

Substrate Selector

Step 1: Select Substrate **Step 2: Determine Key Attribute** **Step 3: Select Product** (see definitions below)

		Plastics/Paints/Coatings/Nylon		Rubber	Metals			Oily Metals		Composites		Concrete/Stone/Ceramics/Glass		Wood
		Low Surface Energy	General Purpose		Temperature and Solvent Resistant	Stainless Steel & Aluminum	Other Metals	Stainless Steel & Aluminum	Other Metals	Fiberglass/SMC	Epoxy	Indoor	Outdoor	
Plastics/Paints/Coatings/Nylon	Low Surface Energy	LSE Acrylic* Plastic & Rubber CA	LSE Acrylic* Plastic & Rubber CA	Plastic & Rubber CA*	N/A	LSE Acrylic	LSE Acrylic	LSE Acrylic	LSE Acrylic	LSE Acrylic Toughened CA*	LSE Acrylic Toughened CA*	LSE Acrylic	LSE Acrylic	LSE Acrylic Surface Insensitive CA*
	General Purpose	LSE Acrylic* Plastic & Rubber CA	LO Acrylic MMA Acrylic Plastic PUR Flexible Epoxy Plastic & Rubber CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy	LO Acrylic MMA Acrylic Flexible Epoxy Plastic PUR Plastic & Rubber CA	DP8407NS Toughened Epoxy Flexible Epoxy Plastic PUR Plastic & Rubber CA	LO Acrylic MMA Acrylic	DP8407NS	Semi-rigid Urethane MMA Acrylic LO Acrylic Flexible Epoxy Urethane Plastic PUR Toughened CA	Semi-rigid Urethane MMA Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR Toughened CA	Flexible Epoxy Rigid Urethane Flexible Urethane Plastic PUR	Flexible Epoxy Flexible Urethane Plastic PUR	Wood PUR Flexible Epoxy Rigid Urethane Surface Insensitive CA
Rubber		Plastic & Rubber CA*	Plastic & Rubber CA* Plastic PUR	Plastic & Rubber CA*	N/A	Flexible Epoxy Plastic PUR	Flexible Epoxy Plastic PUR	N/A	N/A	Plastic & Rubber CA* Plastic PUR	Plastic & Rubber CA* Plastic PUR	Flexible Epoxy Plastic PUR	Flexible Epoxy Plastic PUR	Surface Insensitive CA* Plastic PUR Flexible Epoxy
Metals	Temperature and Solvent Resistant	N/A	Toughened Epoxy Flexible Epoxy	N/A	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Flexible Epoxy	One-part Heat-cured Epoxy Toughened Epoxy	Heat-cured Epoxy	Heat-cured Epoxy	Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy	Flexible Epoxy	Toughened Epoxy Plastic PUR Flexible Epoxy
	Stainless Steel & Aluminum	LSE Acrylic	LO Acrylic MMA Acrylic Flexible Epoxy Plastic PUR Plastic & Rubber CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy	LO Acrylic MMA Acrylic Toughened Epoxy Flexible Epoxy Rigid Epoxy Toughened CA	Heat-cured Epoxy Toughened Epoxy	LO Acrylic MMA Acrylic	DP8407NS Heat-cured Epoxy	Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy MMA Acrylic LO Acrylic Plastic PUR Toughened CA	Toughened Epoxy Flexible Epoxy	Flexible Epoxy	Plastic PUR Toughened Epoxy Rigid Epoxy Flexible Epoxy Surface Insensitive CA
	Other Metals	LSE Acrylic	DP8407NS Toughened Epoxy Flexible Epoxy Plastic PUR Plastic & Rubber CA	Plastic & Rubber CA* Plastic PUR	Heat-cured Epoxy Toughened Epoxy	Heat-cured Epoxy Toughened Epoxy	Toughened Epoxy Flexible Epoxy Heat-cured Epoxy DP810	DP8407NS Heat-cured Epoxy	DP8407NS Heat-cured Epoxy	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy Heat-cured Epoxy Plastic PUR	Toughened Epoxy Heat-cured Epoxy	Flexible Epoxy	Plastic PUR Toughened Epoxy
Oily Metals	Stainless Steel & Aluminum	LSE Acrylic	LO Acrylic MMA Acrylic	N/A	Heat-cured Epoxy	LO Acrylic MMA Acrylic	DP8407NS Heat-cured Epoxy	LO Acrylic MMA Acrylic	DP8407NS	MMA Acrylic LO Acrylic	MMA Acrylic LO Acrylic Heat-cured Epoxy	N/A	N/A	N/A
	Other Metals	LSE Acrylic	DP8407NS	N/A	Heat-cured Epoxy	DP8407NS Heat-cured Epoxy	DP8407NS Heat-cured Epoxy	DP8407NS	DP8407NS Heat-cured Epoxy	DP8407NS	Heat-cured Epoxy	N/A	N/A	N/A
Composites	Fiberglass/SMC	LSE Acrylic Toughened CA*	Semi-rigid Urethane MMA Acrylic LO Acrylic Flexible Epoxy Urethane Plastic PUR Toughened CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	MMA Acrylic LO Acrylic	DP8407NS	Semi-rigid Urethane MMA Acrylic LO Acrylic Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy Rigid Urethane Flexible Epoxy Plastic PUR
	Epoxy	LSE Acrylic Toughened CA*	Semi-rigid Urethane MMA Acrylic Flexible Epoxy Toughened Epoxy Plastic PUR Toughened CA	Plastic & Rubber CA* Plastic PUR	Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy MMA Acrylic LO Acrylic Plastic PUR Toughened CA	Toughened Epoxy Flexible Epoxy Heat Cured Epoxy Plastic PUR	MMA Acrylic LO Acrylic Heat Cured Epoxy	Heat Cured Epoxy	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Toughened Epoxy Flexible Epoxy Plastic PUR Toughened CA	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR
Concrete/Stone/Ceramics/Glass	Indoor	LSE Acrylic	Flexible Epoxy Rigid Urethane Flexible Urethane Plastic PUR	Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Flexible Epoxy	Toughened Epoxy Heat Cured Epoxy	N/A	N/A	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Toughened Epoxy Flexible Epoxy Rigid Urethane Flexible Urethane	Flexible Epoxy Flexible Urethane	Flexible Epoxy Plastic PUR Flexible Urethane
	Outdoor	LSE Acrylic	Flexible Epoxy Flexible Urethane Plastic PUR	Flexible Epoxy Plastic PUR	Flexible Epoxy	Flexible Epoxy	Flexible Epoxy	N/A	N/A	Semi-rigid Urethane Flexible Epoxy Flexible Urethane Plastic PUR	Semi-rigid Urethane Flexible Epoxy Plastic PUR	Flexible Epoxy Flexible Urethane	Flexible Epoxy Flexible Urethane	Flexible Epoxy Plastic PUR Flexible Urethane
Wood		LSE Acrylic Surface Insensitive CA*	Wood PUR Flexible Epoxy Rigid Urethane Surface Insensitive CA	Plastic PUR Surface Insensitive CA*	Toughened Epoxy Plastic PUR Flexible Epoxy	Plastic PUR Toughened Epoxy Rigid Epoxy Surface Insensitive CA	Plastic PUR Toughened Epoxy	N/A	N/A	Semi-rigid Urethane Toughened Epoxy Rigid Urethane Flexible Epoxy Plastic PUR	Semi-rigid Urethane Toughened Epoxy Flexible Epoxy Plastic PUR	Flexible Epoxy Plastic PUR Flexible Urethane	Flexible Epoxy Plastic PUR Flexible Urethane	Wood PUR Rigid Epoxy Toughened Epoxy Rigid Urethane Surface Insensitive CA

 **BEST IN CLASS PRODUCT**  **SUGGESTED ALTERNATE PRODUCT** *with primer

3M™ Scotch-Weld™ Standard MMA Acrylics

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel PL (N/cm) at 75°F (24°C)	Overlap Shear: psi (MPa)			Size	UPC	Stock #
							-20°F (-29°C)	75°F (24°C)	180°F (82°C)			
DP805 (Off-White)	Fast strength build Minimal surface prep	1:1	110,000	3 minutes	10 minutes	35 (62)	2,500 (17)	3,500 (24)	2,200 (15)	48.5mL 200mL	00-638060-08982-8 00-021200-87828-2	7010410436 7010367390
DP820 (Light Yellow)	Tough durable bonds Minimal surface prep	1:1	55,000	15 minutes	40 minutes	20 (36)	3,100 (21)	3,150 (22)	1,900 (13)	48.5mL 200mL 400mL	00-638060-08977-4 00-021200-89348-3 00-021200-89349-0	7010412194 7010329704 7000121258
DP8405NS 8405NS (Green)	High impact Adhesion to most plastics	10:1	70,000	5 minutes	15 minutes	50 (89)	2,600 (18)	4,100 (28)	900 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-68963-5 00-051115-68964-2 00-051115-68981-9 00-051115-68986-4 00-051115-68980-2 00-051115-68987-1	7100009688 7100011056 7100102180 7100027430 7100101506 7100084534
DP8407NS 8407NS (Gray)	High impact Adhesion to most plastics	10:1	20,000	7 minutes	24 minutes	50 (89)	3,400 (23)	4,500 (31)	1,400 (10)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A	00-638060-14631-6 00-638060-14643-9 00-638060-14658-3 00-076308-86306-7 00-638061-14659-0	7100179482 7100179480 7100179264 7100105384 7100179442
DP8410NS 8410NS (Green)	High impact Adhesion to most plastics	10:1	70,000	10 minutes	25 minutes	50 (89)	3,600 (25)	4,100 (28)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-70994-4 00-051115-70995-1 00-051115-68981-9 00-051115-70997-5 00-051115-68980-2 00-051115-71101-5	7100024055 7100024045 7100102180 7100064830 7100101506 7100084532
DP8425NS 8425NS (Green)	High impact Adhesion to most plastics	10:1	70,000	25 minutes	50 minutes	50 (89)	3,800 (26)	3,700 (26)	800 (6)	45mL 490mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-81303-0 00-051115-81302-3 00-051115-68981-9 0-00-68060-00072-9 00-051115-81414-3 00-051115-81031-6	7100078165 7100078166 7100102180 7100255721 7100101506 7100084535

3M™ Scotch-Weld™ Low Odor Acrylics

DP8705NS 8705NS (Black)	Low odor Fast rate of strength build	10:1	80,000	5 minutes	6 minutes	34 (60)	4,350 (30) at -40°C	2,320 (16)	580 (4)	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40963-3 00-638060-40964-0 00-638060-40862-9 00-638060-40863-6 00-638060-40965-7 00-638060-40966-4	7100245036 7100245039 7100233358 7100234571 7100245037 7100245038
DP8710NS 8710NS (Black)	Low odor Fast rate of strength build	10:1	80,000	10 minutes	13 minutes	34 (60)	4,350 (30) at -40°C	2,320 (16)	580 (4)	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40865-0 00-638060-40866-7 00-638060-40862-9 00-638060-40863-6 00-638060-40867-4 00-638060-40868-1	7100233349 7100233348 7100233358 7100234571 7100234572 7100233166
DP8725NS 8725NS (Black)	Low odor Fast rate of strength build	10:1	80,000	23 minutes	25 minutes	34 (60)	4,350 (30) at -40°C	2,320 (16)	580 (4)	45mL 490mL 1 gal. pail A 5 gal. pail A 5 gal. drum B 50 gal. drum B	00-638060-40967-1 00-638060-40968-8 00-638060-40862-9 00-638060-40863-6 00-638060-40969-5 00-638060-40971-8	7100244858 7100244480 7100233358 7100234571 7100244861 7100244862
DP810 810 (Black)	Tough durable bond High impact resistance	1:1	20,000	10 minutes	20 minutes	30 (53)	1,200 (8)	3,600 (25)	500 (3)	48.5mL 200mL 1 gallon pail A 1 gallon pail B 4.4 gal. pail A 4.4 gal. pail B	00-638060-08967-5 00-021200-49079-8 00-048011-56712-9 00-048011-56711-2 00-021200-49081-1 00-021200-49080-4	7100148732 7100142848 7000046401 7000046385 7010365969 7010329544
DP810 810 (Tan)	Tough durable bonds High impact resistance	1:1	20,000	10 minutes	20 minutes	30 (53)	1,200 (8)	3,600 (25)	500 (3)	48.5mL 200mL 400mL 4.4 gal. pail A 4.4 gal. pail B	00-638060-08968-6 00-021200-31311-0 00-021200-31312-7 00-021200-45233-8 00-021200-45230-7	7100148757 7000121267 7000121266 7100077450 7100077451
DP810NS 810NS (Tan)	Tough durable bonds Non-sag	1:1	95,000	10 minutes	20 minutes	20 (36)	1,200 (8)	4,000 (28)	500 (3)	48.5mL 200mL 400mL 4.4 gal. pail A 4.4 gal. pail B	00-638060-08969-9 00-021200-49084-2 00-021200-49083-5 00-638060-14110-6 00-021200-49085-9	7100148748 7100069365 7100069366 7100160337 7000121240

For lead times on bulk adhesives, please contact your 3M representative.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

KEY PRODUCT Denotes product to consider first in this category

***** After Key Products, consider these.

Strong performance in extreme temperatures