



United States



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3M™ Scotch-Weld™ Epoxy Potting Compound DP270 Clear Duo-Pak, 200 mL, 12 per case



An electrical grade two-part epoxy for potting and bonding electronic components, and is electrolytically non-corrosive to copper. It has a 1:1 mix ratio and is a non-exotherming, high flow, clear product with a 70 minute worklife.

Product / 3M Id / UPC

3M™ Scotch-Weld™ Epoxy Potting Compound DP270 Clear Duo-Pak, 200 mL, 12 per case

3M Id : 62-3262-3830-0

GTIN(UPC/EAN) : 0 00 21200 87834 3

3M Scotch-Weld™ Epoxy Potting Compound/Adhesive DP270 Clear and Black

Technical Data

Product Description

3M™ Scotch-Weld™ Epoxy Potting Compound/Adhesive DP270 (or 3M™ Scotch-Weld™ Epoxy Potting Compound/Adhesive 270 B/A) is a two-part, low viscosity epoxy resin system designed primarily for potting, sealing, and encapsulation of many electronic components and is available in clear or black. Scotch-Weld epoxy potting compound/adhesive DP270 is noncorrosive to copper and offers good thermal shock resistance and excellent retention of electrical insulation properties under high humidity conditions.

Scotch-Weld epoxy potting compound/adhesive DP270 has a work life of approximately 70 minutes, a tack-free time of about 3 hours and is fully cured after 48 hours at 73°F (23°C). This product produces no exotherm in 5-10 gram masses and a very slight exotherm in larger masses.

Scotch-Weld epoxy potting compound/adhesive DP270 is ideal for the potting and encapsulation of many heat sensitive or delicate components such as glass diodes and sensors as well as for transformers, coils, chokes, relays, etc. It is available in the convenient 3M™ EPX™ Applicator System for multi-station usage and in bulk containers for larger volume applications.

Available in bulk containers as Scotch-Weld epoxy potting compound/adhesive 270 B/A.

Features

- Good Thermal Shock Resistance
- Meets UL 94 HB (File No. E61941)
- Long Worklife
- Excellent Electrical Properties
- Noncorrosive to Copper
- Negligible Exotherm

Typical Uncured Properties

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

Color:	Clear or Black
Base Resin:	Epoxy/amine
Mix Ratio:	1:1 by volume (1:0.85 B:A by weight)
Net Weight: Lbs./Gal.	Base 9.6 - 9.8 Accelerator 8.0 - 8.2
Worklife:	60-70 minutes @ 23°C (73°F)
Viscosity: @ 23°C (73°F)	Base 7000 - 16,000 cps Accelerator 6000 - 12,000 cps

Scotch-Weld™

Epoxy Potting Compound/Adhesive

DP270 Clear and Black

Typical Cured Properties

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

Physical:	
Color	Clear or Black
Refractive Index @ 25°C (77°C)	Clear 1.656
Cure Shrinkage	.08%
Shore D Hardness (ASTM D-2240)	83
Tack-free Time	Approx. 3 hrs. @ 23°C (73°F)
UL Rating	94 HB (File No. E61941)
Cure Time	48 hrs. @ 23°C (73°F)
Thermal:	
Weight Loss by TGA (in air)	1% @ 122°C (252°F) 5% @ 175°C (347°F) 10% @ 210°C (410°F)
Thermal Coefficient of Expansion by TMA	
Below Tg	80 x 10 ⁻⁶ units/unit/°C 5-30°C range (10-86°F range)
Above Tg	180 x 10 ⁻⁶ units/unit/°C 60-125°C range (140-257°F)
Glass Transition Temperature by DSC	
Onset	43°C (109°F)
Mid-Point	49°C (120°F)
Thermal Conductivity (@ 110°F on .250" samples)	
BTU - ft./ft. ² - hr. - °F	.103
Cal./sec. - cm - °C	.426 x 10 ³
Watt/m - °C	.177
Thermal Shock Resistance	
Potted Washer Olyphant Test	Pass 5 Cycles without cracking
3M Test Method C-3174	
+100°C (air) to -50°C (liquid)	
Electrical:	
Dielectric Constant (ASTM D-150)	3.5 @ 1 KHz @ 23°C (73°F)
Dissipation Factor (ASTM D-150)	.018 @ 1 KHz @ 23°C (73°F)
Dielectric Strength (ASTM D-149)	850 volts/mil
Volume Resistivity (ASTM D-257)	4.1 x 10 ¹⁴ ohm-cm
Insulation Resistance (.8 mm/.8 mm comb pattern on FR-4) 60°C/96% R.H./100 volts d.c.)	
Initial	3 x 10 ¹³ ohms
1000 hrs.	2 x 10 ¹¹ ohms

Scotch-Weld™

Epoxy Potting Compound/Adhesive

DP270 Clear and Black

Storage	Store product at 60-80°F (16-27°C) for maximum storage life.
Shelf Life	These products when stored in original, unopened container have a shelf life of two years for bulk containers and 15 months in duo-pak containers.
Precautionary Information	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.
For Additional Information	To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit www.3M.com/adhesives . Address correspondence to: 3M Industrial Adhesives and Tapes Division, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55144-1000. Our fax number is 651-778-4244. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.
Product Use	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.
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This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.



Industrial Business
Industrial Adhesives and Tapes Division



Recycled Paper
40% pre-consumer
10% post-consumer



Material Safety Data Sheet

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SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

PRODUCT NAME: 3M(TM) Scotch-Weld(TM) Epoxy Potting Compound/Adhesive DP-270, Clear (Part B)
MANUFACTURER: 3M
DIVISION: Industrial Adhesives and Tapes Division

Document Group: 11-2356-1

Product Use:

Specific Use: part B of 2 part adhesive
 Intended Use: Industrial use

SECTION 2: INGREDIENTS

<u>Ingredient</u>	<u>C.A.S. No.</u>	<u>% by Wt</u>
EPOXY RESIN	25068-38-6	93 - 97
HYDROCARBON RESIN	9003-53-6	3 - 7

SECTION 3: HAZARDS IDENTIFICATION

3.1 EMERGENCY OVERVIEW

Odor, Color, Grade: clear, very mild odor.

General Physical Form: Liquid

Immediate health, physical, and environmental hazards: May cause allergic skin reaction.

3.2 POTENTIAL HEALTH EFFECTS

Eye Contact:

Moderate Eye Irritation: Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

8.2 PERSONAL PROTECTIVE EQUIPMENT (PPE)

8.2.1 Eye/Face Protection

Avoid eye contact with vapors, mists, or spray.

The following eye protection(s) are recommended: Safety Glasses with side shields, Indirect Vented Goggles.

8.2.2 Skin Protection

Wear appropriate gloves, such as Nomex, when handling this material to prevent thermal burns. Avoid skin contact. Avoid skin contact with hot material.

Select and use gloves and/or protective clothing to prevent skin contact based on the results of an exposure assessment. Consult with your glove and/or protective clothing manufacturer for selection of appropriate compatible materials.

Gloves made from the following material(s) are recommended: Polyethylene/Ethylene Vinyl Alcohol.

8.2.3 Respiratory Protection

Avoid breathing of dust created by cutting, sanding, grinding or machining.

Select one of the following NIOSH approved respirators based on airborne concentration of contaminants and in accordance with OSHA regulations: Half mask R95 particulate respirator, Half mask or full facepiece air-purifying respirator with N100 particulate filters, Half facepiece or fullface air-purifying respirator with P100 particulate filters, Half facepiece or fullface air-purifying respirator with P95 particulate filters, Half facepiece or fullface air-purifying respirator with N95 particulate filters. Consult the current 3M Respiratory Selection Guide for additional information or call 1-800-243-4630 for 3M technical assistance.

8.2.4 Prevention of Swallowing

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water.

8.3 EXPOSURE GUIDELINES

None Established

SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

Odor, Color, Grade:	clear, very mild odor.
General Physical Form:	Liquid
Autoignition temperature	<i>No Data Available</i>
Flash Point	>=300 °F [<i>Test Method:</i> Closed Cup]
Flammable Limits - LEL	<i>No Data Available</i>
Flammable Limits - UEL	<i>No Data Available</i>
Boiling point	>=300 °F
Vapor Density	<i>Not Applicable</i>
Vapor Pressure	<=650 mmHg [@ 131 °F]
Specific Gravity	1.15 [<i>Ref Std:</i> WATER=1]
pH	<i>Not Applicable</i>
Melting point	<i>No Data Available</i>
Solubility in Water	Nil
Evaporation rate	<i>Not Applicable</i>
Volatile Organic Compounds	0.5 - 1.5 g/l
Percent volatile	<i>Not Applicable</i>
VOC Less H2O & Exempt Solvents	0.5 - 1.5 g/l

Viscosity

13000.0 - 16000.0 centipoise [Details: CONDITIONS: (@ Room Temperature)]

SECTION 10: STABILITY AND REACTIVITY

Stability: Stable.

Materials and Conditions to Avoid: Strong acids; Strong oxidizing agents; Heat is generated during cure. Do not cure a mass larger than 50 grams in a confined space to prevent a premature reaction (exotherm) with production of intense heat and smoke.

Hazardous Polymerization: Hazardous polymerization will not occur.

Hazardous Decomposition or By-Products

Substance

Aldehydes
Hydrocarbons
Carbon monoxide
Carbon dioxide
Ketones
Toxic Vapor, Gas, Particulate

Condition

During Combustion
During Combustion
During Combustion
During Combustion
During Combustion
During Combustion

SECTION 11: TOXICOLOGICAL INFORMATION

Please contact the address listed on the first page of the MSDS for Toxicological Information on this material and/or its components.

SECTION 12: ECOLOGICAL INFORMATION

ECOTOXICOLOGICAL INFORMATION

Not determined.

CHEMICAL FATE INFORMATION

Not determined.

SECTION 13: DISPOSAL CONSIDERATIONS

Waste Disposal Method: Dispose of completely cured (or polymerized) wastes in a sanitary landfill. As a disposal alternative, incinerate uncured product in an industrial or commercial incinerator in the presence of a combustible material.

EPA Hazardous Waste Number (RCRA): Not regulated