



Technical Data Sheet

3M™ Scotch-Weld™ Flexible Acrylic Adhesive DP8625NS



[Product Details](#)



[Regulatory Info/SDS](#)

Product Description

3M™ Scotch-Weld™ DP8625 Adhesive is a flexible low odor, non-flammable, two-part acrylic structural adhesives with a 10:1 mix ratio.

Product Features

- Low-odor, non-flammable acrylic formulation
- 200% Tensile Elongation at Break
- Non-sag formulation resists running and slumping of adhesive
- Room temperature cure
- Contains spacer beads to control bond line thickness

Technical Information Note

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

Note: The following data is taken from tests conducted on limited production runs. 3M will continue to test samples from additional product runs and will issue a new data page if the test results change.

Typical Uncured Physical Properties

Attribute Name	Value
Color	Black ¹
Mix Ratio by Weight (B:A)	10:1
Mix Ratio by Volume (B:A)	10:1

¹ Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

Attribute Name	Temperature	Value
Base Color		Black
Accelerator Color		Gray
Base Density		1.1 g/cm ³ ¹
Accelerator Density		1.1 g/cm ³ ¹
Base Viscosity	22 °C (72 °F)	75000 - 175000 cP ²
Accelerator Viscosity	22 °C (72 °F)	5000 - 20000 cP ²

¹ Density measured using pycnometer.

² Viscosity measured using cone-and-plate viscometer; reported viscosity at 4 sec⁻¹ shear rate.

Typical Mixed Physical Properties

Attribute Name	Temperature	Value
Density (mixed)		1.1 g/cm ³
Viscosity		90,000 cP
Worklife		22 to 24 min ¹
Open Time		20 to 30 min ²
Set Time (min)	22 °C (72 °F)	35 to 40 min ³
Time to Structural Strength		50 to 60 min ⁴
Time to Full Cure	22 °C (72 °F)	24 h

- ¹ 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.
- ² Max time allowed after applying adhesive to a substrate before bond must be closed and fixed. Cure times approximate and depend on adhesive temperature. Hotmelts: The approx. bonding range of a 1/8" bead of molten adhesive on a non-metallic surface.
- ³ Minimum time required to achieve 50 psi of overlap shear strength. Cure times are approximate and depend on adhesive temperature.
- ⁴ Minimum time required to achieve 1,000 psi of overlap shear strength. Cure times are approximate and depend on adhesive temperature.

Typical Physical Properties

Attribute Name	Value
Cured Color	Black
Mixed Color	Black

Typical Cured Characteristics

Temperature: 22 °C (72 °F)

Attribute Name	Test Method	Value
Shore D Hardness	ASTM D2240	35

Typical Performance Characteristics

Overlap Shear Strength

Temperature: 22 °C (72 °F)

Test Method: ASTM D1002

Dwell Time	Test Condition	Substrate	Surface Prep	Value
24 h		Acrylic (PMMA)	Light Abrasion and Solvent Clean	172 lb/in ² ¹
24 h		Epoxy Resin (Fibre Reinforced)	Light Abrasion and Solvent Clean	490 lb/in ² ¹
24 h		Polyester (PET)	Light Abrasion and Solvent Clean	475 lb/in ² ¹
7 d		Aluminum	MEK/Abrade/MEK	855 lb/in ² ²
7 d		Cold Rolled Steel	MEK/Abrade/MEK	666 lb/in ² ²
24 h	@ -40°F(-40°C)	Aluminum	Light Abrasion and Solvent Clean	3,345 lb/in ² ¹
24 h	@ 180°F(82°C)	Aluminum	Light Abrasion and Solvent Clean	206 lb/in ² ¹

¹ 1min open time, 1/2in overlap, 0.010in bond line thickness, separation rate 0.1 in/min metals, 2 in/min plastics, abraded and solvent wiped substrates, 1/16in metals, 1/8in plastics
Cohesive (CF), Adhesive (AF), and Substrate (SF) Failure

² 1" wide 1/2" overlap samples, 1" x 4" substrates, bondline thickness 0.005-0.008in
Separation rate 0.1in/min metal, 2in/min plastic, 20in/min rubber.
Substrate thickness: steel 0.060in, other metal 0.05-0.064in, rubber 0.125in, plastic 0.125in
Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)

Temperature: 22 °C (72 °F)

Substrate: Etched Aluminum

Attribute Name	Value
Bell Peel	74 lb/in width ¹

¹ 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), Adhesive (AF) and Substrate (SF) Failure

Attribute Name	Value
Additional Test notes	<p>Note: This adhesive also has 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.</p> <p>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 this low odor acrylic adhesive, uncured adhesive on exposed surfaces does not evaporate away as quickly, leaving a tacky film of partially cured material. For manufacturing processes that need a tack-free surface quickly, such as for subsequent sanding or painting operations, consider instead using a standard MMA acrylic adhesive.</p>

Typical Environmental Performance

Substrate: Aluminum
 Temperature: 200 °C (392 °F)
 Dwell Time: 30 min

Attribute Name	Test Method	Value
Overlap Shear Strength	ASTM D1002	70 % ¹

¹ 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

Dispense Properties

Attribute Name	Value
Cleaning Recommendation	Excess uncured adhesive can be cleaned with methyl ethyl ketone (MEK)
Fillers	Product contains ceramic particles from 0.002" to 0.010"
Mixing Nozzle Recommendation	Quadro Mixing Nozzle Mix Elements: 16 Length (mm): 90 Volume (ml): 1.72 3M Stock #:7100202930 ¹

Attribute Name	Value
Mixing Nozzle Recommendation	Helical Mixing Nozzle Mix Elements: 18 Length (mm): 221.9 Volume (ml): 12.96 3M Stock #: 7100015959 (Helical Low waste Mixing Nozzle) Mix Elements: 24 Length (mm): 136.7 Volume (ml): 6.28 3M Stock #: 7100066351) ²
Packaging	45ml & 490ml cartridges 5 gallon pails 55 gal drums

¹ 50ml Cartridge

² 400ml Cartridge

Handling/Application Information

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™ Acrylic Adhesives are designed to be used on painted/coated metals, most bare metals, and most plastics and composite materials. 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.* Bare metals: 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 and composite materials: 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.* *Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

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™ Acrylic Adhesives have a shelf life of 12 months from date of manufacture in unopened original containers kept at recommended storage conditions.

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.

Automotive Disclaimer

Select Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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ISO Statement

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

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