



Scotch-Weld™

Structural Plastic Adhesive DP-8010

Easily bond hard-to-bond LSE plastics with minimal surface preparation and high shear/high peel strengths



Less expensive LSE (low surface energy) plastics, i.e. polypropylene and polyethylene, tend to be harder or more expensive to bond than engineering grade plastics. Now with 3M™ Scotch-Weld™ Structural Plastic Adhesive DP-8010, you can use those less costly plastics and avoid traditional assembly consequences. This specially formulated 2-part structural strength acrylic adhesive delivers savings and performance 8 ways:

1. Bonds hard-to-bond plastics with high shear and peel strengths while eliminating the pre-treatment time and costs of traditional adhesives.
2. Simplifies surface preparation to wiping off dust or oil.
3. Helps you use less expensive plastics and save in materials cost.
4. Eliminates the equipment cost associated with friction, vibration, and thermal welding.
5. Fills gaps in loose tolerance parts and saves on rework or mold redesign.
6. Eliminates unsightly mechanical fastening in many assemblies to save drilling, screwing, finishing, and other work while improving aesthetics.
7. Relieves mechanical fastener stress

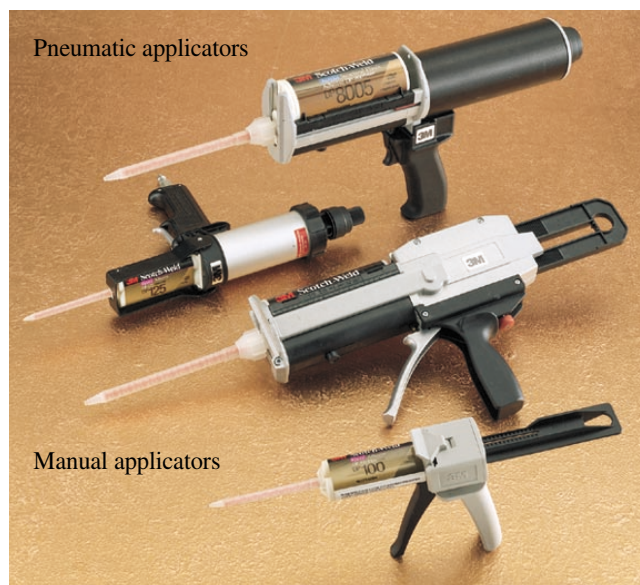
points by distributing stress over a large surface area.

8. Room temperature curing helps save the cost and space of ovens, heaters, and UV lamps.

It all adds up to value in structurally bonding the plastics listed above, and more such as thermoplastic elastomers (TPE's). You can also bond many plastics to dissimilar materials such as metal and glass.

Ten-minute open time gives you added assembly flexibility for alignment and repositioning. A non-sag version is also available for neat application on vertical or angled surfaces.

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Production versatility

To meet a wide range of production requirements, you can select 35ml and 250ml Duo-Pak cartridges for use with hand-held 3M™ EPX™ manual or pneumatic applicators. All are easy to load and use with heavy-duty construction for job site durability.

Bulk pails are also available for higher volume production.

Approximate Coverage by Size of Container

Bead Size	Linear ft per 35 ml*	Linear ft per 250 ml*	Linear ft per mixed gallon
1/2"	1.8	12.9	196
3/8"	3.0	23.0	350
1/4"	7.0	51.8	785
1/8"	28.9	206.7	3,130
1/16"	114.8	820.0	12,240

Note: This technical information and data should be considered representative or typical only and should not be used for specification purposes. * The amounts in the above table do not reflect waste associated with nozzle remnants or piston leveling.

Typical Uncured Physical Properties

Property	
Time to Handling Strength (50 psi @ 73°F (23°C))	1.5 - 2 hrs.
Full Cure Time @ 73°F (23°C)	8 - 24 hrs.
Worklife @ 73°F (23°C)	10 - 12 mins.

Application ideas

- Automotive and commercial vehicle TPO bumper fascia
- Polypropylene caps for seat rails
- Signs and displays
- Lawn and garden equipment
- Shopping carts
- POP dispensers and holders
- Picture frames
- Computer accessories
- Assembly of most plastic products where you need resistance to vibration, water, corrosion, and many chemicals

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which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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