

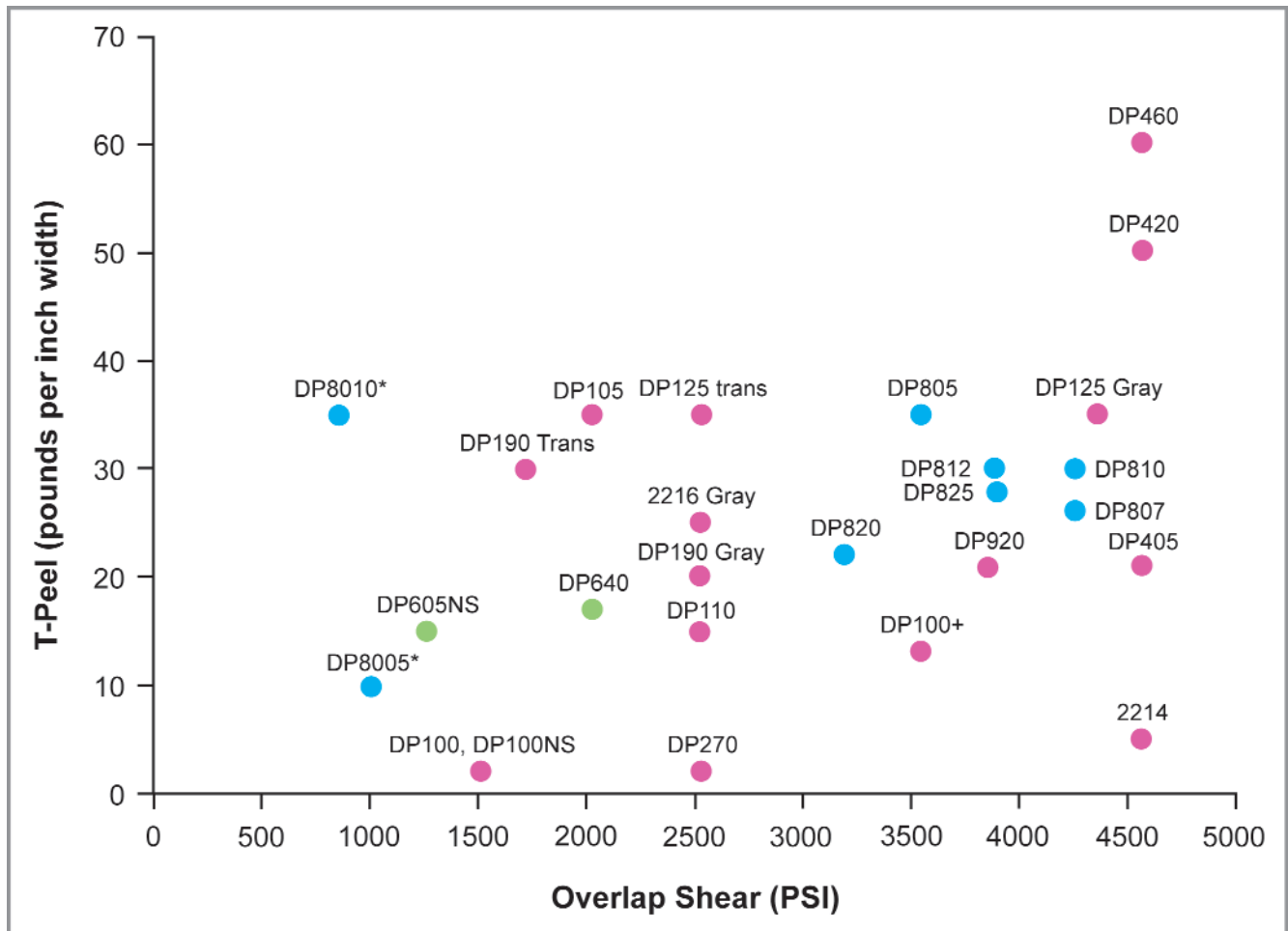


Performance Characteristics of Selected 3M™ Scotch-Weld™ Structural Adhesives

Technical Bulletin

April, 2011

Selecting the structural adhesive most suitable for a specific application requires consideration of a number of factors, including the substrates to be bonded, the environment to which the bonded assembly will be exposed, and the assembly process itself. Adhesive characteristics such as worklife, peel strength, overlap shear strength and flexibility are particularly important. The chart below compares the properties of selected 3M™ Scotch-Weld™ Duo-Pak Adhesives, and denotes the worklife, peel and shear strengths of each.



*(#) Worklife in minutes, defined as the time to gel for a 20 gram mass of adhesive.

- Epoxies
- Acrylics
- Urethanes

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Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/industrial



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