

3M Scotch-Weld™ DP125 Gray Epoxy Adhesive

Category : Polymer , Thermoset , Epoxy , Epoxy Adhesive

Material Notes:

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. Information provided by 3M

Order this product through the following link:

http://www.lookpolymers.com/polymer_3M-Scotch-Weld-DP125-Gray-Epoxy-Adhesive.php

Physical Properties	Metric	English	Comments
Brookfield Viscosity	35000 - 75000 cP	35000 - 75000 cP	Base, RVF #7 spindle, 20 rpm @ 27°C
	45000 - 65000 cP	45000 - 65000 cP	Accelerator, RVF #7 spindle, 20 rpm @ 27°C

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	70	70	ASTM D2240
Tensile Strength at Break	22.8 MPa	3310 psi	ASTM D882
Elongation at Break	125 %	125 %	ASTM D882
Shear Strength	0.414 MPa	60.0 psi	Overlap, Polypropylene
	1.72 MPa	250 psi	Overlap, +3M Primer 3901
	2.76 MPa	400 psi	Overlap, Glass, Borosilicate
	3.59 MPa	520 psi	Overlap, ABS
	3.79 MPa	550 psi	Overlap, Acrylic
	5.17 MPa	750 psi	Overlap, PVC
	6.07 MPa	880 psi	Overlap, Polycarbonate
	6.21 MPa	900 psi	Overlap, Wood, Fir
	12.4 MPa	1800 psi	Overlap, Fiberglass
	13.1 MPa	1900 psi	Overlap, Cold Rolled Steel
15.2 MPa	2200 psi	Overlap, Sanded Aluminum	
23.4 MPa	3400 psi	Overlap, Etched Aluminum	
2.76 MPa	400 psi	Overlap	
@Temperature 82.0 °C	@Temperature 180 °F		

Mechanical Properties	3.10 MPa Metric	450 psi English	Comments
	@Temperature 66.0 °C	@Temperature 151 °F	
	4.83 MPa	700 psi	Overlap
	@Temperature 49.0 °C	@Temperature 120 °F	
	23.4 MPa	3400 psi	Overlap
	@Temperature -55.0 °C	@Temperature -67.0 °F	
	29.6 MPa	4300 psi	Overlap
	@Temperature 21.0 °C	@Temperature 69.8 °F	
Peel Strength	0.351 kN/m	2.00 pli	180°
	0.526 kN/m	3.00 pli	180°
	0.526 kN/m	3.00 pli	180°
	3.16 kN/m	18.0 pli	180°
	6.14 kN/m	35.0 pli	180°

Thermal Properties	Metric	English	Comments
CTE, linear	98.0 µm/m-°C	54.4 µin/in-°F	Below Tg
	@Temperature 5.00 - 20.0 °C	@Temperature 41.0 - 68.0 °F	
	187 µm/m-°C	104 µin/in-°F	Above Tg
	@Temperature 65.0 - 140 °C	@Temperature 149 - 284 °F	
Thermal Conductivity	0.151 W/m-K	1.05 BTU-in/hr-ft ² -°F	
	@Thickness 6.35 mm, Temperature 44.3 °C	@Thickness 0.250 in, Temperature 112 °F	
Glass Transition Temp, Tg	12.0 °C	53.6 °F	Onset
	23.0 °C	73.4 °F	Mid-Point

Electrical Properties	Metric	English	Comments
Volume Resistivity	1.00e+11 ohm-cm	1.00e+11 ohm-cm	ASTM D257
Dielectric Constant	6.3	6.3	ASTM D150
	@Frequency 1000 Hz	@Frequency 1000 Hz	
Dielectric Strength	26.8 kV/mm	680 kV/in	ASTM D149
	@Thickness 0.762 mm	@Thickness 0.0300 in	

Electrical Properties	Metric	English	Comments
Processing Properties	Metric	English	Comments
Cure Time	120 min	2.00 hour	Tack-free
	150 min	2.50 hour	Time to Handling Strength
	420 min	7.00 hour	Full

Descriptive Properties	Value	Comments
Appearance	Amber	Accelerator
	Gray	Base
	Gray	

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