ Plus II Manual Applicator (small cartridges) | 10 |
| 3M™ Scotch-Weld™ EPX™ Pneumatic Applicator (large cartridges) | 1 |
| 3M™ Scotch-Weld™ EPX™ Square Gold Mixing Nozzle (small cartridges) | 72 |
| 3M™ Scotch-Weld™ EPX™ Square Gold Mixing Nozzle (large cartridges) | 36 |



3M™ Wind Structural Adhesives offer solutions for a wide range of applications. The Duo-Pak cartridge provides a controlled flow and is easy to use.

| | |
|--------------------------|-------------------|
| Product Number | W1101 |
| Color | Gray |
| Chemistry | Epoxy |
| Elasticity | Rigid |
| Shear Strength psi (MPa) | 3800-5600 (26-39) |
| Viscosity | Non-Sag |
| Pot Life (hr) | 2 |
| Size gal. (L) | 53 (200) |

Because of its high strength and durability, 3M™ Wind Blade Bonding Adhesive W1101 helps reduce labor costs for in-factory repairs. It also helps reduce turbine downtime by requiring fewer repairs on-site.



3M™ Wind Threadlockers provide excellent vibration, corrosion, and shock resistance. Threadlocker W1235 produces a bond that can be removed with hand tool.

3M™ Wind Threadlockers

One-component anaerobic adhesives that cure and seal threaded assemblies in a wide range of applications to prevent loosening and leakage.

| Product Number | Color | Strength | Viscosity (cP) | Set Time (min) | Size oz. (mL) | Property |
|----------------|-------|----------|----------------|----------------|---------------|--------------|
| W1235 | Blue | Medium | 3,000 | <20 | 8.5 (250) | Oil tolerant |

3M™ Dry Layup Adhesive

This sprayable, high tack and fast-drying adhesive is a synthetic elastomer-based formulation for bonding/holding glass fabrics and roving, other reinforcements and other materials (i.e. flow media) in place during the infusion process. Its particle spray pattern and color provide a visual check of spray level for more consistent application.

| Product Number | Color | Size | Application Method |
|----------------|-------|----------------------------|---|
| 09091 | Red | 16 oz. (473 mL) Aerosol | Aerosol Can |
| 09092 | Red | 5 Gallon (18.9 L) | 3M™ PPS™ Paint Preparation System with 3M Spray Gun |
| 09093 | Red | 55 Gallon (208 L) | 3M™ PPS™ Paint Preparation System with 3M Spray Gun |
| 09094 | Red | 30 lbs. (13.6 kg) Cylinder | 3M™ Scotch-Weld™ Cylinder Adhesive Applicator |
| W7900 | Green | 14.7 oz. (435 mL) Aerosol | Aerosol Can |
| | | 5 Gallon (18.9 L) | 3M™ PPS™ Paint Preparation System with 3M Spray Gun |



3M™ Dry Layup Adhesive is designed to reduce the amount of time required for dry layup of fiberglass. Ideal for robotic application. It also helps reduce wrinkles, which can be a major source of failures.

3M™ Dry Layup Adhesive Accessories

| Product | Qty/Case |
|--|----------|
| 3M™ PPS™ Paint Preparation System with 3M Spray Gun* | 1 |
| Pressure Pot System with 3M Spray Gun* | 1 |
| Bulk Pumping System with 3M Spray Gun* | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive Applicator | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 6 Foot Hose (1.8 m) | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 12 Foot Hose (3.6 m) | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 25 Foot Hose (7.6 m) | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 50 Foot Hose (15.2 m) | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 250050 Spray Tip | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 4001 Spray Tip | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 650050 Spray Tip | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 6501 Spray Tip | 1 |
| 3M™ Scotch-Weld™ Cylinder Adhesive 9501 Spray Tip | 1 |

3M™ Spray Gun Options

| Spray Gun | Air Cap | Fluid Nozzle in. (mm) | Inlet Air psi (kPa) |
|------------|------------|---------------------------|---------------------|
| Series 12S | 7 or 9 | 0.05 or 0.06 (1.3 or 1.5) | 25 (172) |
| Series 19C | 805 or 807 | 0.04 or 0.05 (1.1 or 1.5) | 25 (172) |

Building for safety and reliability.



Installation

The full line of 3M™ Locators and Markers helps you quickly and accurately identify underground assets. From finding the exact path and estimated depth of underground utilities, to locating buried passive markers, to reading and writing information directly to the new RFID markers, 3M offers the precision tools needed to manage your assets. And now, certain 3M™ Dynatel™ Locators interface with select GPS/GIS field mapping instruments.



3M™ Cold Shrink Splices and Terminations

Ensure easy installation, effective insulation and outstanding peace of mind. Dynamic, compressive seals have proven reliable for over 40 years of field use. Meets IEEE standards. Available for applications up to 69kW.

Safety

3M™ Personal Protection Equipment

Designed to improve worker safety and reduce lost time injuries, with a broad range of personal protection equipment engineered for comfort, convenience and functionality.

- ▶ 3M™ Filtering Facepiece Respirators
- ▶ 3M™ Half and Full Facepiece Respirators
- ▶ 3M™ Powered and Supplied Air Respirators
- ▶ 3M™ Hearing Protection
- ▶ 3M™ Eye Protection
- ▶ 3M™ Head and Face Protection
- ▶ 3M™ Peltor™ Communications
- ▶ 3M™ Fall Protection
- ▶ 3M™ Speedglas™ Auto-Darkening Filters and Helmets
- ▶ 3M™ Sorbents



3M™ Safety-Walk™ Slip-Resistant Materials

Protect against costly slips and falls while reducing worker fatigue. Treads, tapes, matting and a variety of pre-cut, easy-to-apply shapes also prevent ice, snow and mud buildup. Available in sizes, colors and grades for virtually any surface.



Connecting you to a world of 3M resources.

Your reliable supplier of technologies for wind energy

When you're being challenged to find new ways to make wind and other forms of sustainable energy more reliable and cost efficient, you need people on your side who have the industry experience and technical know-how to make that happen. With 3M, you have the advantage of an experienced, reliable partner, with the resources and expertise to help you develop applications, provide technical support and supply products almost anywhere in the world.

From tapes and adhesives used in blade manufacturing to electrical splices and terminations for connecting to the grid, 3M is ready to help you build the next generation of wind energy systems – with products designed to enhance reliability, improve performance and provide protection against weathering and harsh environments.

Working with a single, dedicated supplier like 3M gives you one contact for many solutions. And as a global company with operations in 70 countries, and laboratories in 36 countries, we have the ability to connect you with local 3M personnel to provide expert technical and business support almost anywhere in the world. Contact us today to see how 3M's renewable energy expertise can help you meet the challenges of today's marketplace.

3M Global Footprint



United States

800 755 2654

Germany

49 2131 144450

Denmark

45 43 480100

Spain

34 91 3216000

France

33 1 30316161

United Kingdom

44 1344 858000

Italy

39 02 70351

Singapore

65 6450 8888

China

86 21 62753535

South Korea

82 2 3771 4043

India

91 80 22231414

Canada

800 364 3577

Brazil

0800 13 23 33

Mexico

52 55 52702250

Taiwan

886 933 896752

Japan

81 3 3709 8283

Malaysia

603 78062888

Other Areas

800 755 2654

For more information on our wind energy product line, contact 3M Renewable Energy at 800 755 2654 or visit us at 3M.com/Wind

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