

## 3M Scotch-Weld™ EC-2815 B/A FR Epoxy Adhesive

Category : Polymer , Thermoset , Epoxy

### Material Notes:

3M Scotch-Weld Epoxy Adhesive EC-2815 B/A FR is a two-component epoxy adhesive with cure at room temperature or with additional heat to form a tough, impact-resistant bond. It has excellent adhesion to many metal, composite, and plastic substrates. The cured material meets the 14 CFR 25.853 (a) before and subsequent to environmental conditioning. Scotch-Weld EC-2815 B/A FR Adhesive is a non-sag, white adhesive that is designed for structural bonding of metal and composite structures and insert bonding. Information provided by 3M

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_3M-Scotch-Weld-EC-2815-BA-FR-Epoxy-Adhesive.php](http://www.lookpolymers.com/polymer_3M-Scotch-Weld-EC-2815-BA-FR-Epoxy-Adhesive.php)

Physical Properties	Metric	English	Comments
Density	1.10 - 1.30 g/cc	0.0397 - 0.0470 lb/in <sup>3</sup>	Uncured, Part A
	1.20 - 1.40 g/cc	0.0434 - 0.0506 lb/in <sup>3</sup>	Cured
	1.30 - 1.50 g/cc	0.0470 - 0.0542 lb/in <sup>3</sup>	Uncured, Part B
Solids Content	100 %	100 %	Part B
	100 %	100 %	Part A

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	56.5 MPa	8190 psi	cured for 16 hrs at 21-27°C + post cured for 1 hrs at 82°C; ASTM D638-10
Elongation at Break	3.4 %	3.4 %	cured for 16 hrs at 21-27°C + post cured for 1 hrs at 82°C; ASTM D638-10
Tensile Modulus	3.32 GPa	481 ksi	cured for 16 hrs at 21-27°C + post cured for 1 hrs at 82°C; ASTM D638-10
Compressive Strength	68.6 MPa	9950 psi	Peak Stress, cured for 16 hrs at 21-27°C + post cured for 1 hrs at 82°C, 13 mm/min; ASTM D695-10
Compressive Modulus	1.71 GPa	248 ksi	cured for 16 hrs at 21-27°C + post cured for 1 hrs at 82°C, 13 mm/min; ASTM D695-10
Shear Strength	13.1 MPa	1900 psi	with Scotch-Weld EW-5000; ASTM D1002-10
	@Temperature 82.0 °C	@Temperature 180 °F	
	23.4 MPa	3400 psi	with Scotch-Weld EW-5000; ASTM D1002-10
	@Temperature 71.0 °C	@Temperature 160 °F	
	23.4 MPa	3400 psi	No Primer; ASTM D1002-10

Mechanical Properties	@Temperature 71.0 °C Metric	@Temperature 160 °F English	Comments
	24.8 MPa	3600 psi	with Scotch-Weld EW-5000, 14 days at 71°C and 95% RH; ASTM D1002-10
	@Temperature 71.0 °C	@Temperature 160 °F	
	25.5 MPa	3700 psi	with Scotch-Weld EW-5000; ASTM D1002-10
	@Temperature -43.0 °C	@Temperature -45.4 °F	
	32.1 MPa	4650 psi	with Scotch-Weld EW-5000, 14 days at 71°C and 95% RH; ASTM D1002-10
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	34.5 MPa	5000 psi	with Scotch-Weld EW-5000; ASTM D1002-10
	@Temperature 24.0 °C	@Temperature 75.2 °F	
	34.5 MPa	5000 psi	No Primer; ASTM D1002-10
	@Temperature 24.0 °C	@Temperature 75.2 °F	
Peel Strength	5.78 kN/m	33.0 pli	with Scotch-Weld EW-5000; ASTM D3167-10

Processing Properties	Metric	English	Comments
Cure Time	60.0 min	1.00 hour	Full
	@Temperature 82.0 °C	@Temperature 180 °F	
	1440 min	24.0 hour	Full
	@Temperature 24.0 °C	@Temperature 75.2 °F	

Descriptive Properties	Value	Comments
Appearance	Gray	Part A
	White	Part B

## Contact Songhan Plastic Technology Co.,Ltd.

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