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[Adhesives](#) [Scotch-Weld™ Epoxy Adhesives](#)

3M™ Scotch-Weld™ Epoxy Adhesive DP110 Gray Duo-Pak, 200 mL, 12 per case



Gray, fast setting, flexible, two-part adhesive with a 1:1 mix ratio for bonding many materials, such as metals, ceramics and many plastics. 9 minute worklife with handling strength in 20 minutes.

GTIN(UPC/EAN) : 0 00 21200 87274 7
3M Id : 62-3533-3830-4

Additional Information

Unlike many other fast cure two-part epoxies, this adhesive has excellent peel strength and shock and impact resistance. NOTE: Make-To-Order with a lead time of 30-45 days.

Characteristics

Color	Gray
Product Form	Each
Trademark Name 1	3M
Trademark Name 2	Scotch-Weld

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3M™ Scotch-Weld™ Epoxy Adhesive DP110 Gray Duo-Pak, 200 mL, 12 per case Packaging

3M Id: 62-3533-3830-4

Minimum Order Quantity: 12.0 EACH

Case Quantity: 12.0 EACH

	English	Metric
Length	10.3 INCH	0.262 MTR
Width	6.8 INCH	0.173 MTR
Height	8.5 INCH	0.216 MTR
Gross Weight	9.1350 LBS	4.1436 KG

3M

Scotch-Weld™

Epoxy Adhesive

DP110 Translucent and Gray

Technical Data

Product Description 3M™ Scotch-Weld™ Epoxy Adhesive DP110 Translucent and Gray are two-part epoxy adhesives which combine a fast cure with flexibility.

- Features**
- Controlled flow
 - 20 minute handling strength
 - Duo-Pak cartridge dispensing system
 - Good adhesion to many plastics and metals

Typical Uncured Physical Properties

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

Product		Scotch-Weld Epoxy Adhesive DP110 Translucent	Scotch-Weld Epoxy Adhesive DP110 Gray
Viscosity @ 72°F (23°C), 73°F (24°C) (CPS)	Base Accelerator	30,000 - 70,000 30,000 - 70,000	40,000 - 90,000 40,000 - 90,000
Base Resin	Base Accelerator	Modified Epoxy Amine	Modified Epoxy Amine
Color	Base Accelerator	Translucent White Light Yellow	White Black
Net Weight (Lbs./Gallon)	Base Accelerator	9.1 - 9.4 9.0 - 9.3	9.1 - 9.4 9.0 - 9.3
Mix Ratio B : A	Volume Weight	100 : 100 100 : 99	100 : 100 100 : 99
Worklife @ 73°F (24°C) (minutes)		8 - 13	8 - 13

Typical Cured Physical Properties

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

Product	Scotch-Weld Epoxy Adhesive DP110 Translucent	Scotch-Weld Epoxy Adhesive DP110 Gray
Color	Yellow Translucent	Gray
Shore D Hardness (approx.)	40	45
Elongation (approx.)	40%	40%

Scotch-Weld™

Epoxy Adhesives

DP110 Translucent and Gray

Typical Cured Thermal Properties

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

Product	3M™ Scotch-Weld™ Epoxy Adhesive DP110 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP110 Gray
Thermal Conductivity BTU/Hr/Ft ² /°F/Ft.	.106 @ 113°F (45°C)	.104 @ 113°F (45°C)
Thermal Coefficient of Expansion -58°F (-50°C) - 32°F (0°C) -58°F (-50°C) - 166°F (110°C)	80 x 10 ⁻⁶ 200 x 10 ⁻⁶	73 x 10 ⁻⁶ 165 x 10 ⁻⁶
Glass Transition Temp.	55°F (13°C)	61°F (16°C)

Typical Cured Electrical Properties

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

Product	Scotch-Weld Epoxy Adhesive DP110 Translucent	Scotch-Weld Epoxy Adhesive DP110 Gray
Dielectric Strength (volts/mil)	520	470
Volume Resistivity (ohms - cm)	4.5 x 10 ¹⁰	6.9 x 10 ¹⁰

Typical Adhesive Performance Characteristics

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

The following product performance data was obtained in the 3M laboratory under the conditions specified. The following data show typical results obtained with Scotch-Weld epoxy adhesive DP110 Translucent and Gray when applied to properly prepared substrates and cured for 48 hours at 73°F (23°C) under 2 psi pressure and tested according to the specifications indicated.

Note: All data developed after a 48 hour cure @ 75°F (24°C) under 2 psi pressure unless noted otherwise.

A. Aluminum Overlap Shear

Overlap shear strength was measured on FPL etched 1 in. wide by 1/2 in. overlap specimens. The bonds were made from 2 panels of 4 in. x 7 in. x .063 in., 2024 T3 clad aluminum bonded together and cut into 1 in. wide specimens. The separation rate of the testing jaws was .1 in./minute. Tests similar to ASTM D-1002.

Test Temp	Scotch-Weld Epoxy Adhesive DP110 Translucent	Scotch-Weld Epoxy Adhesive DP110 Gray
-67°F (-55°C)	2500 psi	2700 psi
75°F (24°C)	2500 psi	3500 psi
160°F (71°C)	270 psi	270 psi
180°F (82°C)	200 psi	250 psi

Scotch-Weld™

Epoxy Adhesives

DP110 Translucent and Gray

Storage	Store products at 60-80°F (16-27°C) for maximum storage life.
Shelf Life	3M™ Scotch-Weld™ Epoxy Adhesive DP110 Translucent and Gray have a shelf life of 15 months in their unopened containers. Duo-pak cartridges have a shelf life of two years in their unopened bulk 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.
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ISO 9001

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



Material Safety Data Sheet

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SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

PRODUCT NAME: 3M(TM) Scotch-Weld(TM) Epoxy Adhesive DP-110, Gray (Part B) or 3M(TM) Scotch-Weld(TM) Epoxy Adhesive 110 B/A, Gray (Part B)
MANUFACTURER: 3M
DIVISION: Industrial Adhesives and Tapes Division

Document Group: 11-3320-6

Product Use:

Specific Use: Base of 2-Part Epoxy 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	60 - 100
Methacrylate/Butadiene/Styrene Polymer	25053-09-2	10 - 30
Hydrogenated Terphenyl	61788-32-7	5 - 10
Hydrogenated Polyphenyls	68956-74-1	< 1.5

SECTION 3: HAZARDS IDENTIFICATION

3.1 EMERGENCY OVERVIEW

Specific Physical Form: Paste

Odor, Color, Grade: White, very slight odor.

General Physical Form: Liquid

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

3.2 POTENTIAL HEALTH EFFECTS

SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

8.1 ENGINEERING CONTROLS

Provide appropriate local exhaust for cutting, grinding, sanding or machining. Use general dilution ventilation and/or local exhaust ventilation to control airborne exposures to below Occupational Exposure Limits and/or control dust, fume, or airborne particles. If ventilation is not adequate, use respiratory protection equipment.

8.2 PERSONAL PROTECTIVE EQUIPMENT (PPE)

8.2.1 Eye/Face Protection

Avoid eye contact.

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

8.2.2 Skin Protection

Avoid skin contact.

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: Neoprene, Nitrile Rubber.

8.2.3 Respiratory Protection

Avoid breathing of vapors. 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 facepiece or fullface air-purifying respirator with organic vapor cartridges and P95 particulate prefilters, Half facepiece or fullface air-purifying respirator with organic vapor cartridges and N95 particulate prefilters, Half facepiece or fullface air-purifying respirator with organic vapor cartridges and P100 particulate prefilters. 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

<u>Ingredient</u>	<u>Authority</u>	<u>Type</u>	<u>Limit</u>	<u>Additional Information</u>
Hydrogenated Terphenyl	ACGIH	TWA	0.5 ppm	
Hydrogenated Terphenyl	OSHA	TWA	0.5 ppm	Table Z-1A

SOURCE OF EXPOSURE LIMIT DATA:

ACGIH: American Conference of Governmental Industrial Hygienists

CMRG: Chemical Manufacturer Recommended Guideline

OSHA: Occupational Safety and Health Administration

AIHA: American Industrial Hygiene Association Workplace Environmental Exposure Level (WEEL)

SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

Specific Physical Form:	Paste
Odor, Color, Grade:	White, very slight odor.
General Physical Form:	Liquid
Autoignition temperature	<i>No Data Available</i>

Flash Point	>=480 °F [Test Method: Closed Cup]
Flammable Limits - LEL	Not Applicable
Flammable Limits - UEL	Not Applicable
Boiling point	>=260 °C
Density	1.14 g/ml
Vapor Density	Not Applicable
Vapor Pressure	Not Applicable
Specific Gravity	1.14 [Ref Std: WATER=1]
pH	Not Applicable
Melting point	Not Applicable
Solubility in Water	Nil
Evaporation rate	Not Applicable
Hazardous Air Pollutants	0 % weight
Volatile Organic Compounds	Not Applicable
Percent volatile	0.0 % weight
VOC Less H2O & Exempt Solvents	Not Applicable
Viscosity	45000 - 65000 centipoise [@ 73.4 °F]

SECTION 10: STABILITY AND REACTIVITY

Stability: Stable.

Materials and Conditions to Avoid: Strong oxidizing agents

Hazardous Polymerization: Hazardous polymerization will not occur.

Hazardous Decomposition or By-Products

<u>Substance</u>	<u>Condition</u>
Aldehydes	During Combustion
Carbon monoxide	During Combustion
Carbon dioxide	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.