

3M Scotch-Weld™ DP807 Acrylic Adhesives

Category : Polymer , Adhesive

Material Notes:

3M™ Scotch-Weld™ Acrylic Adhesive DP807 is a two-part, 1:1 mix ratio, toughened acrylic structural adhesives. They exhibit excellent shear and peel strengths along with good impact, durability and bond well to many metals, ceramics, wood and most plastics with minimal surface preparation. Information provided by 3M

Order this product through the following link:

http://www.lookpolymers.com/polymer_3M-Scotch-Weld-DP807-Acrylic-Adhesives.php

Physical Properties	Metric	English	Comments
Viscosity	>= 3500 cP	>= 3500 cP	Base
	>= 7500 cP	>= 7500 cP	Accelerator

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	70	70	
Shear Strength	6.03 MPa	875 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Toulene
	6.55 MPa	950 psi	Overlap, PC, Substrate Failure
	6.89 MPa	1000 psi	Overlap, ABS, Substrate Failure
	7.067 MPa	1025 psi	Overlap, Acrylic, Substrate Failure
	8.96 MPa	1300 psi	Overlap, PVC, Substrate Failure
	15.5 MPa	2250 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 66°C tap water
	17.9 MPa	2600 psi	Overlap, Cold-Rolled Steel - slightly oily, Cohesive Failure
	17.9 MPa	2600 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Unleaded gasoline
	19.13 MPa	2775 psi	Overlap, Green Fiberglass Reinforced Plastic, Adhesive Failure
	21.55 MPa	3125 psi	Overlap, Cold-Rolled Steel - solvent cleaned, Adhesive Failure
	21.7 MPa	3150 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 66°C and 80% RH
	27.9 MPa	4050 psi	Overlap, Stainless Steel, Adhesive Failure

Mechanical Properties	28.3 MPa Metric	4100 psi English	Overlap, Aluminum - abraded, 150 grit sandpaper, Adhesive Failure
	28.3 MPa	4100 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in IPA
	28.44 MPa	4125 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 20% bleach solution
	29.0 MPa	4200 psi	Overlap, Aluminum - etched, Adhesive Failure
	30.0 MPa	4350 psi	Overlap, Aluminum - bare, Adhesive Failure
	32.58 MPa	4725 psi	Overlap, Etched Aluminum cured for 7 days @ RT
	34.5 MPa	5000 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Diesel fuel
	35.5 MPa	5150 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 50% Anitfreeze
	5.69 MPa @Temperature 82.0 °C	825 psi @Temperature 180 °F	Overlap, Etched Aluminum
	13.8 MPa @Temperature -55.0 °C	2000 psi @Temperature -67.0 °F	Overlap, Etched Aluminum
	17.9 MPa @Temperature 49.0 °C	2600 psi @Temperature 120 °F	Overlap, Etched Aluminum
	29.48 MPa @Temperature 24.0 °C	4275 psi @Temperature 75.2 °F	Overlap, Etched Aluminum
Peel Strength	4.56 kN/m	26.0 pli	Etched Al/Etched Al after 1 week at RT cure

Electrical Properties	Metric	English	Comments
Dielectric Strength	138 kV/mm	3500 kV/in	ASTM D149

Processing Properties	Metric	English	Comments
Cure Time	240 - 1440 min	4.00 - 24.0 hour	Full cure

Descriptive Properties	Value	Comments
Appearance	Off-white	Base
	Pale yellow	

Descriptive Properties	Value	Comments
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