3IVI'™ Scotch		3M™ Scotch-Weld™ Structural Adhesives													
	The state of the s	110 mm	125 125	60	410	460	490	609	2000 patrones	And diversi	South and	The cost of	MA TOTAL  THE STATE OF THE STAT		
Product number	DP100 Plus	DP110	DP125	DP190	DP410	DP460	DP490	DP609	DP8005	DP8010	DP8405NS	DP8410NS	7240FR		
Properties/suitable for	Multi- purpose adhesive	General purpose flexible bonds	General purpose flexible bonds	High flexibility and elongation	Vibration and impact	Vibration and impact	Vibration and impact	Especially for plastics and wood	Bonds PP and PE	Bonds PP and PE	adhesion to	High-impact adhesion to most plastics	For thicker adhesive layers		
Key features (info box)															
Physical and Performand	ce Characte	eristics, Key	/ Features		1										
Product number	DP100 Plus	DP110	DP125	DP190	DP410	DP460	DP490	DP609	DP8005	DP8010	DP8405NS	DP8410NS	7240FR		
Base	Flexible Epoxy	Flexible Epoxy	Flexible Epoxy	Flexible Epoxy	Toughened Epoxy	Toughened Epoxy	Toughened Epoxy	Flexible Polyurethane	Low Sur- face Energie	Low Sur- face Energie	MMA Acrylic	MMA Acrylic	Toughened Epoxy		
Colour	Clear	Translucent,	Grey	Grey	Beige	Beige	Black	Beige	Acrylic Black, translucent	Acrylic Blue	Green	Green	Grey		
Approx. work life [min]	4	8	25	90	12	60	90	7	3	10	5	10	45		
Approx. time to handling strength	20	20	150	480 - 720	30	240 - 360	240 - 360	60	30	60	14 - 16	16 - 20	360		
[min]		Controlled	Controlled	Controlled		Controlled			Thixotropic						
Viscosity  Overlap shear	Fluid 24	flow	flow 24	flow	Low flow	flow 31	Thixotropic 31	Low flow	low 7	Thixotropic	Thixotropic 30	Thixotropic 25.6	Thixotropic 28		
strength [MPa] Surface energy	<b>24</b>	17	24	17.6	38	31	31	14		13.5	30	20.0	28		
High	++	++	++	++	++	++	++	++	++	++	++	++	++		
Medium	+	+	+	+	+	+	+	+	++	++	++	++	-		
Low	-	-	-	-	-	-	-	-	++	++	-	-	-		
Static and dynamic loads (vibration and impact)					•	•	•				•	•			
Bonding of elec- tronic components						•									
Bonding of materials with different dilatation (thermal expansion)															
Medium thermal expansion (e.g. plastic to plastic)		•													
Higher thermal expansion (e.g. metal to plastic)	•			•											
Bonding of polypropylene, polyethylene, TPE									•	•					
Flame retardant bonding													•		
Suggested Applications															
Product number	DP100 Plus	DP110	DP125	DP190	DP410	DP460	DP490	DP609	DP8005	DP8010	DP8405NS	DP8410NS	7240FR		
General attachment applications in a variety of industries	•	•	•												
Fast potting agent good for applications with thermal cycling	•														
Bond metal, ceramic, wood and many plastic		•	•												
Semi-flexible potting compound				•											
Transportation applications, such as rail and automotive					•	•	•								
Use when toughness and high strength are needed					•	•	•								
Bonding of electronic						•									
Aerospace applications							•								
Bond plastic, wood and painted or primed metal								•							
Bond low surface energy plastics such as polypropyl- ene, polyethylene and thermo- plastic elastomers (TPEs)									•	•					
Joining plastics to metals, such as in the manufacture or repair of appliances									•	•					
Impact resistance composite bonding									•	•					
Metalworking such as HVAC, appliance, and specialty vehicles											•	•			
Sign manufacturing such as panel to frame bonding, trim attachment, letter bonding, and frame assembly											•	•			
Bonding plastics, composites											•	•			
Typically used where fast															
assembly of smaller parts is required											•	•			

on trains

**Product number** 

Adhesive certified for use

DP100 Plus

**DP110** 

DP125

**DP190** 

**DP410** 

**DP460** 

**DP490** 

DP8005

**DP609** 

DP8010

**DP8405NS** 

**DP8410NS** 

7240FR