

February, 2019

## 3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear

### Product Description

3M™ Scotch-Weld™ Epoxy Adhesive DP100 is a two-part adhesive offering fast cure and machinability. Available in larger containers as 3M™ Scotch-Weld™ Epoxy Adhesives 100 B/A or 100 NS B/A.

### Product Features

- Easy mixing
- High Flow
- Fast Cure
- Meets UL 94 HB



# 3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear

## Technical Information Note

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

## Typical Uncured Physical Properties

Property	Values	Notes	Method	Test Condition
Color	Clear	Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.		
Base Viscosity	8,000-15,000 cP	Procedure involves Brookfield RVF, #6 spindle, 20 rpm. Measurement taken after 1 minute.	3M C1d	80°F(27°C)
Accelerator Viscosity	9,000-16,000 cP	Procedure involves Brookfield RVF, #6 spindle, 20 rpm. Measurement taken after 1 minute.	3M C1d	80°F(27°C)
Base Resin	Epoxy			
Base Net Weight	9.5 to 9.9 lb/gal			
Accelerator Net Weight	9.2 to 9.6 lb/gal			
Mix Ratio by Volume (B:A)	1:1			
Mix Ratio by Weight (B:A)	1:0.98			

## Typical Mixed Physical Properties

Property	Values	Method	Test Condition	Notes	Attribute Modifier	Dwell/Time	Dwell/Time Units	Temp C	Temp F	Substrate	Substrate Notes
Worklife, 10g mixed	5 min	3M C548	Room Temperature	Procedure involves periodically measuring a 10 gram mixed mass for spreading and wetting properties. This time approximates the available worklife in an EPX applicator nozzle.							

Table continued on next page

Typical Mixed Physical Properties (continued)

Property	Values	Method	Test Conditions	Notes	Attribute Modifier	Dwell Time	Dwell Units	Temp C	Temp F	Substrate	Substrate Notes
Open Time	5 min			Maximum time allowed after applying adhesive to one substrate before bond must be closed and fixed in place. Cure times are approximate and depend on adhesive temperature. For hotmelts: The approximate bonding range of a 1/8" bead of molten adhesive on a non-metallic surface.							
Time to Handling Strength	15 to 20 min		Room Temperature	Minimum time required to achieve 50 psi of overlap shear strength. Cure times are approximate and depend on adhesive temperature.							
Time to Full Cure	24 to 48 h		Room Temperature								
Time to Full Cure (set time)	24 to 48 h		Room Temperature	The cure time is defined as that time required for the adhesive to achieve a minimum of 80% of the ultimate strength as measured by aluminum-aluminum OLS.							
Rate of Strength Buildup	400 lb/in <sup>2</sup>	ASTM D1002		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 2024 T-3 clad aluminum were bonded and cut into 1 in. wide samples after 24 hours. 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.	Overlap Shear Strength	20	min	23C	72F	Aluminum	7 mil bondline

Table continued on next page

**Typical Mixed Physical Properties (continued)**

Property	Values	Method	Test Condition	Notes	Attribute Modifier	Dwell/Cure Time	Dwell Time Units	Temp C	Temp F	Substrate	Substrate Notes
Rate of Strength Buildup	0 lb/in <sup>2</sup>	ASTM D1002		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 2024 T-3 clad aluminum were bonded and cut into 1 in. wide samples after 24 hours. 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.	Overlap Shear Strength	10	min	23C	72F	Aluminum	7 mil bondline

**Typical Physical Properties**

**Color:** Clear

**Conditions**

**Attribute Modifier:** Cured

**Typical Cured Characteristics**

Property	Values	Method	Dwell/Cure Time	Notes	Test Condition
Shore D Hardness	82	ASTM D2240	60 min @ Room Temperature		
Weight Loss by Thermal Gravimetric Analysis (TGA)	585°F(307°C)	ASTM E1131		Weight loss by Thermal Gravimetric Analysis reported as that temperature at which 5% weight loss occurs by TGA in air at 5°C (9°F) rise per minute.	
Compression Strength	8400 lb/in <sup>2</sup>	ASTM D695			Room Temperature

Typical Performance Characteristics

Overlap Shear Strength	Substrate	Substrate Notes	Surface Preparation	Notes
950 lb/in <sup>2</sup>	Aluminum	0.005-0.008in bondline	MEK/Abrade/MEK	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
1000 lb/in <sup>2</sup>	Cold Rolled Steel	0.005-0.008in bondline	MEK/Abrade/MEK	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
950 lb/in <sup>2</sup>	Copper	0.005-0.008in bondline	MEK/Abrade/MEK	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
700 lb/in <sup>2</sup>	Brass	0.005-0.008in bondline	MEK/Abrade/MEK	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)

Table continued on next page

## Typical Performance Characteristics (continued)

Overlap Shear Strength	Substrate	Substrate Notes	Surface Preparation	Notes
750 lb/in <sup>2</sup>	Stainless Steel	0.005-0.008in bondline	MEK/Abrade/MEK	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
490 lb/in <sup>2</sup>	ABS	0.005-0.008in bondline	IPA Wipe/Abrade/IPA Wipe	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
330 lb/in <sup>2</sup>	Polyvinyl chloride (PVC)	0.005-0.008in bondline	IPA Wipe/Abrade/IPA Wipe	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
250 lb/in <sup>2</sup>	Polycarbonate (PC)	0.005-0.008in bondline	IPA Wipe/Abrade/IPA Wipe	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)

Table continued on next page

Typical Performance Characteristics (continued)

Overlap Shear Strength	Substrate	Substrate Notes	Surface Preparation	Notes
100 lb/in <sup>2</sup>	Acrylic (PMMA)	0.005-0.008in bondline		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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
950 lb/in <sup>2</sup>	Fiber-Reinforced Plastic	0.005-0.008in bondline	IPA Wipe/Abrade/IPA Wipe	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 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. Cohesive Failure (CF), Adhesive Failure (AF), Substrate Failure (SF)
900 lb/in <sup>2</sup>	Galvanized Steel		MEK/Abrade/MEK	1/2" overlap; 0.010" bond line thickness; samples pulled at 0.1 in/min for metals and 2 in/min for plastics; substrates used were 1/16" thick metals and 1/8" thick plastics. AF: adhesive failure CF: cohesive failure SF: substrate failure mixed: AF/CF

Property: Overlap Shear Strength  
 Method: ASTM D1002  
 Dwell/Cure Time: 7  
 Dwell Time Units: days  
 Temp C: 23C  
 Temp F: 73F  
 Environmental Condition: 50%RH

Solvent Resistance	Environmental Condition
A	Immersed in Acetone one hour
A	Immersed in Acetone one month
A	Immersed in Isopropyl Alcohol one hour
B	Immersed in Isopropyl Alcohol one month
A	Immersed in Freon TF one hour
A	Immersed in Freon TF one month
A	Immersed in Freon TMC one hour
A	Immersed in Freon TMC one month
A	Immersed In 1, 1, 1 - Trichloroethane one hour

Table continued on next page

**Typical Performance Characteristics (continued)**

Solvent Resistance	Environmental Condition
B	Immersed In 1, 1, 1 - Trichloroethane one month
A	Immersed in RMA Flux one hour
A	Immersed in RMA Flux one month

Property: Solvent Resistance

Dwell/Cure Time: 24 hr @ Room Temperature + 2 hr @ 160°F(71°C)

notes: Solvent resistance was determined using cured samples (1/2 in. x 4 in. x 1/8 in. thickness) immersed in the test solvent for 1 hour and 1 month. After the allotted period of time, the sample was removed and visually examined for surface attack as compared to the control. Key: A - Unaffected - no change to color or surface texture. B - Slight attack - noticeable swelling of surface. C - Moderate/severe attack - extreme swelling of surface.

T-Peel Adhesion	Substrate	Substrate Notes	Surface Preparation
2 lb/in width	Aluminum	0.032in thick; 17 - 20 mil bondline	
2 lb/in width	Aluminum	0.032in thick; 5 - 8 mil bondline	
2 lb/in width	Cold Rolled Steel	0.032in thick; 17 - 20 mil bondline	MEK/Abrade/MEK

Property: T-Peel Adhesion

Method: ASTM D1876

Dwell/Cure Time: 7

Dwell Time Units: day

Temp C: 23C

Temp F: 73F

notes: Note: The following product performance data was obtained in the 3M laboratory under the conditions specified. The following data shows typical results obtained with 3M™ Scotch-Weld™ Epoxy Adhesives DP100 and DP100 NS when applied to properly prepared substrates, and tested according to the test methods indicated. T-peel strengths were measured on 1 in. wide bonds. The testing jaw separation rate was 20 inches per minute.

**Electrical and Thermal Properties**

Property	Values		Test Condition	Notes	Method
Glass Transition Temperature (Tg)	33 °C	91 °F	Mid-Point	Glass Transition Temperature (Tg) determined using DSC Analyzer with a heating rate of 68°F (20°C) per minute. Second heat values given.	
Volume Resistivity	3.5 × 10 <sup>12</sup> Ω-cm		Room Temperature		ASTM D257
Coefficient of Thermal Expansion	60 × 10 <sup>-6</sup> m/m/°C		-40°C to 20°C (-38°F to 68°F)	Coefficient of thermal expansion determined using DuPont (TMA) using a heating rate of 10°C (50°F) per minute. Second heat values given.	
Coefficient of Thermal Expansion	209 × 10 <sup>-6</sup> m/m/°C		60°C to 120°C (140°F to 248°F)	Coefficient of thermal expansion determined using DuPont (TMA) using a heating rate of 10°C (50°F) per minute. Second heat values given.	



# 3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear

## Handling/Application Information

### Application Equipment

For small or intermittent applications the 3M™ Scotch-Weld™ EPX™ applicator is a convenient method of application.

For larger applications these adhesives may be applied by use of flow equipment. Two-part meter/mixing/dispensing equipment is available for intermittent or production line use. These systems may be desirable because of their variable shot size and flow rate characteristics and are adaptable to many applications.

### Directions for Use

1. For optimum strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user. For specific surface preparations on common substrates, see the following section on Surface Preparation.

2. Use gloves to minimize skin contact with adhesive.

3. These products consist of two parts.

#### Mixing and Applying

For Duo-Pak Cartridges - 48.5 ml

3M™ Scotch-Weld™ DP100 and DP100 NS Adhesives are supplied in a dual syringe plastic Duo-Pak cartridge as part of the 3M™ Scotch-Weld™ EPX™ Applicator system. To use, simply insert the Duo-Pak cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. 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 mixing of Part A and Part B is desired, attach the EPX mixing nozzle to the Duo-Pak cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.

For Duo-Pak Cartridges - 200/400 ml

Directions for Use: While holding cartridge in an upright position, remove insert from Duo-Pak cartridge by unscrewing plastic nut. Detach metal removal disc from insert to free plastic nut for nozzle attachment. Clear orifices if necessary. Attach mixing nozzle and secure with plastic nut. Place cartridge into EPX Applicator.

Dispense a small quantity of adhesive to assure both components are dispensing equally. Apply adhesive to clean surfaces, join parts, secure until set up (20 minutes @ 75°F [24°C]). Leave nozzle attached to store. Replace nozzle after storage.

#### For Bulk Containers

Mix thoroughly by weight or volume in the proportions specified in the Typical Uncured Properties section. Mix approximately 15 seconds after uniform color is obtained.

4. For maximum bond strength apply adhesive evenly to both surfaces to be joined.

5. Application to the substrates should be made within 5 minutes. Larger quantities and/or higher temperatures will reduce this working time.

6. Join the adhesive coated surfaces and allow to cure at 60°F (16°C) or above until completely firm. Heat, up to 200°F (93°C), will speed curing. These products will fully cure in 24-48 hours @ 75°F (24°C).

7. Keep parts from moving during cure. Contact pressure is necessary. Maximum shear strength is obtained with a 3-5 mil bond line.

8. Excess uncured adhesive can be cleaned up with ketone type solvents.\*

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

Adhesive Coverage: A 0.005 in. thick bondline will typically yield a coverage of 320 sqft/gallon.

# 3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear

## Handling/Application Information (continued)

### Surface Preparation

For optimum strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by the user.

The following cleaning methods are suggested for common surfaces:

Steel:

1. Wipe free of dust with oil-free solvent such as acetone or isopropyl alcohol.\*
2. Sandblast or abrade using clean fine grit abrasives.
3. Wipe again with solvent to remove loose particles.
4. If a primer is used, it should be applied within 4 hours after surface preparation.

Aluminum:

1. Acid Etch: Place panels in the following solution for 10 minutes at 150°F ± 5°F (66°C ± 2°C).

Sodium Dichromate 4.1 - 4.9 oz./gallon

Sulfuric Acid, 66°Be 38.5 - 41.5 oz./gallon 2024-T3 aluminum (dissolved) 0.2 oz./gallon minimum Tap Water as needed to balance

2. Rinse: Rinse panels in clear running tap water.

3. Dry: Air dry 15 minutes and force dry 10 minutes at 150°F ± 10°F (66°C ± 5°C).

4. If primer is to be used, it should be applied within 4 hours after surface preparation.

5. Option 2: Degrease with an industrial solvent such as MEK\*; abrade with ScotchBrite™ 7447 abrasive (or sandpaper of approximately 180 grit) and wipe again with solvent\*.

Plastics/Rubber:

1. Wipe with isopropyl alcohol.\*
2. Abrade using fine grit abrasives.
3. Wipe with isopropyl alcohol.\*

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

### Storage and Shelf Life

Store products at 60-80°F (16-27°C) for maximum storage life. Rotate on "first in-first out" basis.

When stored as recommended in original unopened container, this product has a shelf life of 24 months from date of manufacture.

### Industry Specifications

UL 94 HB

### Trademarks

3M, Scotch-Weld and EPX are trademarks of 3M Company.

### References

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Scotch-Weld-Epoxy-Adhesive-DP100?N=5002385+3293242434&amp;rt=rud">https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-Scotch-Weld-Epoxy-Adhesive-DP100?N=5002385+3293242434&amp;rt=rud</a>
Safety Data Sheet (SDS)	<a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=DP100 Clear">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=DP100 Clear</a>

# 3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear

## Family Group

	DP100 Clear	DP100NS Translucent
Time to Full Cure (h) Test Condition: Room Temperature	24 to 48	24 to 48
Time to Handling Strength (min) Test Condition: Room Temperature	15 to 20	15 to 20
Color Attribute Modifier: Cured	Clear	Translucent
Open Time (min)	5	5

## ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

## Information

**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.

**Product Selection and Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

**Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

**Limitation of Liability:** Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

3M™ Scotch-Weld™ Epoxy Adhesive DP100 Clear



3M United States  
3M Center  
St. Paul, MN 55144-1000  
800-362-3550  
[www.3M.com](http://www.3M.com)

Please recycle.  
© 3M 2021. All Rights Reserved.

The brands listed above are trademarks of 3M