

# Technical Data Sheet

## 3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP8810NS Green

### Product Description

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives are high performance, two-part acrylic adhesives that offer excellent shear, peel, and impact performance. These toughened products provide improved adhesion to many plastics and metals, including those with slightly oily surfaces. These durable products feature a fast rate of strength build, providing structural strength in minutes. Their low odor and non-flammability features also make them easier to incorporate into a manufacturing process.

Review UL File QQQW2. MH17478 and Sign Components Manual (SAM) File E464624 for certification of these adhesive systems in electrical equipment.

DP8810NS Green has been tested for surface flammability, smoke, toxic gas generation, and caloric content per ASTM E162, ASTM E662, ASTM E1354, Bombardier SMP 800-C, and Boeing BSS 7239 test methods. DP8805NS Green and DP8825NS Green should yield similar results.

### Product Features




- Toughened
- Excellent shear strength
- High peel and impact strength
- 10:1 mix ratio control bond line thickness
- Variety of open times available
- Increased cure speed with applied heat
- Contain glass beads (0.010" diameter) to control bond line thickness

Note: Unless otherwise indicated, all properties measured at 72°F (22°C).


### Technical Information Note


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

### Typical Mixed Physical Properties



| Property  | Values       | Additional Information   |
|---|--------------|--|
| Open Time   | 10 min       | <a href="#">View</a>  |
| Notes: POR=Pop Off Rubber   |              |  |
| Time to Structural Strength   | 19 to 23 min | <a href="#">View</a>  |
| Notes: Minimum time required to achieve 1,000 psi of overlap shear strength. Cure times are approximate and depend on adhesive temperature. |              |  |
| Viscosity   | 45000 cP     |  |
| Density (mixed)   | 1.06 g/cm³   |  |
| Worklife  | 8 to 12 min  | <a href="#">View</a>  |

Notes: Maximum time that adhesive can remain in a static mixing nozzle and still be expelled without undue force on the applicator. Cure times are approximate and depend on adhesive temperature.





|  |              |  |
|--|--------------|--|
| Set Time (min)   | 16 to 20 min | <a href="#">View</a>  |
| Temp C: 23C<br>Temp F: 73F   |              |  |
| Notes: Minimum time required to achieve 50 psi of overlap shear strength. Cure times are approximate and depend on adhesive temperature. |              |  |

|                            |       |  |
|----------------------------|-------|--|
| Time to Full Cure          | 24 hr | <a href="#">View</a>  |
| Temp C: 23C<br>Temp F: 73F |       |  |

### Typical Physical Properties

| Property         | Values     | Additional Information   |
|------------------|------------|--|
| Color            | Blue-Green | <a href="#">View</a>  |
| Test Name: Mixed |            |  |
| Color            | Blue-Green | <a href="#">View</a>  |
| Test Name: Cured |            |  |

### Typical Uncured Physical Properties

| Property   | Values                 | Additional Information   |
|--|------------------------|--|
| Base Color   | Off-White              |  |
| Accelerator Color  | Blue                   |  |
| Base Density   | 1.06 g/cm <sup>3</sup> | <a href="#">View</a>  |
| Notes: Density measured using pycnometer.  |                        |  |
| Accelerator Density  | 1.08 g/cm <sup>3</sup> | <a href="#">View</a>  |
| Notes: Density measured using pycnometer.  |                        |  |
| Base Viscosity   | 45000 cP               | <a href="#">View</a>  |
| Notes: Viscosity measured using cone-and-plate viscometer; reported viscosity at 3.8 sec <sup>-1</sup> shear rate. |                        |  |
| Accelerator Viscosity  | 15000 cP               | <a href="#">View</a>  |
| Notes: Viscosity measured using cone-and-plate viscometer; reported viscosity at 3.8 sec <sup>-1</sup> shear rate. |                        |  |

Mix Ratio by Volume (B:A) 10:1


Mix Ratio by Weight (B:A) 10:1

## Typical Performance Characteristics

### Additional Test notes

Note: Environmental aging tests have shown that these adhesives may accelerate the corrosion of certain bare metals (such as cold rolled steel, copper, brass, and bronze), leading to low bond strength values and early bond failure. These adhesives also have relatively low adhesion to low surface energy plastics (such as polypropylene, polyethylene, TPO, and PTFE). Applications involving any of these materials should be carefully evaluated by the end user for suitability.


Note: The presence of oxygen inhibits the cure of acrylic structural adhesives. Therefore, any exposed surfaces of the mixed adhesive will cure much more slowly than adhesive contained within the bond line. With methyl methacrylate (MMA) acrylic adhesives, any uncured adhesive on the surface flashes off immediately, leaving a surface that feels dry to the touch. With these low odor acrylic adhesives, uncured adhesive on exposed surfaces does not evaporate away quickly, leaving a wet film of partially cured material. For manufacturing processes that need a dry surface quickly, such as for subsequent sanding or painting operations, consider instead the standard acrylic adhesives (DP8405NS Green, DP8410NS Green, DP8425NS Green, and Metal Bonder DP8407NS Green).

| Property                                     | Values | Additional Information   |
|--|--------|--|
| Environmental Resistance 49C 100%RH Aluminum | 35 %   | <a href="#">View</a>  |

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 49C  
Temp F: 120F  
Environmental Condition: 100%RH  
Substrate: Aluminum


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

|  |      |  |
|--|------|--|
| Environmental Resistance 32C 100%RH Aluminum | 55 % | <a href="#">View</a>  |
|--|------|--|

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 32C  
Temp F: 90F  
Environmental Condition: 100%RH  
Substrate: Aluminum

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids


|   |      |  |
|---|------|--|
| Environmental Resistance 66C 80%RH Aluminum | 70 % | <a href="#">View</a>  |
|---|------|--|

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 66C  
Temp F: 150F  
Environmental Condition: 80%RH


Substrate: Aluminum

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance -40°C (-40°F) Aluminum 95 % [View](#) 

Test Name: Overlap Shear Strength


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 149C Aluminum 100 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 149C  
Temp F: 300F  
Substrate: Aluminum


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 49C 80%RH Aluminum 65 % [View](#) 

Test Method: ASTM D1002


Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 49C  
Temp F: 120F  
Environmental Condition: 80%RH  
Substrate: Aluminum

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 85°C (185°F) 85%RH Aluminum 50 % [View](#) 

Test Name: Overlap Shear Strength


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 100%RH Aluminum 75 % [View](#) 

Test Method: ASTM D1002






Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 23C  
Temp F: 72F  
Environmental Condition: 100%RH  
Substrate: Aluminum

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 23°C (72°F) Salt water (5 wt% in water) Aluminum 75 % [View](#) 


Test Name: Overlap Shear Strength

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

|   |      |  |
|---|------|--|
| Environmental Resistance Diesel Fuel Aluminum   | 90 % | View    |
| <p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength<br/>Dwell/Cure Time: 1000.0<br/>Dwell Time Units: hr<br/>Temp C: 23C<br/>Temp F: 72F<br/>Environmental Condition: Diesel Fuel<br/>Substrate: Aluminum</p> <p>Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp &gt;100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids</p>                  |      |  |
| Environmental Resistance Motor Oil Aluminum   | 95 % | View    |
| <p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength<br/>Dwell/Cure Time: 1000.0<br/>Dwell Time Units: hr<br/>Temp C: 23C<br/>Temp F: 72F<br/>Environmental Condition: Oil 10W30<br/>Substrate: Aluminum</p> <p>Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp &gt;100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids</p>                    |      |  |
| Environmental Resistance Antifreeze (50 wt% in water) Aluminum  | 90 % | View  |
| <p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength<br/>Dwell/Cure Time: 1000.0<br/>Dwell Time Units: hr<br/>Temp C: 23C<br/>Temp F: 72F<br/>Environmental Condition: Antifreeze (50 wt% in water)<br/>Substrate: Aluminum</p> <p>Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp &gt;100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids</p> |      |  |
| Environmental Resistance Isopropyl Alcohol (IPA) Aluminum   | 50 % | View  |
| <p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength<br/>Dwell/Cure Time: 1000.0<br/>Dwell Time Units: hr<br/>Temp C: 23C<br/>Temp F: 72F<br/>Environmental Condition: Isopropyl Alcohol (IPA)<br/>Substrate: Aluminum</p> <p>Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp &gt;100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids</p>      |      |  |
| Environmental Resistance Bleach (10 wt% in water) Aluminum  | 65 % | View  |
| <p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength<br/>Dwell/Cure Time: 1000.0<br/>Dwell Time Units: hr</p>  |      |  |

Temp C: 23C  
Temp F: 72F  
Environmental Condition: Bleach (10 wt% in water)  
Substrate: Aluminum


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance -40C Polyvinyl chloride (PVC) 100 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: -40C  
Temp F: -40F  
Substrate: Polyvinyl chloride (PVC)


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 49C Polyvinyl chloride (PVC) 95 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 49C  
Temp F: 120F  
Substrate: Polyvinyl chloride (PVC)


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 66C Polyvinyl chloride (PVC) 100 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 66C  
Temp F: 150F  
Substrate: Polyvinyl chloride (PVC)


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 100%RH Polyvinyl chloride (PVC) 100 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1000.0  
Dwell Time Units: hr  
Temp C: 23C  
Temp F: 72F  
Environmental Condition: 100%RH  
Substrate: Polyvinyl chloride (PVC)

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids


Environmental Resistance Salt water (5 wt% in water) Polyvinyl chloride (PVC) 100 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength

Dwell/Cure Time: 1000.0  
 Dwell Time Units: hr  
 Temp C: 23C  
 Temp F: 72F  
 Environmental Condition: Salt water (5 wt% in water)  
 Substrate: Polyvinyl chloride (PVC)


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance Hydrochloric acid (16 wt% in water) Polyvinyl chloride (PVC) 95 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
 Dwell/Cure Time: 1000.0  
 Dwell Time Units: hr  
 Temp C: 23C  
 Temp F: 72F  
 Environmental Condition: Hydrochloric acid (16 wt% in water)  
 Substrate: Polyvinyl chloride (PVC)


Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance Sodium hydroxide (10 wt% in water) Polyvinyl chloride (PVC) 95 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
 Dwell/Cure Time: 1000.0  
 Dwell Time Units: hr  
 Temp C: 23C  
 Temp F: 72F  
 Environmental Condition: Sodium hydroxide (10 wt% in water)  
 Substrate: Polyvinyl chloride (PVC)

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Environmental Resistance 85C 85%RH Polyvinyl chloride (PVC) 100 % [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
 Dwell/Cure Time: 1000.0  
 Dwell Time Units: hr  
 Temp C: 85C  
 Temp F: 185F  
 Environmental Condition: 85%RH  
 Substrate: Polyvinyl chloride (PVC)

Notes: Performance % to control sample @RT, tested after 24hr dwell @RT. Cured adhesives can handle short contact to most chemicals or env. cond. Avoid long exposure to: Temp >100°F + water Ketone-type solvents (acetone, MEK) Gasoline and similar liquids

Bell Peel 23°C (72°F) Aluminum 35 lb/in width [View](#) 

Substrate: Etched Aluminum  
 Failure Mode: CF


Notes: 6 in/min, 1in wide, 1/16in thick Data from 3M™ EPX™ Applicator System with an EPX static mixer according to manufacturer's directions. Thorough hand-mixing will afford comparable results. Cohesive (CF), Adesive (AF) and Substrate (SF) Failure

### Typical Cured Characteristics


| Property | Values                    | Additional Information |
|----------|---------------------------|------------------------|
| Modulus  | 125000 lb/in <sup>2</sup> |                        |

View 

Notes: 1/8" thick Type I test specimens; samples pulled at 0.2 in/min.  
ASTM D638 2 week dwell at 23°C (72°F)

|                  |                         |  |
|------------------|-------------------------|--|
| Tensile Strength | 1650 lb/in <sup>2</sup> | View  |
|------------------|-------------------------|--|

Notes: 1/8" thick Type I test specimens; samples pulled at 0.2 in/min.

|                         |       |  |
|-------------------------|-------|--|
| Tensile Strain at Break | 6.5 % | View  |
|-------------------------|-------|--|

Notes: 1/8" thick Type I test specimens; samples pulled at 0.2 in/min.

## Storage and Shelf Life

Store product at 80°F (27°C) or below. Refrigeration at 40°F (4°C) will help extend shelf life. Do not freeze. Allow product to reach room temperature prior to use.

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives have a shelf life of 24 months from date of manufacture in unopened original containers kept at recommended storage conditions.

## Industry Specifications

Review UL File QQQW2. MH17478 and Sign Components Manual (SAM) File E464624 for certification of these adhesive systems in electrical equipment.

Bombardier SMP 800-C

Boeing BSS 7239

[EN 45545 test report details \(ISO 5659-2, ISO 9239-1, ISO 5660-1, ISO 5658-2\)](#)

[NFPA 130 test report details \(ASTM E162, ASTM E662, SMP 800-C, BSS 7239\)](#)

## Bottom Matter

3M

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## Trademarks

3M, Scotch-Weld and EPX are trademarks of 3M Company.

## Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M's Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer's use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

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## Handling/Application Information

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### Directions for Use

1. To obtain the highest strength structural bonds, paint, oxide films, oils, dust, mold release agents, and all other surface contaminants must be completely removed. The amount of surface preparation depends on the required bond strength and environmental aging resistance desired by user. For suggested surface preparations on common substrates, see the section on surface preparation.

### 2. Mixing For Duo-Pak Cartridges

Store cartridges with cap end up to allow any air bubbles to rise towards the tip. To use, simply insert the cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. Then remove the cap and expel a small amount of adhesive to ensure material flows freely from both sides of cartridge. For automatic mixing, attach an EPX mixing nozzle to the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after obtaining a uniform color.

### For Bulk Containers

Mix thoroughly by weight or volume in the proportion specified on the product label or in the typical uncured properties section. Mix approximately 15 seconds after obtaining a uniform color.

3. Apply adhesive and join surfaces within the open time listed for the specific product. Larger quantities and/or higher temperatures will reduce this working time.

4. Allow adhesive to cure at 60°F (16°C) or above until completely firm. Applying heat up to 150°F (66°C) will increase cure speed.

5. Keep parts from moving during cure. Apply contact pressure or fixture in place if necessary. Optimum bond line thickness ranges from 0.005 to 0.020 inch; shear strength will be maximized with thinner bond lines, while peel strength reaches a maximum with thicker bond lines.

6. Excess uncured adhesive can be cleaned up with ketone-type solvents.

\*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

### Surface Preparation

3M™ Scotch-Weld™ Low Odor Acrylic Adhesives are designed to be used on painted or coated metals, most plastics, glass, and some bare metals. The following cleaning methods are suggested for common surfaces:

#### Painted/coated metals:

1. Wipe surface free of dust and dirt with clean cloth and pure isopropyl alcohol.\*
2. Sandblast or lightly abrade using clean fine grit abrasives. Do not completely remove the paint layer or coating down to bare steel.
3. Wipe again with clean cloth and pure isopropyl alcohol to remove loose particles.\*

#### Aluminum/stainless steel:

1. Wipe surface free of dust and dirt with clean cloth and pure acetone.\*
2. Sandblast or lightly abrade using clean fine grit abrasives.
3. Wipe again with clean cloth and pure acetone to remove loose particles.\*

#### Plastics:

1. Wipe surface free of dust and dirt with clean cloth and pure isopropyl alcohol.\*
2. Lightly abrade using fine grit abrasives.
3. Wipe again with clean cloth and pure isopropyl alcohol to remove loose particles.\*

#### Glass:

1. Wipe surface free of dust and dirt with clean cloth and pure acetone.\*
2. Apply a thin coating of silane adhesion promoter to the glass surface and allow to dry completely before adhesive bonding.

\*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

## References

| Property              | Values  |
|-----------------------|---|
| 3m.com Product Page   | <a href="https://www.3m.com/3M/en_US/p/d/b40066426/">https://www.3m.com/3M/en_US/p/d/b40066426/</a>   |
| Safety Data Sheet SDS | <a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=DP8810NS Green">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=DP8810NS Green</a> |

## Family Group

Link Tags:

- DP8805NS Green
- DP8810NS Green
- DP8825NS Green

| Products       | Open Time | Time to Structural Strength | Color      | Time to Full Cure | Modulus                       | Tensile Strength              | Worklife     | Set Time (min) | Tensile Strain at Break |
|----------------|-----------|-----------------------------|------------|-------------------|-------------------------------|-------------------------------|--------------|----------------|-------------------------|
| DP8810NS Green | 10 min    | 19 to 23 min                | Blue-Green | 24 hr             | 125000 lb/in <sup>2</sup>     | 1650 lb/in <sup>2</sup>       | N/A          | N/A            | N/A                     |
| DP8805NS Green | 5 min     | 8 to 10 min                 | Blue-Green | N/A               | N/A                           | N/A                           | N/A          | N/A            | N/A                     |
| DP8825NS Green | N/A       | 50 to 56 min                | Blue-Green | 24 hr             | Not Tested lb/in <sup>2</sup> | Not Tested lb/in <sup>2</sup> | 22 to 24 min | 42 to 46 min   | Not Tested %            |

## ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

## 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.

## Information

**Technical Information:** The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

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