3M

Scotch-Weld™

EPX™ Acrylic Adhesive DP801

Product Data Sheet

Product Description			
	DP801 Adhesive is a room temperature curing, toughened acrylic adhesive supplied in 3M Duo-Pak cartridge for use with the 3M EPX Applicator. DP801 offers the following Features:	Very fast curing with a set time of 2-4 minutes at room temperature. Toughened acrylic adhesive giving high peel strength and excellent impact resistance.	1:1 premix system allowing gap filling. Low Odour. Particularly suitable for plastic bonding. Also bonds metals, wood, and GRP.

Physical Properties
Not for specification purposes

	BASE	ACCELERATOR
Base	Modified Acrylic	Modified Acrylic
Specific Gravity	1.04	1.04
Viscosity (cP at 20°C)	20,000 - 40,000	20,000 - 40,000
Colour	Pale Yellow	Green
Work Life	1 - 2 minutes at 23°C.	
Time to Handling Strength	2-4 minutes at 23°C	
Cure Time	75% ultimate strength in 20 minutes 90% ultimate strength in 1 hour 100% ultimate strength in 24 hours	
Shelf Life	6 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

Performance Characteristics
Not for specification purposes

T-Peel Strength	Measured on abraded, cold rolled steel at 23°C. 100 N/cm (57 piw)	
Service Temperature	-55°C to +80°C	Measured after application of DP801 through 7 element static mixer.

Performance Characteristics (Cont...) Not for specification purposes	**Overlap Shear Strength**	The following strengths were obtained with DP801 when tested at 23°C in accordance with ASTM D 1002-72.	

	MPa	psi
Cold Rolled Steel	10.0	1450
FPL Etched Aluminium	13.0	1885
Copper	11.0	1595
Stainless Steel	14.0	2030
Brass	14.0	2030
Acrylic:		
- Solvent Wiped	4.4*	640*
- Abraded	4.4*	640*
Rigid PVC		
- Solvent Wiped	4.1*	595*
- Abraded	4.1*	595*
Polycarbonate		
- Solvent Wiped	2.9	420
- Abraded	5.9*	855*
* Denotes Substrate Failure		

Storage Conditions	Store product at 16 to 27°C for maximum storage life. High temperatures reduce normal storage life.	Rotate stock on a "first in-first out" basis.

Directions for Use /Clean Up	Place Duo-Pak cartridge into retaining lip on applicator. Remove re-sealable cap. Attach mixing nozzle and dispense.	Remove mixing nozzle after use. WIPE TIP CLEAN AFTER USE AND REPLACE CAP.	**Clean Up:** Excess uncured adhesive can be removed with Scotch-Grip Solvent No. 2. **NOTE:** Solvent No. 2 is flammable and the proper safety precautions should be observed.

Date :   March 1996
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Health & Safety Information

Precautions:
Irritating to eyes, respiratory system and skin. May cause sensitisation by skin contact. Keep away from heat. Keep away from sources of ignition - No Smoking. Avoid contact with skin and eyes. Use only in well ventilated areas. **CAUTION:** Adhesive is prone to exotherm and is therefore not recommended for potting and encapsulating applications.

First Aid:

Eye Contact:
Rinse immediately with plenty of water and seek medical advice.

Skin Contact:
Wash immediately with plenty of soap and water.

For further Health and Safety Information please contact the Toxicology Department at the Bracknell Head Office on (0344) 858000.

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