



**Adhesive
Solutions**

GROUP OF COMPANY

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3M

Scotch-Weld™

Epoxy Adhesives

DP190 Translucent and Grey

Technical Data

February, 2016

Product Description

3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent is a 1:1 mix ratio similar to 3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A Translucent but faster curing.

3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey is a 1:1 by volume mix ratio of 3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A Grey and exhibits good peel, shear and environmental aging properties.

Available in bulk containers as 3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A.

Features

- 90 minute worklife
- Flexible
- Translucent or grey colour
- High shear and peel strength
- 1:1 mix ratio

**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.

		3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
Base Resins		Epoxy/Amine	Epoxy/Amine
Viscosity¹, Approximate @ 24°C (75°F)	Base (B) Accelerator (A)	2,000-8,000 cps 7,000-15,000 cps	75,000-150,000 cps 40,000-80,000 cps
Net Weight (Lbs./gal.)	Base (B) Accelerator (A)	9.3-9.7 8.2-8.6	11.0-11.4 10.6-11.0
Colour (Lbs./gal.)	Base (B) Accelerator (A)	Clear Amber	White Grey
Mix Ratio (B:A)	By Volume By Weight	1:1 1.15:1	1:1 1.06:1
Worklife² @ 23°C (73°F)	2 gram 20 gram	80 min. 60 min.	— 90 min.

Footnotes:

1. Viscosity determined using 3M test method C-1D. Procedure involves Brookfield RVF, #7 spindle, 20 rpm and 26°C (80°F) Measurement taken after 1 minute rotation.
2. Worklife determined using 3M test method C-3180. 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.

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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

Footnotes:

3. Tack-free time determined per 3M test method C-3173. Involves dispensing 0.5 gram amount of adhesive onto substrate and testing periodically for no adhesive transfer to metal spatula.
4. Handling strength determined per 3M test method C-3179. Time to handling strength taken to be that required to achieve a 50 psi OLS strength using aluminum substrates.

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.

5. Tensile and Elongation. Used procedure in 3M test method C-3094/ATSM D 882. Samples were 2 in. dumbbells with .0125 in. neck and .030 in. sample thickness. Separation rate was 2 inches per minute. Samples cured 2 hrs RT plus 2 hrs/ 71°C (160°F).

6. Weight loss by TGA reported as that temperature at which 5% weight loss occurs by TGA in air at 5°C rise per minute per ASTM 1131-86.

7. TCE determined using TMA Analyzer using a heating rate of 10°C (50°F) per minute. Second heat values given.

8. Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 20°C (68°F) per minute. Second heat values given.

9. Thermal conductivity determined using ASTM C177 and C-matic Instrument using 2 in. diameter samples.

Thermal shock resistance run per 3M test method C-3174. 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.

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
Colour	Translucent	Grey
Hardness (ASTM D2240) Shore D	35	60
Worklife²	80 minutes	90 minutes
Tack-free Time³	~ 4 hrs	~ 6 hrs
Time to Handling Strength⁴	6 hrs	8-12 hrs
Full Cure Time⁵	14 days	7 days
Elongation⁶	120%	30%
Tensile Strength⁶	2750 psi	3500 psi

Thermal

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
Weight Loss by Thermal Gravimetric Analysis (TGA)⁷	1% @ 199°C (390°F) 5% @ 312°C (594°F)	1% @ 247°C (477°F) 5% @ 337°C (639°F)
Thermal Coefficient of Expansion (TCE) by TMA⁸ (° x 10⁻⁶ units/unit/°C)		
Below Tg	86 (5-20°C [41-68°F] range)	62 (5-25°C [41-68°F] range)
Above Tg	166 (75-140°C [167-284°F] range)	177 (65-140°C [167-284°F] range)
Glass Transition Temperature (Tg) by DCS⁹ Onset Mid-Point	10°C (50°F) 27°C (80°F)	7°C (45°F) 20°C (68°F)
Thermal Conductivity¹⁰ (@ 110°F on .250 in. samples) BTU - ft./ft.² - hr. - °F) Cal./sec. - cm - °C) Watt/m - °C	.079 .39 x 10 ⁻³ .136	.220 90.9 x 10 ⁻² .381
Thermal Shock Resistance¹¹ Potted Washer Olyphant Test (3MITSD Test Method C-3174 +100°C[air] to -50°C[liquid])	Pass 5 cycles without cracking	Pass 5 cycles without cracking

Electrical

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
Dielectric Constant @ 1 KHz @ 23°C (73°F) (ASTM D 150)	6.2	6.5
Dissipation Factor @ 1 KHz @ 23°C (73°F) (ASTM D 150)	0.16	0.09
Dielectric Strength (ASTM D 149) Sample Thickness Approx. 30 mil.	875 volts/mil	830 volts/mil
Volume Resistivity (ASTM D 257)	7.5 x 10 ¹⁰ ohm-cm	5.0 x 10 ¹² ohm-cm

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Typical Adhesive Performance Characteristics

The following product performance data were 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 were 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.

Overlap Shear Strength (OLS) to¹²

(Bonds cured 24 hrs @ RT + 2 hrs 71°C [160°F])

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
Etched Aluminum	1800 psi	2500 psi
Sanded Aluminum (60 grit)	850 psi	1500 psi
Cold Rolled Steel	850 psi	1400 psi
Wood, Fir	650 psi	1100 psi
Glass, Borosilicate	260 psi	300 psi
Glass, +3M™ Scotch-Weld™ Primer 3901	300 psi	300 psi
Polycarbonate	400 psi	800 psi
Acrylic	350 psi	500 psi
Fibreglass	1000 psi	1600 psi
ABS	400 psi	700 psi
PVC	650 psi	800 psi
Polypropylene	90 psi	50 psi

Rate of Strength Buildup

(OLS on Etched Aluminum)¹² Bonds tested after:

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
1 hr @ RT	10 psi	10 psi
6 hrs @ RT	200 psi	50 psi
24 hrs @ RT	800 psi	1000 psi
7 days @ RT	1200 psi	2000 psi
1 mo @ RT	1800 psi	2200 psi
3 mos @ RT	1800 psi	2500 psi

Footnotes:

12. Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate. The thickness of the bond line was 0.005-0.008 in. All strengths were measured at 21°C (70°F) except where noted. (Test per ASTM D 1002-72.)

The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubber, 0.125 in.; plastics,

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Typical Adhesive Performance Characteristics (continued)

Footnotes:

12. Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate. The thickness of the bond line was 0.005-0.008 in. All strengths were measured at 21°C (70°F) except where noted. (Test per ASTM D 1002-72.)

The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubber, 0.125 in.; plastics, 0.125 in.

13. Solvent resistance was determined using cured (24 hrs RT + 2 hrs 71°C [160°F]) samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed in the test solvent for 1 hour and 1 month. After the allotted period of time the sample was removed and visually examined for surface attack as compared to the control.

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

Environmental Aging

(OLS on Etched Aluminum)¹² Bonds tested after:

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
24 hrs RT + 2 hrs @ 71°C (160°F)	1700 psi	2500 psi
24 hrs RT + 2 hrs @ 115°C (240°F)	3200 psi	3000 psi
1 wk RT + wk @ 90°F/90% RH	1400 psi	2400 psi
1 wk RT + 1 wk 248°F (120°C)	3500 psi	3500 psi
1 wk RT + 1 wk H ₂ O Immersion	1700 psi	2500 psi

Overlap Shear Strength vs Temperature¹²

(Bonds cured 24 hr @ RT + 2 hrs @ 71°C [160°F]) Bonds tested at:

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
-55°C (-67°F)	3500 psi	1500 psi
21°C (70°F)	1200 psi	2500 psi
49°C (120°F)	290 psi	1000 psi
66°C (150°F)	200 psi	600 psi
82°C (180°F)	160 psi	400 psi

180°F Peel Strength vs Temperature¹²

(Bonds cured 24 hr @ RT + 4 hrs @ 71°C [160°F]) Bonds tested at:

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
-55°C (-67°F)	3 piw	3 piw
21°C (70°F)	20 piw	20 piw
49°C (120°F)	3 piw	10 piw
66°C (150°F)	2 piw	4 piw
82°C (180°F)	1 piw	2 piw

Solvent Resistance¹³

One Hour/One Month

One Hour/One Month

	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey
Acetone	A/A	A/A
Isopropyl Alcohol	A/A	A/A
Freon TF	A/A	A/A
Freon TMC	A/B	A/A
1,1,1-Trichlorethane	A/A	A/A
RMA Flux	A/A	A/A

Key: A - Unaffected, B - Slight Attack, C - Moderate/Severe Attack

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3M™ EPX™ Pneumatic Applicator Delivery Rates

200 ml Applicator – Maximum Pressure 58 psi

Adhesive*	6mm Nozzle gms/minute	10mm Nozzle gms/minute
3M™ Scotch-Weld™ Epoxy Adhesive DP190 Grey	11.9	46.0

50 ml Applicator – Maximum Pressure 50 psi

Adhesive*	1/4 in. Nozzle gms/minute
3M™ Scotch-Weld™ Epoxy Adhesive DP190 Translucent	112 16.9
Scotch-Weld epoxy adhesive DP190Grey	21.5 (nozzle cut back 2 divisions)
Scotch-Weld epoxy adhesive DP190Grey	41.1
Scotch-Weld epoxy adhesive DP190 38°C (100°F)	

*Tests were run at a temperature of 21°C ± 1°C (70°F ± 2°F) and at maximum applicator pressure.

Handling/Curing Information

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 necessary directly depends on the required bond strength and the environmental aging resistance desired by the user. For suggested surface preparations on common substrates, see the section on surface preparation.
2. Mixing

For Duo Pak Cartridges

3M™ Scotch-Weld™ Epoxy Adhesives DP190 Translucent and DP190 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 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 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 colour is obtained.

3. For maximum bond strength, apply adhesive evenly to both surfaces to be joined.
4. Application to the substrates should be made within 75 minutes. Larger quantities and/or higher temperatures will reduce this working time.
5. Join the adhesive coated surfaces and allow to cure at 16°C (60°F) or above until completely firm. Heat up to 93°C (200°F) will speed curing. These products will cure in 7 to 14 days @ 24°C (75°F).
6. Keep parts from moving during cure. Contact pressure necessary. Maximum shear strength is obtained with a 3-5 mil bondline.
7. 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 sq. ft./gallon.

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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 necessary 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, 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 87°C (190°F) ± -12°C (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 65°C (150°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 65°C (150°F) ± -12°C (10°F).
5. If primer is to be used, it should be applied within 4 hours after surface preparation.

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 3M™ Scotch-Weld™ Metal Primer EC3901 or equivalent 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.

Application Equipment Suggestions

For smaller or intermittent applications, the 3M™ EPX Applicator 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.

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Storage Store products at 15-27°C (60-80°F) for maximum shelf life.

Shelf Life These products have a shelf life of two years in their unopened original bulk containers and 15 months in duo-pak containers from date of shipment.

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.

Technical Information The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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ISO 9001: 2000

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