

# Technical Data Sheet

## 3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear

### Product Description

3M™ Scotch-Weld™ Epoxy Adhesive DP100 is a two-part adhesive offering fast cure and machinability. Available in larger containers as 3M™ Scotch-Weld™ Epoxy Adhesives 100 B/A or 100 NS B/A.

### Product Features

- Easy mixing
- High Flow
- Fast Cure
- Meets 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 Uncured Physical Properties

Property	Values	Additional Information
Color	Clear	<a href="#">View</a> 

Notes: Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

Base Viscosity	8,000-15,000 cP	<a href="#">View</a> 
Test Method: 3M C1d Temp C: 27C Temp F: 80F Notes: Procedure involves Brookfield RVF, #6 spindle, 20 rpm. Measurement taken after 1 minute.		

Accelerator Viscosity	9,000-16,000 cP	<a href="#">View</a> 
Test Method: 3M C1d Temp C: 27C Temp F: 80F Notes: Procedure involves Brookfield RVF, #6 spindle, 20 rpm. Measurement taken after 1 minute.		







Base Resin	Epoxy
Base Net Weight	9.5 to 9.9 lb/gal


Accelerator Net Weight 9.2 to 9.6 lb/gal

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

Mix Ratio by Weight (B:A) 1:0.98

### Typical Mixed Physical Properties

Property	Values	Additional Information
Open Time	5 min	<a href="#">View</a> 
Notes: POR=Pop Off Rubber		
Worklife, 10g mixed	5 min	<a href="#">View</a> 
Test Method: 3M C548  Temp C: 23C Temp F: 73F  Notes: Procedure involves periodically measuring a 10 gram mixed mass for spreading and wetting properties. This time approximates the usable worklife in an EPX applicator nozzle.		
Set Time (min)	15 to 20 min	<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.		
Time to Full Cure	24 to 48 hr	<a href="#">View</a> 
Temp C: 23C Temp F: 73F  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.		
Time to Full Cure	24 to 48 hr	<a href="#">View</a> 
Temp C: 23C Temp F: 73F		
Rate of Strength Buildup 20min	400 lb/in <sup>2</sup>	<a href="#">View</a> 
Test Method: ASTM D1002  Test Name: Overlap Shear Strength Dwell/Cure Time: 20.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Substrate: Aluminum  Notes: 1in wide 1/2in overlap shear specimens. 2 panels 0.063 in. thick, 4 in. x 7 in. of 2024T-3 clad aluminum bonded and cut 1in wide samples after 24hr. 7mil bondline. Jaw Separation 0.1in/min		


Rate of Strength Buildup 0 lb/in<sup>2</sup> [View](#) 

Test Method: ASTM D1002



Test Name: Overlap Shear Strength  
Dwell/Cure Time: 10.0  
Dwell Time Units: min  
Temp C: 23C  
Temp F: 72F  
Substrate: Aluminum

Notes: 1in wide 1/2in overlap shear specimens. 2 panels 0.063 in. thick, 4 in. x 7 in. of 2024T-3 clad aluminum bonded and cut 1in wide samples after 24hr. 7mil bondline. Jaw Separation 0.1in/min

### Typical Physical Properties

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

### Typical Cured Characteristics

Property	Values	Additional Information
Shore D Hardness	82	<a href="#">View</a> 
Test Method: ASTM D2240		
Temp C: 23C Temp F: 73F		
Weight Loss by Thermal Gravimetric Analysis (TGA)	585°F(307°C)	<a href="#">View</a> 
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.		

Compression Strength	8400 lb/in <sup>2</sup>	<a href="#">View</a> 
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Test Method: ASTM D695






### Typical Performance Characteristics

Property	Values	Additional Information
Overlap Shear Strength 7day Aluminum	950 lb/in <sup>2</sup>	<a href="#">View</a> 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
Dwell/Cure Time: 7.0  
Dwell Time Units: day  
Temp C: 23C  
Temp F: 73F  
Environmental Condition: 50%RH  
Substrate: Aluminum  
Surface Preparation: MEK/Abrade/MEK

Notes: 1in wide 1/2in overlap specimens. 2 panels of 0.05-0.064in x 4in x 7in 2024T-3 clad aluminum bonded and cut to 1in wide samples after 24hr. Jaw separation 0.1 in/min, 0.005-0.008in bondline. Cohesive (CF), Adhesive (AF), and Substrate (SF) Failure

Overlap Shear Strength 7day Cold Rolled Steel	1000 lb/in <sup>2</sup>	View 
<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: 73F Environmental Condition: 50%RH Substrate: Cold Rolled Steel Surface Preparation: MEK/Abrade/MEK</p> <p>Notes: Overlap shear (OLS) strengths were measured on 1in wide 1/2in overlap specimens on 1in x 4in x .060in substrates. Jaw separation 0.1 in/min. 0.005-0.008in bondline. Cohesive (CF), Adhesive(AF), and Substrate(SF) Failure</p>		
Overlap Shear Strength 7day Copper	950 lb/in <sup>2</sup>	View 
<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: 73F Environmental Condition: 50%RH Substrate: Copper Surface Preparation: MEK/Abrade/MEK</p> <p>Notes: Overlap shear (OLS) strengths were measured on 1in wide 1/2in overlap specimens on 1in x 4in x 0.05-0.060in substrates. Jaw separation 0.1 in/min. 0.005-0.008in bondline. Cohesive (CF), Adhesive(AF), and Substrate(SF) Failure</p>		
Overlap Shear Strength 7day Brass	700 lb/in <sup>2</sup>	View 
<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: 73F Environmental Condition: 50%RH Substrate: Brass Surface Preparation: MEK/Abrade/MEK</p> <p>Notes: Overlap shear (OLS) strengths were measured on 1in wide 1/2in overlap specimens on 1in x 4in x 0.05-0.060in substrates. Jaw separation 0.1 in/min. 0.005-0.008in bondline. Cohesive (CF), Adhesive(AF), and Substrate(SF) Failure</p>		
Overlap Shear Strength 7day Stainless Steel	750 lb/in <sup>2</sup>	View 
<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: 73F Environmental Condition: 50%RH Substrate: Stainless Steel Surface Preparation: MEK/Abrade/MEK</p> <p>Notes: Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1" x 4" x 0.060" substrate Jaw Separation 0.1in/min Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)</p>		
Overlap Shear Strength 7day ABS	490 lb/in <sup>2</sup>	View 
<p>Test Method: ASTM D1002</p> <p>Test Name: Overlap Shear Strength</p>		

Dwell/Cure Time: 7.0  
 Dwell Time Units: day  
 Temp C: 23C  
 Temp F: 73F  
 Environmental Condition: 50%RH  
 Substrate: ABS  
 Surface Preparation: IPA Wipe/Abrade/IPA Wipe

Notes: Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. Bonds made with 1 in x 4 in x 0.125in pieces of substrate with a 0.005-0.008in bondline. Jaw Separation 2in/min Cohesive (CF), Adhesive (AF), Substrate (SF) Failure

Overlap Shear Strength 7day Polyvinyl chloride (PVC)

330 lb/in<sup>2</sup>

[View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
 Dwell/Cure Time: 7.0  
 Dwell Time Units: day  
 Temp C: 23C  
 Temp F: 73F  
 Environmental Condition: 50%RH  
 Substrate: Polyvinyl chloride (PVC)  
 Surface Preparation: IPA Wipe/Abrade/IPA Wipe

Notes: Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. 1" x 4" x 0.125" substrate Jaw separation 2 in/min; 0.005-0.008in bondline. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)

Overlap Shear Strength 7day Polycarbonate (PC)

250 lb/in<sup>2</sup>

[View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
 Dwell/Cure Time: 7.0  
 Dwell Time Units: day  
 Temp C: 23C  
 Temp F: 73F  
 Environmental Condition: 50%RH  
 Substrate: Polycarbonate (PC)  
 Surface Preparation: IPA Wipe/Abrade/IPA Wipe

Notes: Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. 1" x 4" x 0.125" substrate Jaw separation 2 in/min; 0.005-0.008in bondline. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)

Overlap Shear Strength 7day Acrylic (PMMA)

100 lb/in<sup>2</sup>

[View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
 Dwell/Cure Time: 7.0  
 Dwell Time Units: day  
 Temp C: 23C  
 Temp F: 73F  
 Environmental Condition: 50%RH  
 Substrate: Acrylic (PMMA)

Notes: Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. 1" x 4" x 0.125" substrate Jaw separation 2 in/min; 0.005-0.008in bondline. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)

Overlap Shear Strength 7day Fiber-Reinforced Plastic

950 lb/in<sup>2</sup>

[View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength  
 Dwell/Cure Time: 7.0  
 Dwell Time Units: day  
 Temp C: 23C  
 Temp F: 73F  
 Environmental Condition: 50%RH  
 Substrate: Fiber-Reinforced Plastic  
 Surface Preparation: IPA Wipe/Abrade/IPA Wipe

Notes: Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. 1" x 4" x 0.125" substrate Jaw separation 2 in/min; 0.005-0.008in bondline. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)



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 B 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 A 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 B [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.

Overlap Shear Strength 7day Galvanized Steel 900 lb/in<sup>2</sup> [View](#) 

Test Method: ASTM D1002

Test Name: Overlap Shear Strength

Dwell/Cure Time: 7.0

Dwell Time Units: day

Temp C: 23C

Temp F: 73F

Environmental Condition: 50%RH

Substrate: Galvanized Steel

Surface Preparation: MEK/Abrade/MEK

Notes: 0.5in overlap, 0.1 in/min for metals and 2 in/min for plastics, substrates lightly abraded and solvent wiped, substrates used were 1/16in thick, 0.010in bondline Substrate (SF), Adhesive (AF), Cohesive (CF), and Mixed (MF) Failure modes

T-Peel Adhesion 7day 23C Aluminum 2 lb/in width [View](#) 

Test Method: ASTM D1876

Test Name: T-Peel Adhesion

Dwell/Cure Time: 7.0

Dwell Time Units: day

Temp C: 23C

Temp F: 73F

Substrate: Aluminum

Notes: 0.032in thick, 5 - 8 mil bondline T-peel strengths with 1 in wide bonds. Jaw separation rate @ 20 in/min.

T-Peel Adhesion 7day 23C Aluminum 2 lb/in width [View](#) 

Test Method: ASTM D1876

Test Name: T-Peel Adhesion

Dwell/Cure Time: 7.0


Dwell Time Units: day

Temp C: 23C

Temp F: 73F

Substrate: Aluminum

Notes: 0.032in thick, 5 - 8 mil bondline T-peel strengths with 1 in wide bonds. Jaw separation rate @ 20 in/min.

T-Peel Adhesion 7day 23C Cold Rolled Steel 2 lb/in width [View](#) 

Test Method: ASTM D1876

Test Name: T-Peel Adhesion


Dwell/Cure Time: 7.0  
 Dwell Time Units: day  
 Temp C: 23C  
 Temp F: 73F  
 Substrate: Cold Rolled Steel  
 Surface Preparation: MEK/Abrade/MEK

Notes: 0.032in thick, 5 - 8 mil bondline T-peel strengths with 1 in wide bonds. Jaw separation rate @ 20 in/min.

## Electrical and Thermal Properties

Property	Values	Additional Information
Glass Transition Temperature (Tg)	33 °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)	91 °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.

Volume Resistivity	3.5 x 10 <sup>12</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	60 x 10 <sup>-6</sup> m/m/°C	<a href="#">View</a> 
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Notes: Coefficient of thermal expansion determined using DuPont (TMA) using a heating rate of 10°C (50°F) per minute. Second heat values given.

Coefficient of Thermal Expansion	209 x 10 <sup>-6</sup> m/m/°C	<a href="#">View</a> 
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Notes: Coefficient of thermal expansion determined using DuPont (TMA) using a heating rate of 10°C (50°F) per minute. Second heat values given.

## Storage and Shelf Life

Store products at 60-80°F (16-27°C) for maximum storage life. Rotate on “first in-first out” basis.

When stored as recommended in original unopened container, this product has a shelf life of 24 months from date of manufacture.

## Industry Specifications

UL 94 HB

## Bottom Matter

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 800-362-3550

## Trademarks

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



## Automotive Disclaimer

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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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### Application Equipment

For small or intermittent applications the 3M™ Scotch-Weld™ EPX™ applicator is a convenient method of application.

For larger applications these adhesives may be applied by use of flow equipment. Two-part meter/mixing/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 optimum 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. For specific surface preparations on common substrates, see the following section on Surface Preparation.
2. Use gloves to minimize skin contact with adhesive.
3. These products consist of two parts.

### Mixing and Applying

For Duo-Pak Cartridges - 48.5 ml

3M™ Scotch-Weld™ DP100 and DP100 NS Adhesives are supplied in a dual syringe plastic Duo-Pak cartridge as part of the 3M™ Scotch-Weld™ 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 Duo-Pak 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 mixing of Part A and Part B is desired, attach the EPX 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 Duo-Pak Cartridges - 200/400 ml

Directions for Use: While holding cartridge in an upright position, remove insert from Duo-Pak cartridge by unscrewing plastic nut. Detach metal removal disc from insert to free plastic nut for nozzle attachment. Clear orifices if necessary. Attach mixing nozzle and secure with plastic nut. Place cartridge into EPX Applicator. Dispense a small quantity of adhesive to assure both components are dispensing equally. Apply adhesive to clean surfaces, join parts, secure until set up (20 minutes @ 75°F [24°C]). Leave nozzle attached to store. Replace nozzle after storage.

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 5 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 fully cure in 24-48 hours @ 75°F (24°C).
7. Keep parts from moving during cure. Contact pressure is 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 and follow the manufacturer’s precautions and directions for use.

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

#### Surface Preparation

For optimum 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 the user.

The following cleaning methods are suggested for common surfaces:

#### Steel:

1. Wipe free of dust with oil-free solvent such as acetone or isopropyl alcohol.\*
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. Acid Etch: Place panels in the following solution for 10 minutes at 150°F ± 5°F (66°C ± 2°C).

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

2. Rinse: Rinse panels in clear running tap water.
3. Dry: Air dry 15 minutes and force dry 10 minutes at 150°F ± 10°F (66°C ± 5°C).
4. If primer is to be used, it should be applied within 4 hours after surface preparation.
5. Option 2: Degrease with an industrial solvent such as MEK\*; abrade with ScotchBrite™ 7447 abrasive (or sandpaper of approximately 180 grit) and wipe again with solvent\*.

#### Plastics/Rubber:

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

\*Note: When using solvents, extinguish all ignition sources 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/b40066435/">https://www.3m.com/3M/en_US/p/d/b40066435/</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=DP100 Clear">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=DP100 Clear</a>

## Family Group

Link Tags:

- DP100 Clear
- DP100NS Translucent

Products	Open Time	Color	Set Time (min)	Time to Full Cure	Shore D Hardness
DP100 Clear	5 min	Clear	15 to 20 min	24 to 48 hr	N/A
DP100NS Translucent	N/A	Translucent	N/A	N/A	82

## ISO Statement

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

## Information

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**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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