

# 3M™ Epoxy Bonding Adhesive EG-2P-3005

## Product Description

3M™ Epoxy Bonding Adhesive EG-2P-3005 is a fast setting, flexible 1:1 mix ratio epoxy adhesive/sealant. Its flexibility when cured makes it ideal for applications involving dissimilar surfaces where thermal coefficient of expansion may be a problem.

## Product Availability

3M™ Epoxy Bonding Adhesive EG-2P-3005 is offered in 50 mL and 400 mL Duo-Pak.

## Typical Uncured Properties

Table I describes the typical properties of uncured 3M™ Epoxy Bonding Adhesive EG-2P-3005 material.

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

**Table I.** Typical Uncured Properties of 3M™ Epoxy Bonding Adhesive EG-2P-3005.

Property		Units	Typical Value	Note
Appearance	Base (B) Accelerator (A)		Clear liquid Clear liquid	
Viscosity	Base (B) Accelerator (A)	cps cps	1,000 - 6,000 8,000 - 18,000	1
Mix Ratio (B:A)	By volume By weight		1:1 1:0.97	
Worklife		minutes	5	2

**Note 1:** Tested at 25°C on AR2000 viscometer with 2° 20mm diameter cone and plate.

**Note 2:** Approximated from evaluation of 2 g sample from EFD mixing nozzle.



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## Typical Cured Properties

Table II shows the typical properties of cured 3M™ Epoxy Bonding Adhesive EG-2P-3005 material.

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

**Table II.** Typical Cured Properties of 3M™ Epoxy Bonding Adhesive EG-2P-3005.

Property	Units	Typical Value	Note
Appearance		Clear	
Hardness	Shore D	60	3
Time to Handling Strength		20 min @ 23°C	
Cure Time		48 hrs @ 23°C	
Elongation	%	120	4
Tensile Strength	MPa	10	4
Tg by DSC	°C	12	3

**Note 3:** Sample was cured at RT for 24 hours.

**Note 4:** Sample was 2" dumbbell. Separation rate was 2"/min. Sample was cured at RT for 24 hours.

## Typical Adhesive Performance Characteristics

Table III shows the typical adhesive performance characteristics of 3M™ Epoxy Bonding Adhesive EG-2P-3005 material.

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

**Table III.** Typical Adhesive Characteristics of 3M™ Epoxy Bonding Adhesive EG-2P-3005.

Property	Units	Typical Value	Note
<b>Overlap Shear</b>			5
Etched Aluminum	psi	2500	
Cold Rolled Steel	psi	1800	
Polycarbonate	psi	250	
Polypropylene	psi	100	
ABS	psi	400	
PVC	psi	800	
Acrylic	psi	300	

**Note 5:** Sample was cured at RT for 24 hours. Bond was 1" x 0.5" x 3 mil. Separation rate was 0.1"/min for metals and 2"/min for plastics.

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## Storage and Shelf Life

**Storage:** Store 3M™ Epoxy Bonding Adhesive at 60-80°F (15-27°C) or refrigerate for maximum shelf life.

**Shelf Life:** 3M™ Epoxy Bonding Adhesive EG-2P-3005 has a shelf life of 15 months in original containers.

## Certification/Recognition

**MSDS:** 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 or (651) 737-6501.

**RoHS:** This product complies with the requirements of EU Directive 2002/95/EC and 2005/618/EC.

## For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-251-8634. Address correspondence to: 3M, Electronics Markets Materials Division, 3M Center, Building 225-3S-06, St. Paul, MN 55144-1000. Our fax number is 651-778-4244 or 1-877-369-2923. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

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