



## Material Safety Data Sheet

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**PRODUCT NAME:** 3M™ Scotch-Weld™ Epoxy Adhesive DP-100, Clear  
**MANUFACTURER:** 3M  
**DIVISION:** Industrial Adhesives and Tapes Division

**ADDRESS:** 3M Center  
St. Paul, MN 55144-1000

**EMERGENCY PHONE: 1-800-364-3577 or (651) 737-6501 (24 hours)**

**Issue Date:** 04/23/10  
**Supersedes Date:** 01/31/06

**Document Group:** 11-3180-4

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62-3575-1430-6, 62-3575-1435-5, 62-3575-1436-3, 62-3575-1439-7, 62-3575-2530-2, 62-3575-3530-1, 62-3575-3830-5, 62-3575-3835-4, 62-3575-9930-7

**This product is a kit or a multipart product which consists of multiple, independently packaged components. An MSDS for each of these components is included. Please do not separate the component MSDSs from this cover page. The document numbers of the MSDSs for components of this product are:**

10-3337-2, 10-3341-4

### Revision Changes:

Copyright was modified.

Kit: Component document group number(s) was modified.

Page Heading: Product name was modified.

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Kit: Division name was modified.

Kit: ID Number Heading was added.

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## Material Safety Data Sheet

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### SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

**PRODUCT NAME:** 3M(TM) Scotch-Weld(TM) Epoxy Adhesive DP-100 Clear (Part B)

**MANUFACTURER:** 3M

**DIVISION:** Industrial Adhesives and Tapes

**ADDRESS:** 3M Center  
St. Paul, MN 55144-1000

EMERGENCY PHONE: 1-800-364-3577 or (651) 737-6501 (24 hours)

**Issue Date:** 06/16/2005

**Supersedes Date:** 06/25/2001

**Document Group:** 10-3337-2

**Product Use:**

Specific Use: base for 2 part epoxy adhesive

### SECTION 2: INGREDIENTS

<u>Ingredient</u>	<u>C.A.S. No.</u>	<u>% by Wt</u>
EPOXY RESIN	25068-38-6	100

### SECTION 3: HAZARDS IDENTIFICATION

#### 3.1 EMERGENCY OVERVIEW

**Specific Physical Form:** Viscous

**Odor, Color, Grade:** light straw colored, epoxy odor

**General Physical Form:** Liquid

**Immediate health, physical, and environmental hazards:** May cause allergic skin reaction.

#### 3.2 POTENTIAL HEALTH EFFECTS

**Eye Contact:**

Moderate Eye Irritation: Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

Vapors released during curing may cause eye irritation. Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

Dust created by cutting, grinding, sanding, or machining may cause eye irritation. Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

**Skin Contact:**

Moderate Skin Irritation: Signs/symptoms may include localized redness, swelling, itching, and dryness.

Prolonged or repeated exposure may cause:

Allergic Skin Reaction (non-photo induced): Signs/symptoms may include redness, swelling, blistering, and itching.

**Inhalation:**

Vapors released during curing may cause irritation of the respiratory system. Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

Dust from cutting, grinding, sanding or machining may cause irritation of the respiratory system. Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

**Ingestion:**

Gastrointestinal Irritation: Signs/symptoms may include abdominal pain, stomach upset, nausea, vomiting and diarrhea.

## SECTION 4: FIRST AID MEASURES

### 4.1 FIRST AID PROCEDURES

The following first aid recommendations are based on an assumption that appropriate personal and industrial hygiene practices are followed.

**Eye Contact:** Flush eyes with large amounts of water. If signs/symptoms persist, get medical attention.

**Skin Contact:** Remove contaminated clothing and shoes. Immediately flush skin with large amounts of water. Get medical attention. Wash contaminated clothing and clean shoes before reuse.

**Inhalation:** If signs/symptoms develop, remove person to fresh air. If signs/symptoms persist, get medical attention.

**If Swallowed:** Do not induce vomiting unless instructed to do so by medical personnel. Give victim two glasses of water. Never give anything by mouth to an unconscious person. Get medical attention.

## SECTION 5: FIRE FIGHTING MEASURES

### 5.1 FLAMMABLE PROPERTIES

**Autoignition temperature**

*No Data Available*

**Flash Point**

249 °C [*Test Method: Pensky-Martens Closed Cup*]

**Flammable Limits - LEL**

*Not Applicable*

Flammable Limits - UEL

*Not Applicable*

## 5.2 EXTINGUISHING MEDIA

Ordinary combustible material. Use fire extinguishers with class A extinguishing agents (e.g., water, foam).

## 5.3 PROTECTION OF FIRE FIGHTERS

**Special Fire Fighting Procedures:** Water may be used to blanket the fire. Wear full protective equipment (Bunker Gear) and a self-contained breathing apparatus (SCBA).

**Unusual Fire and Explosion Hazards:** Not applicable.

**Note:** See STABILITY AND REACTIVITY (SECTION 10) for hazardous combustion and thermal decomposition information.

## SECTION 6: ACCIDENTAL RELEASE MEASURES

**Accidental Release Measures:** Observe precautions from other sections. Call 3M- HELPS line (1-800-364-3577) for more information on handling and managing the spill. Evacuate unprotected and untrained personnel from hazard area. The spill should be cleaned up by qualified personnel. Ventilate the area with fresh air. For large spill, or spills in confined spaces, provide mechanical ventilation to disperse or exhaust vapors, in accordance with good industrial hygiene practice. Warning! A motor could be an ignition source and could cause flammable gases or vapors in the spill area to burn or explode. Contain spill. Collect as much of the spilled material as possible. Clean up residue. Place in a closed container approved for transportation by appropriate authorities. Dispose of collected material as soon as possible.

**In the event of a release of this material, the user should determine if the release qualifies as reportable according to local, state, and federal regulations.**

## SECTION 7: HANDLING AND STORAGE

### 7.1 HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Avoid breathing of dust created by cutting, sanding, grinding or machining. Avoid contact with oxidizing agents.

### 7.2 STORAGE

Store away from acids. Store away from oxidizing agents.

## SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

### 8.1 ENGINEERING CONTROLS

Provide ventilated enclosure for heat curing. Provide appropriate local exhaust for cutting, grinding, sanding or machining. Curing enclosures must be exhausted to outdoors or to a suitable emission control device.

### 8.2 PERSONAL PROTECTIVE EQUIPMENT (PPE)

#### 8.2.1 Eye/Face Protection

Avoid eye contact.

The following eye protection(s) are recommended: Safety Glasses with side shields, Indirect Vented Goggles.

**8.2.2 Skin Protection**

Avoid skin contact. Do not cure up a mass of combined material larger than 50 grams to prevent the possibility of exotherm.

Select and use gloves and/or protective clothing to prevent skin contact based on the results of an exposure assessment. Consult with your glove and/or protective clothing manufacturer for selection of appropriate compatible materials.

Gloves made from the following material(s) are recommended: Polyethylene/Ethylene Vinyl Alcohol.

**8.2.3 Respiratory Protection**

Avoid breathing of dust created by cutting, sanding, grinding or machining.

Select one of the following NIOSH approved respirators based on airborne concentration of contaminants and in accordance with OSHA regulations: Half facepiece or fullface air-purifying respirator with P100 particulate filters, Half facepiece or fullface air-purifying respirator with P95 particulate filters, Half facepiece or fullface air-purifying respirator with N95 particulate filters.

Consult the current 3M Respiratory Selection Guide for additional information or call 1-800-243-4630 for 3M technical assistance.

**8.2.4 Prevention of Swallowing**

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water.

**8.3 EXPOSURE GUIDELINES**

None Established

**SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES**

<b>Specific Physical Form:</b>	Viscous
<b>Odor, Color, Grade:</b>	light straw colored, epoxy odor
<b>General Physical Form:</b>	Liquid
<b>Autoignition temperature</b>	<i>No Data Available</i>
<b>Flash Point</b>	249 °C [ <i>Test Method:</i> Pensky-Martens Closed Cup]
<b>Flammable Limits - LEL</b>	<i>Not Applicable</i>
<b>Flammable Limits - UEL</b>	<i>Not Applicable</i>
<b>Boiling point</b>	>=249 °C
<b>Density</b>	1.17 g/ml
<b>Vapor Density</b>	<i>Not Applicable</i>
<b>Vapor Pressure</b>	<=0.03 mmHg [ <i>@ 70 °C</i> ]
<b>Specific Gravity</b>	1.17
<b>pH</b>	<i>Not Applicable</i>
<b>Melting point</b>	<i>Not Applicable</i>
<b>Solubility in Water</b>	Nil
<b>Evaporation rate</b>	<i>Not Applicable</i>
<b>Volatile Organic Compounds</b>	0 g/l
<b>VOC Less H2O &amp; Exempt Solvents</b>	0 g/l
<b>Viscosity</b>	10000 - 30000 centipoise [ <i>@ 73.400000000 °F</i> ] [ <i>Details:</i> MITS data]

**SECTION 10: STABILITY AND REACTIVITY**

**Stability:** Stable.

**Materials and Conditions to Avoid:** Strong acids; Strong oxidizing agents; Heat is generated during cure. Do not cure a mass larger

than 50 grams in a confined space to prevent a premature reaction (exotherm) with production of intense heat and smoke.

**Hazardous Polymerization:** Hazardous polymerization will not occur.

### Hazardous Decomposition or By-Products

<u>Substance</u>	<u>Condition</u>
Aldehydes	During Combustion
Carbon monoxide	During Combustion
Carbon dioxide	During Combustion
Ketones	During Combustion

## SECTION 11: TOXICOLOGICAL INFORMATION

Please contact the address listed on the first page of the MSDS for Toxicological Information on this material and/or its components.

## SECTION 12: ECOLOGICAL INFORMATION

### ECOTOXICOLOGICAL INFORMATION

Not determined.

### CHEMICAL FATE INFORMATION

Not determined.

## SECTION 13: DISPOSAL CONSIDERATIONS

**Waste Disposal Method:** Dispose of completely cured (or polymerized) wastes in a sanitary landfill. Incinerate in an industrial or commercial facility in the presence of a combustible material. As a disposal alternative, incinerate uncured product in an industrial or commercial incinerator in the presence of a combustible material.

**EPA Hazardous Waste Number (RCRA):** Not regulated

Since regulations vary, consult applicable regulations or authorities before disposal.

## SECTION 14: TRANSPORT INFORMATION

DP-100

Not regulated per U.S. DOT, IATA or IMO.

*These transportation classifications are provided as a customer service. As the shipper YOU remain responsible for complying with all applicable laws and regulations, including proper transportation classification and packaging. 3M's*

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## SECTION 15: REGULATORY INFORMATION

### US FEDERAL REGULATIONS

Contact 3M for more information.

#### 311/312 Hazard Categories:

Fire Hazard - No Pressure Hazard - No Reactivity Hazard - No Immediate Hazard - Yes Delayed Hazard - No

### STATE REGULATIONS

Contact 3M for more information.

### CHEMICAL INVENTORIES

The components of this product are in compliance with the chemical notification requirements of TSCA.

All applicable chemical ingredients in this material are listed on the European Inventory of Existing Chemical Substances (EINECS), or are exempt polymers whose monomers are listed on EINECS.

Contact 3M for more information.

**Additional Information:** This Base (Mfg. #EC-3575) used with Scotch-Weld DP-100 Part A Clear Epoxy Adh.; (Mfg. #EC-3675 - MSDS DOC #1033414).

### INTERNATIONAL REGULATIONS

Contact 3M for more information.

**This MSDS has been prepared to meet the U.S. OSHA Hazard Communication Standard, 29 CFR 1910.1200.**

## SECTION 16: OTHER INFORMATION

#### NFPA Hazard Classification

Health: 2 Flammability: 1 Reactivity: 1 Special Hazards: None



National Fire Protection Association (NFPA) hazard ratings are designed for use by emergency response personnel to address the hazards that are presented by short-term, acute exposure to a material under conditions of fire, spill, or similar emergencies. Hazard ratings are primarily based on the inherent physical and toxic properties of the material but also include the toxic properties of combustion or decomposition products that are known to be generated in significant quantities.

No revision information is available.

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### SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

**PRODUCT NAME:** 3M™ Scotch-Weld™ Epoxy Adhesive DP-100 Clear (Part A)

**MANUFACTURER:** 3M

**DIVISION:** Industrial Adhesives and Tapes Division

**ADDRESS:** 3M Center  
St. Paul, MN 55144-1000

EMERGENCY PHONE: 1-800-364-3577 or (651) 737-6501 (24 hours)

**Issue Date:** 01/06/10

**Supersedes Date:** 06/16/05

**Document Group:** 10-3341-4

**Product Use:**

Specific Use: Accelerator for 2 part epoxy adhesive  
Intended Use: Structural adhesive

### SECTION 2: INGREDIENTS

<u>Ingredient</u>	<u>C.A.S. No.</u>	<u>% by Wt</u>
MERCAPTAN POLYMER N.J.T.S. Reg. No. 04499600-6776	Trade Secret	80 - 95
2,4,6-TRIS([DIMETHYLAMINO]METHYL) PHENOL	90-72-2	7 - 13

### SECTION 3: HAZARDS IDENTIFICATION

#### 3.1 EMERGENCY OVERVIEW

**Specific Physical Form:** Viscous

**Odor, Color, Grade:** dark amber, strong mercaptan odor

**General Physical Form:** Liquid

**Immediate health, physical, and environmental hazards:**

#### 3.2 POTENTIAL HEALTH EFFECTS

**Eye Contact:**

Moderate Eye Irritation: Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

Vapors released during curing may cause eye irritation. Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

Dust created by cutting, grinding, sanding, or machining may cause eye irritation. Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

**Skin Contact:**

Moderate Skin Irritation: Signs/symptoms may include localized redness, swelling, itching, and dryness.

**Inhalation:**

Respiratory Tract Irritation: Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

Dust from cutting, grinding, sanding or machining may cause irritation of the respiratory system. Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

**Ingestion:**

Gastrointestinal Irritation: Signs/symptoms may include abdominal pain, stomach upset, nausea, vomiting and diarrhea.

## SECTION 4: FIRST AID MEASURES

### 4.1 FIRST AID PROCEDURES

The following first aid recommendations are based on an assumption that appropriate personal and industrial hygiene practices are followed.

**Eye Contact:** Flush eyes with large amounts of water. If signs/symptoms persist, get medical attention.

**Skin Contact:** Remove contaminated clothing and shoes. Immediately flush skin with large amounts of water. Get medical attention. Wash contaminated clothing and clean shoes before reuse.

**Inhalation:** Remove person to fresh air. If signs/symptoms develop, get medical attention.

**If Swallowed:** Do not induce vomiting unless instructed to do so by medical personnel. Give victim two glasses of water. Never give anything by mouth to an unconscious person. Get medical attention.

## SECTION 5: FIRE FIGHTING MEASURES

### 5.1 FLAMMABLE PROPERTIES

**Autoignition temperature**

*No Data Available*

Flash Point	257 °C [ <i>Test Method:</i> Closed Cup]
Flammable Limits - LEL	<i>Not Applicable</i>
Flammable Limits - UEL	<i>Not Applicable</i>

## 5.2 EXTINGUISHING MEDIA

Ordinary combustible material. Use fire extinguishers with class A extinguishing agents (e.g., water, foam).

## 5.3 PROTECTION OF FIRE FIGHTERS

**Special Fire Fighting Procedures:** Water may be used to blanket the fire. Wear full protective equipment (Bunker Gear) and a self-contained breathing apparatus (SCBA).

**Unusual Fire and Explosion Hazards:** Not applicable.

**Note:** See STABILITY AND REACTIVITY (SECTION 10) for hazardous combustion and thermal decomposition information.

## SECTION 6: ACCIDENTAL RELEASE MEASURES

### Accidental Release Measures:

Dispose of collected material as soon as possible.

Observe precautions from other sections. Call 3M- HELPS line (1-800-364-3577) for more information on handling and managing the spill. Collect as much of the spilled material as possible. Clean up residue with an appropriate solvent selected by a qualified and authorized person. Ventilate the area with fresh air. Read and follow safety precautions on the solvent label and MSDS.

**In the event of a release of this material, the user should determine if the release qualifies as reportable according to local, state, and federal regulations.**

## SECTION 7: HANDLING AND STORAGE

### 7.1 HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Avoid breathing of dust created by cutting, sanding, grinding or machining. Avoid contact with oxidizing agents.

### 7.2 STORAGE

Store away from oxidizing agents.

## SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

### 8.1 ENGINEERING CONTROLS

Provide ventilated enclosure for heat curing. Provide appropriate local exhaust for cutting, grinding, sanding or machining. Curing enclosures must be exhausted to outdoors or to a suitable emission control device.

### 8.2 PERSONAL PROTECTIVE EQUIPMENT (PPE)

#### 8.2.1 Eye/Face Protection

Avoid eye contact.

The following eye protection(s) are recommended: Safety Glasses with side shields, Indirect Vented Goggles.

**8.2.2 Skin Protection**

Avoid skin contact. Do not cure up a mass of combined material larger than 50 grams to prevent the possibility of exotherm.

Select and use gloves and/or protective clothing to prevent skin contact based on the results of an exposure assessment. Consult with your glove and/or protective clothing manufacturer for selection of appropriate compatible materials.

Gloves made from the following material(s) are recommended: Polyethylene/Ethylene Vinyl Alcohol.

**8.2.3 Respiratory Protection**

Avoid breathing of dust created by cutting, sanding, grinding or machining.

Select one of the following NIOSH approved respirators based on airborne concentration of contaminants and in accordance with OSHA regulations: Half facepiece or fullface air-purifying respirator with P100 particulate filters, Half facepiece or fullface air-purifying respirator with P95 particulate filters, Half facepiece or fullface air-purifying respirator with N95 particulate filters.

Consult the current 3M Respiratory Selection Guide for additional information or call 1-800-243-4630 for 3M technical assistance.

**8.2.4 Prevention of Swallowing**

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water.

**8.3 EXPOSURE GUIDELINES**

<u>Ingredient</u>	<u>Authority</u>	<u>Type</u>	<u>Limit</u>	<u>Additional Information</u>
2,4,6-TRIS([DIMETHYLAMINO]METHYL) PHENOL	CMRG	TWA	5 ppm	

**SOURCE OF EXPOSURE LIMIT DATA:**

ACGIH: American Conference of Governmental Industrial Hygienists

CMRG: Chemical Manufacturer Recommended Guideline

OSHA: Occupational Safety and Health Administration

AIHA: American Industrial Hygiene Association Workplace Environmental Exposure Level (WEEL)

**SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES**

<b>Specific Physical Form:</b>	Viscous
<b>Odor, Color, Grade:</b>	dark amber, strong mercaptan odor
<b>General Physical Form:</b>	Liquid
<b>Autoignition temperature</b>	<i>No Data Available</i>
<b>Flash Point</b>	257 °C [ <i>Test Method: Closed Cup</i> ]
<b>Flammable Limits - LEL</b>	<i>Not Applicable</i>
<b>Flammable Limits - UEL</b>	<i>Not Applicable</i>
<b>Boiling point</b>	>=257 °C
<b>Density</b>	1.15 g/ml
<b>Vapor Density</b>	<i>Not Applicable</i>
<b>Vapor Pressure</b>	<i>No Data Available</i>
<b>Vapor Pressure</b>	Negligible
<b>Specific Gravity</b>	1.15
<b>pH</b>	<i>Not Applicable</i>
<b>Melting point</b>	<i>Not Applicable</i>
<b>Solubility in Water</b>	Negligible
<b>Evaporation rate</b>	<i>Not Applicable</i>

Hazardous Air Pollutants	0 % weight
Volatile Organic Compounds	0 % weight
Kow - Oct/Water partition coef	No Data Available
Percent volatile	0 % weight
VOC Less H2O & Exempt Solvents	0 g/l
Viscosity	8000 - 15000 centipoise [@ 73 °F]

## SECTION 10: STABILITY AND REACTIVITY

**Stability:** Stable.

### Materials and Conditions to Avoid:

#### 10.1 Conditions to avoid

Heat is generated during cure. Do not cure a mass larger than 50 grams in a confined space to prevent a premature reaction (exotherm) with production of intense heat and smoke.

#### 10.2 Materials to avoid

Strong oxidizing agents

**Hazardous Polymerization:** Hazardous polymerization will not occur.

### Hazardous Decomposition or By-Products

<u>Substance</u>	<u>Condition</u>
Carbon monoxide	During Combustion
Carbon dioxide	During Combustion
Hydrogen Sulfide	During Combustion
Oxides of Nitrogen	During Combustion
Oxides of Sulfur	During Combustion

## SECTION 11: TOXICOLOGICAL INFORMATION

Please contact the address listed on the first page of the MSDS for Toxicological Information on this material and/or its components.

## SECTION 12: ECOLOGICAL INFORMATION

### ECOTOXICOLOGICAL INFORMATION

Not determined.

### CHEMICAL FATE INFORMATION

Not determined.

## SECTION 13: DISPOSAL CONSIDERATIONS

**Waste Disposal Method:** Dispose of completely cured (or polymerized) wastes in a sanitary landfill. As a disposal alternative, incinerate uncured product in an industrial or commercial incinerator in the presence of a combustible material.

**EPA Hazardous Waste Number (RCRA):** Not regulated

Since regulations vary, consult applicable regulations or authorities before disposal.

## SECTION 14: TRANSPORT INFORMATION

DP-100

Not regulated per U.S. DOT, IATA or IMO.

*These transportation classifications are provided as a customer service. As the shipper YOU remain responsible for complying with all applicable laws and regulations, including proper transportation classification and packaging. 3M's transportation classifications are based on product formulation, packaging, 3M policies and 3M's understanding of applicable current regulations. 3M does not guarantee the accuracy of this classification information. This information applies only to transportation classification and **not the packaging, labeling, or marking requirements**. The original 3M package is certified for U.S. ground shipment only. If you are shipping by air or ocean, the package may not meet applicable regulatory requirements.*

## SECTION 15: REGULATORY INFORMATION

### US FEDERAL REGULATIONS

Contact 3M for more information.

#### 311/312 Hazard Categories:

Fire Hazard - No    Pressure Hazard - No    Reactivity Hazard - No    Immediate Hazard - Yes    Delayed Hazard - No

### STATE REGULATIONS

Contact 3M for more information.

### CHEMICAL INVENTORIES

The components of this product are in compliance with the chemical notification requirements of TSCA.

All applicable chemical ingredients in this material are listed on the European Inventory of Existing Chemical Substances (EINECS), or are exempt polymers whose monomers are listed on EINECS.

Contact 3M for more information.

**Additional Information:** This Accelerator (Mfg #EC-3675) used with Scotch-Weld DP-100 Part B Clear Epoxy Adh.; (Mfg. #EC-3575 - MSDS DOC #1033372).

## **INTERNATIONAL REGULATIONS**

Contact 3M for more information.

**This MSDS has been prepared to meet the U.S. OSHA Hazard Communication Standard, 29 CFR 1910.1200.**

## **SECTION 16: OTHER INFORMATION**

### **NFPA Hazard Classification**

**Health: 2 Flammability: 1 Reactivity: 1 Special Hazards: None**

National Fire Protection Association (NFPA) hazard ratings are designed for use by emergency response personnel to address the hazards that are presented by short-term, acute exposure to a material under conditions of fire, spill, or similar emergencies. Hazard ratings are primarily based on the inherent physical and toxic properties of the material but also include the toxic properties of combustion or decomposition products that are known to be generated in significant quantities.

### **Revision Changes:**

Section 1: Product name was modified.  
Section 1: Product use information was modified.  
Section 1: Division name was modified.  
Copyright was modified.  
Section 3: Potential effects from skin contact information was modified.  
Section 3: Potential effects from inhalation information was modified.  
Section 13: Waste disposal method information was modified.  
Section 4: First aid for inhalation - termination of exposure - was modified.  
Section 4: First aid for inhalation - medical assistance - was modified.  
Section 14: Transportation legal text was modified.  
Page Heading: Product name was modified.  
Section 9: Property description for optional properties was modified.  
Section 14: ID Number(s) Template 1 was added.  
Section 2: Ingredient table was added.  
Section 8: Exposure guidelines ingredient information was added.  
Section 8: Exposure guidelines data source legend was added.  
Section 10.1 Conditions to avoid was added.  
Section 10.2 Materials to avoid was added.  
Section 6: Release measures information was added.  
Section 6: Release measures information was added.  
Section 10: Materials to avoid physical property was added.  
Section 10: Conditions to avoid physical property was added.  
Section 3: Immediate skin hazard(s) was deleted.  
Section 6: Release measures information was deleted.  
Section 10: Materials and conditions to avoid physical property was deleted.



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# Scotch-Weld™

## EPX™ Adhesive DP100

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### Product Data Sheet

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Updated : March 1996  
Supersedes : November 1993

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**Product Description** DP100 clear epoxy adhesive is a clear room temperature curing, two part epoxy adhesive supplied in 3M Duo-Pak cartridge for use with the 3M EPX Applicator.

**DP100 offers the following features:**

- 1:1 premix system.
- Machineable.
- Suitable for bonding clear substrates, potting and encapsulating.

Fast curing with handling strength achieved in 15 minutes at room temperature.

A clear epoxy adhesive with high flow and excellent impact resistance.

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**Physical Properties**  
Not for specification purposes

	BASE	ACCELERATOR
<b>Base</b>	Modified Epoxy	Modified Mercaptan
<b>Specific Gravity</b>	1.16	1.15
<b>Viscosity</b> (cP at 27°C)	11,500	13,500
<b>Colour</b>	Clear	Clear
<b>Work Life</b>	3-5 minutes at 24°C	
<b>Handling Strength</b>	15 minutes at 23°C	
<b>Full Strength</b>	24 hours (test full performance at one week).	
<b>Shelf Life</b>	15 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

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**Performance Characteristics**  
Not for specification purposes

<b>T-Peel Strength</b>	Measured on abraded, steel (0.8mm) at 24°C. 3.5 N/cm (2 piw)	
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**Performance Characteristics (Cont...)**

Not for specification purposes

**Overlap Shear Strength**

The following strength values were obtained with DP100 when tested after 5 day cure cycle at 24°C.

Substrates solvent wiped, abraded and solvent wiped prior to bonding.

	MPa	psi
Galvanised Steel	6.7	900
Cold Rolled Steel	6.9	1000
FPL Etched Aluminium	9.0	1300
Copper	6.6	950
Stainless Steel	6.2	750
Brass	4.8	700
Acrylic	1.9	280
PVC	2.3	330
Polycarbonate	2.1	310
Neoprene/Steel	0.1	5
SBR/Steel	0.4	60
ABS	3.6	520
FRP	6.6	950

**Durability**

Percent of bond strength remaining after exposure to 90% relative humidity/32°C for 90 days.

All materials were solvent wiped/abraded/solvent wiped prior to bonding.

Aluminium	100	Aluminium Primed with EC1945 B/A	100
Steel	100	Steel Primed with EC1945 B/A	100
ABS	100	FRP	100
3M Primer EC1945 B/A was applied by dip-coating			
Metals were 1.6mm thick Plastics were 3mm thick			

**Electrical Properties**

<b>Dielectric Strength (Volts/mm)</b>	4.1 x 10 <sup>4</sup>	
<b>Volume Resistivity (Ohms/cm)</b>	2.7 x 10 <sup>14</sup>	

**Thermal Properties**

<b>Thermal Conductivity W/m°C</b>	<b>Coefficient of Thermal Expansion (cm/cm/°C)</b>	
0.180	- 50°C to 30°C 60 x 10 <sup>-6</sup> 50°C to 110°C 209 x 10 <sup>-6</sup>	

**Storage Conditions**

Store product at 16 to 27°C for maximum storage life. High temperatures reduce normal storage life.

Rotate stock on a "first in-first out" basis.

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## Directions for Use /Clean Up

Place the cartridge into the 3M EPX Applicator and clip into position.

Remove the resealable cap.

Expel a small quantity of adhesive and ensure both components flow freely.

Attach correct mixer nozzle (this should have 20 or more elements).

Dispense the adhesive as required.

When finished either leave the nozzle in place and store, or remove the nozzle, wipe clean the tip, and replace cap.

To re-start after storage remove the old nozzle with cured adhesive and re-fit a new nozzle, or remove the cap and fit a new nozzle.

## Surface Preparation:

The degree of surface preparation depends on the bond strength required and the environment likely to be encountered by the bonded structure. For most plastics solvent wiping with 3M VHB surface cleaner, followed by abrasion with 3M Scotchbrite 7447, followed by a further solvent wipe until clean, will give good performance (except for acetal, polyethylene and polypropylene and some other low surface energy materials). This also applies to powder coat paints and other stoved paint systems.

The same surface preparation will also give good adhesion to metal surfaces. The objective is to remove loosely attached surface films such as oils, waxes, dusts, mill-scale, loose paints and all other

surface contaminants in addition to enhancing mechanical adhesion. Grit-blasting using a clean, fine grit also offers excellent adhesion on many metallic substrates.

Where humid environments are likely to be encountered by metallic substrates we recommend additional priming with 3M Scotch-Weld 3901. Alternatively, chemical conversion coating techniques combined with priming can offer the best durability.

## Clean-Up:

Excess uncured adhesive can be removed with the following solvents:

**3M VHB Surface Cleaner**  
 (mild alcohol based cleaner)  
**3M Scotch-Grip Solvent No2.** (Ketone blend)  
**3M Industrial Cleaner**  
 (Aerosol).

## Health & Safety Information

### Precautions:

Causes severe eye irritation; may cause permanent eye damage. May cause sensitisation by skin contact. Avoid contact with skin and eyes. Wear suitable gloves and eye/face protection. Launder contaminated clothing before re-use. Avoid prolonged breathing of vapours.

Avoid inhalation of dust when grinding or cutting cured material.

### First Aid:

### Eye Contact:

Immediately flush eyes with copious amounts of water for at least 15 minutes, holding eyes open. Call a physician.

### Skin Contact:

Wash immediately with plenty of soap and water.

For further Health and Safety Information please contact the Toxicology Department at the Bracknell Head Office on (0344) 858000.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



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