

## 3M Scotch-Weld™ DP825 Acrylic Adhesives

Category : Polymer , Adhesive

### Material Notes:

3M™ Scotch-Weld™ Acrylic Adhesive DP825 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-DP825-Acrylic-Adhesives.php](http://www.lookpolymers.com/polymer_3M-Scotch-Weld-DP825-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	5.52 MPa	800 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Toulene
	6.55 MPa	950 psi	Overlap, Acrylic, Substrate Failure
	6.89 MPa	1000 psi	Overlap, Etched Aluminum
	7.067 MPa	1025 psi	Overlap, PC, Substrate Failure
	7.24 MPa	1050 psi	Overlap, ABS, Substrate Failure
	9.65 MPa	1400 psi	Overlap, PVC, Substrate Failure
	15.00 MPa	2175 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 66°C tap water
	17.41 MPa	2525 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Unleaded gasoline
	17.9 MPa	2600 psi	Overlap, Cold-Rolled Steel - slightly oily, Cohesive Failure
	18.10 MPa	2625 psi	Overlap, Green Fiberglass Reinforced Plastic, Adhesive Failure
	18.10 MPa	2625 psi	Overlap, Etched Aluminum
	18.44 MPa	2675 psi	Overlap, Etched Aluminum
	20.86 MPa	3025 psi	Overlap, Cold-Rolled Steel - solvent cleaned, Adhesive Failure

Mechanical Properties	26.37 MPa Metric	3825 psi English	Overlap, Etched Aluminum tested after 1 week of Immersion in IPA
	26.5 MPa	3850 psi	Overlap, Aluminum - etched, Adhesive Failure
	26.72 MPa	3875 psi	Overlap, Stainless Steel, Adhesive Failure
	27.06 MPa	3925 psi	Overlap, Aluminum - abraded, 150 grit sandpaper, Adhesive Failure
	28.3 MPa	4100 psi	Overlap, Aluminum - bare, Adhesive Failure
	30.3 MPa	4400 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in Diesel fuel
	30.85 MPa	4475 psi	Overlap, Etched Aluminum
	32.1 MPa	4650 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 50% Anitfreeze
	33.1 MPa	4800 psi	Overlap, Etched Aluminum cured for 7 days @ RT
	33.4 MPa	4850 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 20% bleach solution
	46.9 MPa	6800 psi	Overlap, Etched Aluminum tested after 1 week of Immersion in 66°C and 80% RH
Peel Strength	4.91 kN/m	28.0 pli	Etched Al/Etched Al after 1 week at RT cure

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	
	Yellow	Accelerator

## Contact Songhan Plastic Technology Co.,Ltd.

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