Technisches Datenblatt

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3M SCOTCH-WELD DP420/DP420NS/DP420LH

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Scotch-Weld™

Epoxy Adhesive

DP420 Black • DP420 NS Black • DP420 Off-White • DP420 LH

Technical Data **April, 2019**

Product Description

3M™ Scotch-Weld™ Epoxy Adhesives are high performance, two-part epoxy adhesives offering outstanding shear and peel adhesion, and very high levels of durability.

Features

- High shear strength
- High peel strength
- Outstanding environmental performance
- Easy mixing
- 20 minute worklife
- Controlled flow (3M™ Scotch-Weld™ Epoxy Adhesive DP420 NS Black)
- Recognized as meeting UL 94 HB – Underwriters Laboratory Horizontal Burn Flammability Test (3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White)
- Low halogen content (3M™ Scotch-Weld™ Epoxy Adhesive DP420 LH)

Typical Uncured Physical Properties

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

Product		3M™ Scotch-Weld™ Epoxy Adhesive			
		DP420 Black	DP420 NS Black	DP420 Off-White	DP420 LH
Viscosity (approx.) @ 73°F (23°C)	Base Accelerator	20,000-50,000 cP 8,000-14,000 cP	190,000-270,000 cP 60,000-130,000 cP	20,000-50,000 cP 8,000-14,000 cP	20,000-50,000 cP 8,000-14,000 cP
Base Resin	Base Accelerator	epoxy amine	epoxy amine	epoxy amine	epoxy amine
Color	Base Accelerator	black amber	black amber	white amber	white amber
Net Weight Lbs./Gallon	Base Accelerator	9.3-9.7 9.0-9.4	9.4-9.8 9.1-9.5	9.3-9.7 9.0-9.4	9.3-9.7 9.0-9.4
Mix Ratio (B:A)	Volume Weight	2:1 2:0.97	2:1 2:0.97	2:1 2:0.97	2:1 2:0.97
Worklife, 73°F (23°C)	20 g mixed 10 g mixed 5 g mixed	15 minutes 20 minutes 30 minutes	15 minutes 20 minutes 30 minutes	15 minutes 20 minutes 30 minutes	15 minutes 20 minutes 30 minutes

3M™ Scotch-Weld™
Epoxy Adhesive
DP420 Black • DP420 NS Black • DP420 Off-White • DP420 LH

Typical Cured Properties

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

The properties of cured 3M™ Scotch-Weld™ Epoxy Adhesive DP420 NS Black and 3M™ Scotch-Weld™ Epoxy Adhesive DP420 LH are expected to be similar to the properties of 3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black and 3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White, respectively as described by data in the following sections of this technical data sheet.

An exception to this is the concentration of halogens in 3M™ Scotch-Weld™ Epoxy Adhesive DP420 LH. 3M™ Scotch-Weld™ Epoxy Adhesive DP420 LH is a form of 3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White that can be considered "low halogen". Low halogen is defined by the Electrotechnical Commission (IEC) 61249-2-21 standard as having less than 900 ppm chlorine, 900 ppm bromine, and less than 1500 ppm total chlorine and bromine.

3M™ Scotch-Weld™ Epoxy Adhesive DP420 LH Test Results

Halogens (determined by ion chromatography)		
Total Chlorine (ppm)	**Total Bromine (ppm)**	**Total Halogens (ppm)**
720	<5	<800

Product	**3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black**	**3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White**
Physical Color	Black	Opaque, off-white
Shore D Hardness	75-80	75-80
Thermal Coefficient of Thermal Expansion (in./in./°C) Below Tg Above Tg	80 x 10^{-6} 194 x 10^{-6}	85 x 10^{-6} 147 x 10^{-6}
Thermal Conductivity (btu - ft./ft.^{2} - hr. - °F) @ 45°C	0.104	0.104
Electrical Dielectric Strength (ASTM D 149)	888 volts/mil	690 volts/mil
Volume Resistivity (ASTM D 257)	1.6 x 10^{15} ohm-cm	1.3 x 10^{14} ohm-cm

Typical Curing Characteristics

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

Rate of Strength Build-Up
Aluminum, Overlap Shear (7 mil Bondline) (ASTM D 1002-72)
Bonds Tested at 73°F (23°C)
3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black

Time in Oven	Cure Temperature		
	73°F (23°C)	120°F[1] (49°C)	140°F[1] (60°C)
15 min.	NT	NT	3200
30	NT	2300	NT
60	NT	4700	4700
2 hr.	300		
3	800		
5	3000		
6	3700		
24	4500		

[1]This represents the oven temperature to which the bonds were subjected for the prescribed time. The average bondline temperature during the cure time will be somewhat lower than the oven temperature.

NOTE: The data in this data sheet were generated using the 3M™ EPX Applicator System equipped with an EPX static mixer, according to manufacturer's directions. Thorough hand-mixing will afford comparable results.

3M™ Scotch-Weld™
Epoxy Adhesive
DP420 Black • DP420 NS Black • DP420 Off-White • DP420 LH

Typical Adhesive Performance Characteristics

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

Substrates and Testing

A. Overlap Shear (ASTM D 1002-72)

Overlap shear (OLS) strengths were measured on 1 in. wide 1/2 in. overlap specimens. These bonds were made individually using 1 in. x 4 in. pieces of substrate except for aluminum. Two panels 0.063 in. thick, 4 in. x 7 in. of 2024T-3 clad aluminum were bonded and cut into 1 in. wide samples after 24 hours. The thickness of the bondline was 0.005-0.008 in. All strengths were measured at 73°F (23°C) except where noted.

The separation rate of the testing jaws was 0.1 in. per minute for metals, 2 in. per minute for plastics and 20 in. per minute for rubbers. The thickness of the substrates were: steel, 0.060 in.; other metals, 0.05-0.064 in.; rubbers, 0.125 in.; plastics, 0.125 in.

B. T-peel (ASTM D 1876-61T)

T-peel strengths were measured on 1 in. wide bonds at 73°F (23°C). The testing jaw separation rate was 20 inches per minute. The substrates were 0.032 in. thick.

C. Bell Peel (ASTM D 3167)

Bell peel strengths were measured on 1/2 in. wide bonds at the temperatures noted. The testing jaw separation rate was 6 in. per minute. The bonds are made with 0.064 in. bonded to 0.025 in. thick adherends.

D. Cure Cycle

With the exception of Rate of Strength Build-Up Tests, all bonds, were cured 7 days at 73°F (23°C) at 50% RH before testing or subjected to further conditioning or environmental aging.

	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White	3M™ Scotch-Weld™ Epoxy Adhesive DP420NS Black
-67°F (-55°C)	4500	4500	4500
73°F (23°C)	4500	4500	4500
180°F (82°C) (15 min.)[1]	1260	450	860
(30 min.)[1]	2250	700	1400
(60 min.)[1]	2980	750	1600
(4 hr.)[1]	2690	2500	2100
250°F (121°C) (15 min.)[1]	570	200	350

Aluminum, Overlap Shear, at Temperature (PSI)

[1]Represents time in test chamber oven before test.

Metals, Overlap Shear, Tested @ 73°F (23°C) (PSI)

		3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White	3M™ Scotch-weld™ Epoxy Adhesive DP420NS Black
Aluminum-	Etched	4500	4500	4500
	Oakite degrease	4000	3500	NT
	MEK/abrade/MEK	2500	3500	3500
Cold Rolled Steel-	Oakite degrease	—	4000	NT
	MEK/abrade/MEK	2200	2700	2500
Copper-	MEK/abrade/MEK	5000	4000	3000
Brass-	MEK/abrade/MEK	2800	4100	3500
Stainless Steel-	MEK/abrade/MEK	1800	1700	3900
Galvanized Steel-	Hot dipped	2900	2000	NT
	Electrodeposited	3000	2100	NT

NT: Not tested

Typical Adhesive Performance Characteristics *(continued)*

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

Substrates and Testing *(continued)*

Aluminum, T-Peel (PIW), at Temperature

	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White
-67°F (-55°C)	9.3	5-10
73°F (23°C)	50	50
180°F (82°C)	20	3-5

Metals, T-Peel, Tested @ 73°F (23°C) (PIW)

		3M™ Scotch-Weld™ Epoxy Adhesive DP420	3M™Scotch-Weld™ Epoxy Adhesive DP420
Aluminum, etched	17-20 mil bondline	60	50
	5-8 mil bondline	50	40
Cold Rolled Steel	17-20 mil bondline Oakite degreased	40	40
	MEK/abrade/MEK	25	25

Aluminum, Bell Peel (PIW), at Temperature

	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White	3M™ Scotch-Weld™ Epoxy Adhesive DP420NS Black
-67°F (-55°C)	20	not tested	Not tested
73°F (23°C)	82		58
180°F (82°C)	18		Not tested

Other Substrates, Overlap Shear Tested @ 73°F (23°C) (PSI)

Substrate	Surf. Prep. 11		Surf. Prep. 22		
	3M Scotch-Weld Epoxy Adhesive DP420 Black	3M Scotch-Weld Epoxy Adhesive DP420 Off-White	3M Scotch-Weld Epoxy Adhesive DP420 Black	3M Scotch-Weld Epoxy Adhesive DP420 Off White	3M Scotch-Weld Epoxy Adhesive DP420NS Black
ABS	450	320	550	500	870
PVC	4003	220	3603	300	NT
Polycarbonate	440	400	450	550	470
Polyacrylic	190	230	450	280	NT
Polystryene	380	350	580	380	NT
FRP	600	350	1100[3]	1300[3]	3700
Phenolic	1400[3]	1400[3]	1300[3]	1400[3]	1170
SBR/Steel	70	150[3]	180[3]	150[3]	NT
Neoprene/Steel	80	40	100	80	NT

1Isopropyl Alcohol Wipe. See Surface Preparation Section D for additional information.
2Isopropyl Alcohol/Abrade/Isopropyl Alcohol: See Surface Preparation Section E for additional information.
3Substrate failure.

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Typical Adhesive Performance Characteristics *(continued)*

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

Substrates and Testing *(continued)*
Environmental Resistance
Aluminum (Etched)
Measured by Overlap Shear Tested @ 73°F (23°C) (PSI)[1] (ASTM D 1002-72)

Environment	Condition	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black	3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White	3M™ Scotch-Weld™ Epoxy Adhesive DP420NS Black
73°F (23°C)/50% RH	30 d[2]	4900	5100	4590
Distilled Water	30 d, i[3]	4200	4700	4790
Water Vapor	120°F (49°C)/100% RH, 30 d 200°F (93°C)/100% RH, 14 d	4000 4000	4700 3000	4410 3780
Antifreeze/H_2O (50/50)	180°F (82°C), 30 d, i	3000	4200	4240
Isopropyl Alcohol	73°F (23°C), 30 d, i	4500	5300	5180
Methyl Ethyl Ketone	73°F (23°C), 30 d, i	3500	4600	NT
Salt Spray (5%)	95°F (35°C), 30 d	NT	5100	NT
Skydrol LD-4	150°F (66°C), 30 d, i	4000	5400	4810

[1]Data reported are actual values from the lots tested and may be higher than values published elsewhere in this data sheet.
[2] d = days
[3] i = immersion

3M™ EPX Pneumatic Applicator Delivery Rates

200 ml Applicator – Maximum Pressure 58 psi

Adhesive*	6mm Nozzle gms/minute	10mm Nozzle gms/minute
3M™ Scotch-Weld™ Epoxy Adhesive DP420 Black	29.6	113
3M™ Scotch-Weld™ Epoxy Adhesive DP420 Off-White	31.1	132

*Tests were run at a temperature of 70°F ± 2°F (21°C ± 1°C) and at maximum applicator pressure.

Handling/Application Information

Directions for Use

3M™ Scotch-Weld™ Epoxy Adhesive DP420 is supplied in dual syringe plastic duo-pak cartridges as part of the 3M™ EPX Applicator System. The duo-pak cartridges are supplied in 50 ml, 200 ml and 400 ml configurations. To use the EPX cartridge system simply insert the duo-pak cartridge into the EPX applicator. Next, remove the duo-pak cartridge cap and expel a small amount of adhesive to be sure both sides of the duo-pak cartridge are flowing evenly and freely. If simultaneous mixing of Part A and Part B is desired, attach the EPX mixing nozzle to the duo-pak cartridge and begin dispensing the adhesive.

When mixing Part A and Part B manually the components must be mixed in the ratio indicated in the typical uncured properties section of this data sheet. Complete mixing of the two components is required to obtain optimum properties.

Two-part mixing/proportioning/dispensing equipment is available for intermittent or production line use. These systems are ideal for line uses because of their variable shot size and flow rate characteristics and are adaptable to most applications.

Apply adhesive to clean, dry surfaces, joint parts and secure until adhesive sets (see rate of strength build up).

Surface Preparation

The following surface preparations were used for substrates described in this Technical Data Sheet.

A. **Aluminum Etch**
Optimized FPL Etch - 3M (test method C-2803)

1. Alkaline degrease – Oakite 164 solution (9-11 oz./gallon water) at 190°F ± 10°F (88°C ± 5°C) for 10-20 minutes. Rinse immediately in large quantities of cold running water (3M test method C-2802).
2. Optimized FPL Etch Solution (1 liter):

Material	**Amount**
Distilled Water	700 ml plus balance of liter (see below)
Sodium Dichromate	28 to 67.3 grams
Sulfuric Acid	287.9 to 310.0 grams
Aluminum Chips	1.5 grams/liter of mixed solution

To prepare 1 liter of this solution, dissolve sodium dichromate in 700 ml of distilled water. Add sulfuric acid and mix well. Add additional distilled water to fill to 1 liter. Heat mixed solution to 66 to 71°C (150 to 160°F). Dissolve 1.5 grams of 2024 bare aluminum chips per liter of mixed solution. Gentle agitation will help aluminum dissolve in about 24 hours.

To FPL etch panels, place them in the above solution at 150 to 160°F (66 to 71°C) for 12 to 15 minutes.

Note: Review and follow precautionary information provided by chemical suppliers prior to preparation of this etch solution.

3. Rinse immediately in large quantities of clear running tap water.

Surface Preparation ***(continued)***

4. Dry – air dry approximately 15 minutes followed by force dry at 140°F (60°C) maximum for 10 minutes (minimum).
5. Both surface structure and chemistry play a significant role in determining the strength and permanence of bonded structures. It is therefore advisable to bond or prime freshly primed clean surfaces as soon as possible after surface preparation in order to avoid contamination and/or mechanical damage. Please contact your 3M sales representative for primer recommendations.

B. Oakite Degrease

Oakite 164 solutions (9-11 oz./gallon of water) at 190°F ± 10°F (88°C ± 5°C) for 2 minutes. Rinse immediately in large quantities of cold running water.

C. MEK/Abrade/MEK

Wipe surface with a methyl ethyl ketone (MEK) soaked swab, abrade and wipe with a MEK soaked swab.***** Allow solvent to evaporate before applying adhesive.

***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

D. Isopropyl Alcohol Wipe Only Surface Preparation

Wipe surface with an isopropyl alcohol soaked swab.* Allow solvent to evaporate before applying adhesive.

***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

E. Isopropyl Alcohol/Abrade/Isopropyl Alcohol Surface Preparation

Wipe surface with an isopropyl alcohol soaked swab, abrade using clean fine grit abrasives, and wipe with an isopropyl alcohol soaked swab.* Then allow solvent to evaporate before applying adhesive.

***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

3M™ Scotch-Weld™

Epoxy Adhesive

DP420 Black • DP420 NS Black • DP420 Off-White • DP420 LH

Storage	Store products at 60-80°F (15-27°C) for maximum shelf life.
Shelf Life	These products have a shelf life of 24 months from date of manufacture in original containers at room temperature
Precautionary Information	Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.
Technical Information	The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.
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This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2008 standards.

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