

# Technical Data Sheet

## 3M™ Scotch-Weld™ Epoxy Adhesive DP125 Gray

### Product Description

Scotch-Weld epoxy adhesive DP125 Gray is a filled, pigmented version of the Scotch-Weld epoxy adhesive DP125 Translucent and has similar performance and flexibility properties.

Available in bulk containers as 3M™ Scotch-Weld™ Epoxy Adhesive 125 B/A Gray.





### Product Features

- 25 minute worklife
- Flexible
- Gray
- High peel and shear strength
- Controlled flow
- 1:1 mix ratio
- Recognized as meeting UL 94 HB

### 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	25 min	<a href="#">View</a> 
Notes: POR=Pop Off Rubber		
Worklife, 2g mixed	25 min	<a href="#">View</a> 
Test Method: 3M C3180 Temp C: 23C Temp F: 73F Notes: Procedure involves periodically measuring a 2 gram mixed mass for self leveling and wetting properties. This time will also approximate the usable worklife in an 3M™ EPX™ Applicator mixing nozzle.		
Worklife, 20g mixed	15 min	<a href="#">View</a> 
Test Method: 3M C3180 Temp C: 23C Temp F: 73F Notes: Procedure involves periodically measuring a 2 gram mixed mass for self leveling and wetting properties. This time will also approximate the usable worklife in an 3M™ EPX™ Applicator mixing nozzle.		
Time to Handling Strength	≈2.5 hr	<a href="#">View</a> 

Temp C: 23C  
Temp F: 73F


Notes: Minimum time required to achieve 50 psi of overlap shear strength. Cure times are approximate and depend on adhesive temperature.

Tack Free Time	≈2 hr	<a href="#">View</a> 
<p>Test Method: 3M C3173</p> <p>Notes: Involves dispensing 0.5 gram amount of adhesive onto substrate and testing periodically for no adhesive transfer to metal spatula.</p>		
Time to Full Cure	7 day	<a href="#">View</a> 
<p>Notes: The cure time is defined as that time required for the adhesive to achieve a minimum of 80% of the ultimate strength as measured by aluminum-aluminum OLS.</p>		
Time to Full Cure	2.5 hr	<a href="#">View</a> 
<p>Temp C: 23C Temp F: 73F</p> <p>Notes: The cure time is defined as that time required for the adhesive to achieve a minimum of 80% of the ultimate strength as measured by aluminum-aluminum OLS.</p>		
Rate of Strength Buildup 6hr	500 lb/in <sup>2</sup>	<a href="#">View</a> 
<p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength Dwell/Cure Time: 6.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Substrate: Etched Aluminum</p> <p>Notes: 1 in wide 1/2 in overlap specimens with 1 in x 4 in substrates. 0.005-0.008in bondline. Jaw separation 0.1 in/min. Substrate thickness 0.05-0.064 in</p>		
Rate of Strength Buildup 1day	1700 lb/in <sup>2</sup>	<a href="#">View</a> 
<p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength Dwell/Cure Time: 1.0 Dwell Time Units: day Temp C: 23C Temp F: 72F Substrate: Etched Aluminum</p> <p>Notes: 1 in wide 1/2 in overlap specimens with 1 in x 4 in substrates. 0.005-0.008in bondline. Jaw separation 0.1 in/min. Substrate thickness 0.05-0.064 in</p>		
Rate of Strength Buildup 7day	2300 lb/in <sup>2</sup>	<a href="#">View</a> 
<p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength Dwell/Cure Time: 7.0 Dwell Time Units: day Temp C: 23C Temp F: 72F Substrate: Etched Aluminum</p> <p>Notes: 1 in wide 1/2 in overlap specimens with 1 in x 4 in substrates. 0.005-0.008in bondline. Jaw separation 0.1 in/min. Substrate thickness 0.05-0.064 in</p>		
Rate of Strength Buildup 1month	3300 lb/in <sup>2</sup>	<a href="#">View</a> 



Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 1.0  
Dwell Time Units: month  
Temp C: 23C  
Temp F: 72F  
Substrate: Etched Aluminum



Notes: 1 in wide 1/2 in overlap specimens with 1 in x 4 in substrates. 0.005-0.008in bondline. Jaw separation 0.1 in/min. Substrate thickness 0.05-0.064 in

Rate of Strength Buildup	250 lb/in <sup>2</sup>	<a href="#">View</a> 
<p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength Dwell/Cure Time: 3.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Substrate: Etched Aluminum</p> <p>Notes: 1 in wide 1/2 in overlap specimens with 1 in x 4 in substrates. 0.005-0.008in bondline. Jaw separation 0.1 in/min. Substrate thickness 0.05-0.064 in</p>		

### Typical Physical Properties

Property	Values	Additional Information
Color	Gray	<a href="#">View</a> 
Test Name: Mixed		
Color	Gray	<a href="#">View</a> 
Test Name: Cured		

### Typical Uncured Physical Properties

Property	Values	Additional Information
Base Color	Gray	
Accelerator Color	Amber	
Base Viscosity	35,000-75,000 cP	<a href="#">View</a> 
<p>Test Method: 3M C1d</p> <p>Temp C: 27C Temp F: 80F</p> <p>Notes: Procedure involves Brookfield RVF, #7 spindle, 20 rpm. Measurement taken after 1 minute rotation.</p>		
Accelerator Viscosity	45,000-65,000 cP	<a href="#">View</a> 
Test Method: 3M C1d		

Temp C: 27C  
Temp F: 80F

Notes: Procedure involves Brookfield RVF, #7 spindle, 20 rpm. Measurement taken after 1 minute rotation.


Base Resin	Epoxy/Amine
Base Net Weight	10.3 to 10.7 lb/gal
Accelerator Net Weight	8.5 to 8.9 lb/gal
Mix Ratio by Volume (B:A)	1:1
Mix Ratio by Weight (B:A)	1.2:1

### Typical Performance Characteristics

#### Additional Test notes

The following product performance data was obtained in the 3M laboratory under the conditions specified. The following data show typical results obtained with the 3M™ Scotch-Weld™ Adhesives when applied to properly prepared substrates, cured, and tested according to the specifications indicated. The data was generated using the 3M™ EPX™ Applicator System equipped with an EPX applicator static mixer, according to manufacturer's directions. Thorough hand mixing should afford comparable results.



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

Property	Values	Additional Information
Elongation (%)	120 %	<a href="#">View</a> 

Test Method: ASTM D882

Dwell/Cure Time: 2.0  
Dwell Time Units: hr  
Temp C: 23C  
Temp F: 72F  
Environmental Condition: +2 hr @ 160F(71C)

Notes: Samples were 2 in. dumbbells with 0.125 in. neck and .030 in. sample thickness. Separation rate was 2 inches per minute.

T-Peel Adhesion -55C Etched Aluminum	3 lb/in width	<a href="#">View</a> 
<p>Test Method: ASTM D1876</p> <p>Test Name: T-Peel Adhesion Temp C: -55C Temp F: -67F Substrate: Etched Aluminum</p> <p>Notes: T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.</p>		
T-Peel Adhesion 23C Etched Aluminum	35 lb/in width	<a href="#">View</a> 

Test Method: ASTM D1876

Test Name: T-Peel Adhesion  
Temp C: 23C  
Temp F: 73F  
Substrate: Etched Aluminum

Notes: T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.

T-Peel Adhesion 49C Etched Aluminum      18 lb/in width      [View](#) 

Test Method: ASTM D1876

Test Name: T-Peel Adhesion  
Temp C: 49C  
Temp F: 120F  
Substrate: Etched Aluminum

Notes: T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.

T-Peel Adhesion 66C Etched Aluminum      3 lb/in width      [View](#) 

Test Method: ASTM D1876

Test Name: T-Peel Adhesion  
Temp C: 66C  
Temp F: 150F  
Substrate: Etched Aluminum

Notes: T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.

T-Peel Adhesion 82C Etched Aluminum      2 lb/in width      [View](#) 

Test Method: ASTM D1876

Test Name: T-Peel Adhesion  
Temp C: 82C  
Temp F: 180F  
Substrate: Etched Aluminum

Notes: T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.020 in. thick. Samples dwelled for 24 hrs at 23C + 2 hrs at 71C before testing.

Solvent Resistance Acetone 1hr      A      [View](#) 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Acetone 1hr

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance Acetone 1month      A      [View](#) 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Acetone 1mo

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance Isopropyl Alcohol 1hr      A      [View](#) 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Isopropyl Alcohol 1hr

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance Isopropyl Alcohol 1month      A      [View](#) 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Isopropyl Alcohol 1mo

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance Freon TF 1hr A View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Freon TF 1hr

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance Freon TF 1month A View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Freon TF 1mo

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance Freon TMC 1hr A View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Freon TMC 1hr

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance Freon TMC 1month B View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + Freon TMC 1mo

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance 1, 1, 1 - Trichloroethane 1hour A View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + 1, 1, 1 - Trichloroethane 1hr

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance 1, 1, 1 - Trichloroethane 1month A View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + 1, 1, 1 - Trichloroethane 1mo

Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance RMA Flux 1hr A View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + RMA Flux 1hr


Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

Solvent Resistance RMA Flux 1month A View 

Environmental Condition: 24hr @ RT + 2hr @ 160F(71C) + RMA Flux 1mo


Notes: Cured OLS samples immersed in solvent and after dwell, examined for surface attack compared to control. A: Unaffected, no color or texture change B: Slight attack, slight swelling of surface. C: Moderate/severe attack, extreme swelling of surface.

## Typical Cured Characteristics

Property	Values	Additional Information
Shore D Hardness	70	<a href="#">View</a> 

Test Method: ASTM D2240


Temp C: 23C  
Temp F: 73F

Tensile Strength	3300 lb/in <sup>2</sup>	<a href="#">View</a> 
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Test Method: ASTM D882

Dwell/Cure Time: 2.0  
Dwell Time Units: hr  
Temp C: 23C  
Temp F: 72F  
Environmental Condition: +2 hr @ 160F(71C)


Notes: Samples were 2 in. dumbbells with 0.125 in. neck and .030 in. sample thickness. Separation rate was 2 inches per minute.

Weight Loss by Thermal Gravimetric Analysis (TGA)	1%	<a href="#">View</a> 
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Test Method: ASTM E1131


Temp C: 176C  
Temp F: 349F

Notes: Weight loss by Thermal Gravimetric Analysis reported as that temperature at which 5% weight loss occurs by TGA in air at 5°C (9°F) rise per minute.

Thermal Shock Resistance	Pass 5 cycles without cracking	<a href="#">View</a> 
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Test Method: 3M C3174

Notes: Involves potting a metal washer into a 2 in. x 0.5 in. thick section and cycling this test specimen to colder and colder temperatures.

Weight Loss by Thermal Gravimetric Analysis (TGA)	303 °C	<a href="#">View</a> 
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Test Method: ASTM E1131


Notes: Weight loss by Thermal Gravimetric Analysis reported as that temperature at which 5% weight loss occurs by TGA in air at 5°C (9°F) rise per minute.

Weight Loss by Thermal Gravimetric Analysis (TGA)	577 F	<a href="#">View</a> 
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Test Method: ASTM E1131

Notes: Weight loss by Thermal Gravimetric Analysis reported as that temperature at which 5% weight loss occurs by TGA in air at 5°C (9°F) rise per minute.


## Electrical and Thermal Properties

Property	Values	Additional Information
Glass Transition Temperature (T <sub>g</sub> )	23 °C	<a href="#">View</a> 

Notes: Glass Transition Temperature (T<sub>g</sub>) determined using DSC Analyzer with a heating rate of 68°F (20°C) per minute. Second heat values given.


Glass Transition Temperature (T <sub>g</sub> )	73 °F	<a href="#">View</a> 
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Notes: Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 68°F (20°C) per minute. Second heat values given.

Glass Transition Temperature (Tg)	12 °C	<a href="#">View</a> 
Notes: Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 68°F (20°C) per minute. Second heat values given.		

Glass Transition Temperature (Tg)	54 °F	<a href="#">View</a> 
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Notes: Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 68°F (20°C) per minute. Second heat values given.

Dielectric Constant 1KHz	6.3	<a href="#">View</a> 
Test Method: ASTM D150		
Temp C: 23C Temp F: 72F		

Dielectric Constant 1MHz	0.13	<a href="#">View</a> 
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Test Method: ASTM D150

Temp C: 23C  
Temp F: 72F


Thermal Conductivity	0.36 x 10 <sup>-3</sup> Cal/s/cm/°C	<a href="#">View</a> 
Test Method: C177		
Temp F: 110F		
Notes: Thermal conductivity determined using C-matic Instrument using 2 in. diameter samples.		

Thermal Conductivity	15.1 W/m/K	<a href="#">View</a> 
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Test Method: C177

Temp F: 110F

Notes: Thermal conductivity determined using C-matic Instrument using 2 in. diameter samples.

Thermal Conductivity	0.087 (btu-ft)/(h-ft <sup>2</sup> -°F)	<a href="#">View</a> 
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Test Method: C177


Temp F: 110F

Notes: Thermal conductivity determined using C-matic Instrument using 2 in. diameter samples.

Volume Resistivity	1.0 x 10 <sup>11</sup> Ω-cm	<a href="#">View</a> 
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Test Method: ASTM D257

Temp C: 23C  
Temp F: 73F

Coefficient of Thermal Expansion	98 x 10 <sup>-6</sup> m/m/°C	<a href="#">View</a> 
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Notes: TCE determined using TMA Analyzer using a heating rate of 10°C per minute. Second heat values given.

Coefficient of Thermal Expansion



187 x 10<sup>-6</sup> m/m/°CView 

Notes: TCE determined using TMA Analyzer using a heating rate of 10°C per minute. Second heat values given.

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## Storage and Shelf Life

Store products at 60-80°F (16-27°C) for maximum shelf life.

These products have a shelf life of 24 months from date of manufacture in their unopened original containers.

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## Industry Specifications

UL 94 HB

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## Bottom Matter

3M

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## Trademarks

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

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## 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

### Application Equipment

For small or intermittent applications the 3M™ EPX™ Applicator System is a convenient method of application.

For larger applications these products may be applied by use of flow equipment.

Two part meter/mixing/proportioning/dispensing equipment is available for intermittent or production line use. These systems may be desirable because of their variable shot size and flow rate characteristics and are adaptable to many applications.

### Directions for Use

1. For high strength structural bonds, paints, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user. For specific surface preparations on common substrates, see the section on surface preparation.

2. Use gloves to minimize skin contact. Do not use solvents for cleaning hands.

3. Mixing.

For Duo Pak Cartridges

3M™ Scotch-Weld™ Epoxy Adhesives DP125 Translucent and Gray are supplied in a dual syringe plastic duo-pak cartridge as part of the 3M™ EPX™ Applicator System. To use, simply insert the duo-pak cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. Next, remove the duopak cartridge cap and expel a small amount of adhesive to be sure both sides of the duo-pak cartridge are flowing evenly and freely. If automatic mixing of Part A and Part B is desired, attach the EPX applicator mixing nozzle to the duo-pak cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.

For Bulk Containers

Mix thoroughly by weight or volume in the proportions specified in the typical uncured properties section. Mix approximately 15 seconds after uniform color is obtained.

4. For maximum bond strength, apply adhesive evenly to both surfaces to be joined.

5. Application to the substrates should be made within 20 minutes. Larger quantities and/or higher temperatures will reduce this working time.

6. Join the adhesive coated surfaces and allow to cure at 60°F (16°C) or above until completely firm. Heat up to 200°F (93°C), will speed curing. These products will cure in 7 days @ 75°F (24°C).

7. Keep parts from moving during cure. Contact pressure necessary. Maximum shear strength is obtained with a 3-5 mil bond line.

8. Excess uncured adhesive can be cleaned up with ketone type solvents.\*

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

Adhesive Coverage (typical): A 0.005 in. thick bondline will yield a coverage of 320 sqft/gallon.

Surface Preparation

For high strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user.

The following cleaning methods are suggested for common surfaces:

Steel:

1. Wipe free of dust with oil-free solvent such as acetone, isopropyl or alcohol solvents.\*
2. Sandblast or abrade using clean fine grit abrasives.
3. Wipe again with solvent to remove loose particles.\*
4. If a primer is used, it should be applied within 4 hours after surface preparation.

Aluminum:

1. Alkaline Degrease: Oakite 164 solution (9-11 oz./gallon water) at 190°F ± 10°F for 10-20 minutes. Rinse immediately in large quantities of cold running water.
2. Acid Etch: Place panels in the following solution for 10 minutes at 150°F ± 5°F .

Sodium Dichromate 4.1 - 4.9 oz./gallon

Sulfuric Acid, 66°Be 38.5 - 41.5 oz./gallon

2024-T3 aluminum (dissolved) 0.2 oz./gallon minimum

Tap water as needed to balance

3. Rinse: Rinse panels in clear running tap water.

4. Dry: Air dry 15 minutes; force dry 10 minutes at 150°F ± 10°F.

5. If primer is to be used, it should be applied within 4 hours after surface preparation.

Note: Read and follow supplier's environmental, health, and safety documentation for these chemicals prior to preparation of this solution.

Plastics/Rubber:

1. Wipe with isopropyl alcohol.\*
2. Abrade using fine grit abrasives.
3. Wipe with isopropyl alcohol.\*

Glass:

1. Solvent wipe surface using acetone or MEK.\*
2. Apply a thin coating (0.0001 in. or less) of primer such as 3M™ Scotch-Weld™ Metal Primer EC3901 to the glass surfaces to be bonded and allow the primer to dry before bonding.

\*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow 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/b5005321031/">https://www.3m.com/3M/en_US/p/d/b5005321031/</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=DP125 Gray">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=DP125 Gray</a>

## Family Group

Link Tags:

- DP125 Translucent
- DP125 Gray

Products	Open Time	Time to Handling Strength	Color
DP125 Translucent	25 min	≈2.5 hr	N/A
DP125 Gray	25 min	≈2.5 hr	Gray

## 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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