SNAPSHOOT
ENGINEERED FOR A SAFER TOMORROW

현장을 이해하고, 필요한 솔루션을 연결합니다.

산업안전 · 추락방지 시스템
산업용 소재 · 건축자재
제품 제안부터 공급·시공·설치·교육까지



COMPANY INFORMATION

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TECHNICAL DOCUMENTS

인증서 · 데이터시트 · 기술자료

제품의 규격과 성능, 인증 및 적용 조건을 확인하기 위한 자료입니다.

ABOUT SNAPSHOOT

제품 공급을 넘어, 현장에 맞는 해결책으로

스냅슛은 산업현장의 작업 환경과 요구 조건을 바탕으로
적합한 제품과 시스템을 제안합니다. 현장 실사를 통해 설치 조건을 확인하고,
공급부터 시공·설치 및 사용 교육까지 필요한 과정을 함께합니다.

추락방지 시스템

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윈치 안전블록 · 구조장비

산업안전 보호구

전신형 안전대 · 랜야드 · 안전블록
작업 환경에 맞춘 개인보호구

산업용 소재·건축자재

산업용 테이프 · 접착제 · 기능성 소재
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홈페이지 바로가기 →
문서 라이브러리 바로가기 →
시공사례 바로가기 →
문의하기 →

본 페이지는 스냅슛의 자료 제공 안내용 표지입니다. 첨부된 인증서 및 기술자료의 발행 주체, 인증 대상과 적용 범위는 해당 원문을 기준으로 확인해 주세요.



3M Science. Applied to Life.™

Technical Data Sheet

3M™ Scotch-Weld™ Flexible Acrylic Adhesive DP8625NS

V-9 | English-US
Last Revision Date: July, 2026
Supersedes: December, 2025

Additional Info

Regulatory Info/SDS

Product Description

3M™ Scotch-Weld™ DP8625 Adhesive is a flexible low odor, non-flammable, two-part acrylic structural adhesives with a 10:1 mix ratio.

Product Features

- Low-odor, non-flammable acrylic formulation
- 118 % Tensile Elongation at Break
- Non-sag formulation resists running and slumping of adhesive
- Room temperature cure
- Contains spacer beads to control bond line thickness

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

Attribute Name	Value
Color	Black [1]
Mix Ratio by Weight (B:A)	10:1
Mix Ratio by Volume (B:A)	10:1

[1] Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

Attribute Name	Temperature	Value
Base Color		Black
Accelerator Color		Gray
Base Viscosity	23 °C (73 °F)	70000-950000 cP [1]
Accelerator Viscosity	23 °C (73 °F)	8000-18000 cP [1]
Base Density		1.1 g/cm³
Accelerator Density		1.1 g/cm³

[1] Viscosity measured using cone-and-plate viscometer; reported viscosity at 4 sec^{-1} shear rate.

Typical Mixed Physical Properties

Attribute Name	Temperature	Value
Density (mixed)		1.1 g/cm³
Viscosity		64000 - 87900 cP
Open Time		15 min [1]
Worklife		25 min [2]
Time to Handling Strength		40 min
Time to Full Cure	23 °C (73 °F)	48 h

[1] Max time allowed after applying adhesive to a substrate before bond must be closed and fixed. Cure times approximate and depend on adhesive temperature. Hotmelts: The approx. bonding range of a 3.2 mm (1/8 in) bead of molten adhesive on a non-metallic surface.

[2] Maximum time that adhesive can remain in a static mixing nozzle and still be expelled without undue force on the applicator. Cure times are approximate and depend on adhesive temperature.

Typical Physical Properties

Attribute Name	Value
Cured Color	Black
Mixed Color	Black

Typical Cured Characteristics

Test Method: ASTM D638, ISO 527

Attribute Name	Dwell Time	Temperature	Value
Modulus		23 °C (73 °F)	39 MPa (5669 lb/in²) [1]
Peak Stress	7 d	23 °C (73 °F)	0.06 MPa (9 lb/in²) [2]
Elongation at Break			118 %

[1] 1.5 mm (1/16") thick Type IV dog-bone specimens, samples pulled at 100 mm/min (4 in/min). 2 week dwell in CTH room at 22 °C (72 °F)

[2] Tested in accordance with ASTM D638 test method, Type IV dogbone. Jaw separation 100 mm/min. Sample removed from a dry condition and tested after equilibriation at 25 °C / 50%RH for 40 hrs.

Temperature: 23 °C (73 °F)

Attribute Name	Test Method	Value
Shore D Hardness	ASTM D2240	44

Typical Performance Characteristics

Overlap Shear Strength

Temperature: 23 °C (73 °F)
Test Condition: 23 °C
Dwell Time: 72 h
Test Method: ASTM D1002, ISO 4587

Substrate	Surface Prep	Value
ABS	Solvent Wipe (IPA)	5.6 MPa (813 lb/in²) [1]
Polycarbonate (PC)	Solvent Wipe (IPA)	3.2 MPa (467 lb/in²) [1]
Acrylic (PMMA)	Solvent Wipe (IPA)	4.6 MPa (660 lb/in²) [1]
Polyvinyl chloride (PVC)	Solvent Wipe (IPA)	3.6 MPa (518 lb/in²) [1]
Aluminum	MEK / Abrade / MEK	6.9 MPa (995 lb/in²) [1]
Cold Rolled Steel	MEK / Abrade / MEK	6.6 MPa (952 lb/in²) [1]
Epoxy Resin (fiber-reinforced)	MEK / Abrade / MEK	8.9 MPa (1286 lb/in²) [1]
Polyester resin (fiber-reinforced)	MEK / Abrade / MEK	5.6 MPa (809 lb/in²) [1]

[1] 25 mm by 12.7 mm (1" x 1/2"), bondline thickness: 0.07-0.25 mm (3-10 mil). Substrate size: 102mm x 25mm (1" x 4"). Separation rate 1.2 mm/min (0.05 in/min) for metal, 51 mm/min (2 in/min) for plastic, 510 mm/min (20 in/min) for rubber.

Substrate: Aluminum
Surface Prep: MEK,Sandblast,MEK
Test Condition: Pendulum Impact

Attribute Name	Test Method	Value
Impact Shear Strength	ASTM D950	17 J [1]

[1] 21.7J Hammer

Substrate: Aluminum
Surface Prep: Light Abrasion and Solvent Clean
Temperature: 23 °C (73 °F)
Test Condition: 23 °C

Attribute Name	Test Method	Value
Bell Peel	ASTM D3167	10 N/mm (57 lb/in) [1]

[1] Bonds are made with a 1.6mm thick, 178 mm long (1/16" thick, 7" long) substrate, bonded to a 0.5 mm thick, 254 mm long (20 mil thick, 10" long) substrate. 25 mm (1") wide bonds. Bondline thickness: 0.04 mm (17 mil). Separation rate 1.2 mm/min (6 in/min pull rate)
Cohesive Failure (CF), Adhesive Failure (AF), Mixed Failure (MF), Substrate Failure (SF)

Attribute Name	Value
Additional Test notes	Note: This adhesive also has relatively low adhesion to low surface energy plastics (such as polypropylene, polyethylene, TPO, and PTFE). Applications involving any of these materials should be carefully evaluated by the end user for suitability. Note: The presence of oxygen inhibits the cure of some acrylic structural adhesives. Therefore, any exposed surfaces of the mixed adhesive will cure more slowly than adhesive within the bond line. With this acrylic adhesive, uncured adhesive that remains on exposed surfaces, will leave a tacky film of partially cured material. For manufacturing processes that need a tack-free surface quickly, such as for subsequent sanding or painting operations, consider instead using a standard MMA acrylic adhesive.

Typical Environmental Performance

Overlap Shear Strength

Test Condition: 23 °C
Dwell Time: 500 h
Test Method: ASTM D1002, ISO 4587

Temperature	Environmental Condition	Substrate	Value
23 °C (73 °F)	Diesel Fuel Submersion	Aluminum	99 % [1]
23 °C (73 °F)	Gasoline Submersion	Aluminum	9 % [1]
23 °C (73 °F)	Water Submersion	Aluminum	72 % [1]
23 °C (73 °F)	Salt water (5 wt% in water)	Aluminum	77 % [1]
85 °C (185 °F)	85 %RH	Aluminum	85 % [1]
49 °C (120 °F)	80 %RH	PVC	73 % [1]

[1] Performance % to control sample @RT. Samples were cured @RT for at least 24h prior to Environmental Exposure.
Overlap shear (OLS) strengths were measured on 1in wide 1/2in overlap specimens on 1in x 4in x .060in substrates.
Jaw separation 0.05 in/min. 10 mil bondline.

Overlap Shear Strength

Substrate: Aluminum
Dwell Time: 30 min
Test Method: ASTM D1002, ISO 4587

Temperature	Test Condition	Value
-40 °C (-40 °F)	-40 °C	233 % (16 MPa) (2316 lb/in²) [1]
49 °C (120 °F)	49 °C	46 % (3.2 MPa) (457 lb/in²) [1]
82 °C (180 °F)	82 °C	25 % (1.7 MPa) (252 lb/in²) [1]
200 °C (392 °F)	200 °C	12 % (0.8 MPa) (122 lb/in²) [1]

[1] Performance % to control sample @RT. Samples were cured @RT for at least 24h prior to Environmental Exposure.
Overlap shear (OLS) strengths were measured on 1in wide 1/2in overlap specimens on 1in x 4in x .060in substrates.
Jaw separation 0.05 in/min. 10 mil bondline.

Electrical and Thermal Properties

Attribute Name	Value
Glass Transition Temperature (Tg)	27ºC [1]

[1] Measured at one week via DMA

Attribute Name	Value
Thermal Conductivity	Conductivity: 0.233 W/mK

Coefficient of Thermal Expansion

Test Condition	Value
Below Tg	153.4 µm/(m° C)
Above Tg	215 µm/ (m° C)

Dispense Properties

Attribute Name	Value
Cleaning Recommendation	Excess uncured adhesive can be cleaned with methyl ethyl ketone (MEK)
Fillers	Product contains ceramic particles from 0.002" to 0.010"
Packaging	45ml & 490ml cartridges 5 gallon pails 55 gal drums
45-50ml Cartridge Nozzle	Quadro (Orange), 16 element, 90mm, 1.7ml, #7100202930
490ml Cartridge Nozzle	Helical (Orange), 18 element, 222mm, 13.0ml, #7100304367

Handling/Application Information

Directions for Use

1. To obtain the highest strength structural bonds, paint, oxide films, oils, dust, mold release agents, and all other surface contaminants must be completely removed. The amount of surface preparation depends on the required bond strength and environmental aging resistance desired by user. For suggested surface preparations on common substrates, see the section on surface preparation.

2. Mixing For Duo-Pak Cartridges
Store cartridges with cap end up to allow any air bubbles to rise towards the tip. To use, simply insert the cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. Then remove the cap and expel a small amount of adhesive to ensure material flows freely from both sides of cartridge. For automatic mixing, attach an EPX mixing nozzle to the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after obtaining a uniform color.

For Bulk Containers
Mix thoroughly by weight or volume in the proportion specified on the product label or in the typical uncured properties section. Mix approximately 15 seconds after obtaining a uniform color.

3. Apply adhesive and join surfaces within the open time listed for the specific product. Larger quantities and/or higher temperatures will reduce this working time.

4. Allow adhesive to cure at 16 °C (60 °F) or above until completely firm. Applying heat up to 66 °C (150 °F) will increase cure speed.

5. Keep parts from moving during cure. Apply contact pressure or fixture in place if necessary. Optimum bond line thickness ranges from 0.005 to 0.020 inch; shear strength will be maximized with thinner bond lines, while peel strength reaches a maximum with thicker bond lines.

6. Excess uncured adhesive can be cleaned up with ketone-type solvents.

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

Surface Preparation

3M™ Scotch-Weld™ Acrylic Adhesives are designed to be used on painted/coated metals, most bare metals, and most plastics and composite materials. The following cleaning methods are suggested for common surfaces:

Painted/coated metals:

1. Wipe surface free of dust and dirt with clean cloth and pure isopropyl alcohol.*

2. Sandblast or lightly abrade using clean fine grit abrasives. Do not completely remove the paint layer or coating down to bare steel.

3. Wipe again with clean cloth and pure isopropyl alcohol to remove loose particles.*

Bare metals:

1. Wipe surface free of dust and dirt with clean cloth and pure acetone.*

2. Sandblast or lightly abrade using clean fine grit abrasives.

3. Wipe again with clean cloth and pure acetone to remove loose particles.*

Plastics and composite materials:

1. Wipe surface free of dust and dirt with clean cloth and pure isopropyl alcohol.*

2. Lightly abrade using fine grit abrasives.

3. Wipe again with clean cloth and pure isopropyl alcohol to remove loose particles.*

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

Storage and Shelf Life

Store under normal conditions of 16° to 27 °C (60° to 80 °F) in the original packaging, out of direct sunlight. Refrigeration at 4 °C (40 °F) will help extend shelf life. Do not freeze. Allow product to reach room temperature prior to use. Use duo-pak containers within 18 months from date of manufacture. Bulk shelf life may vary; please consult your local 3M contact.

Product Family

This product is a part of the the Flexible Acrylic Family which includes: 3M™ Scotch-Weld™ Flexible Acrylic Adhesive DP8610NS, 3M™ Scotch-Weld™ Flexible Acrylic Adhesive DP8625NS

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

Information

Intended Use: This product is intended for bonding of materials specified and described in its Technical Data Sheet, when used in accordance with the guidance provided by 3M in such Technical Data Sheet and other product instructions. Since there are many factors that can affect a product's use, the customer remains responsible for determining whether the 3M product is suitable and appropriate for the customer's specific application and system, including customer conducting an appropriate risk assessment and evaluating the 3M product in customer's application and system.

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ISO Statement

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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