Dispensing Guide for 3M™ Scotch-Weld™ Two-Part Acrylic Adhesive DP8407NS

Technical Bulletin **March 2022**

Uncured Properties

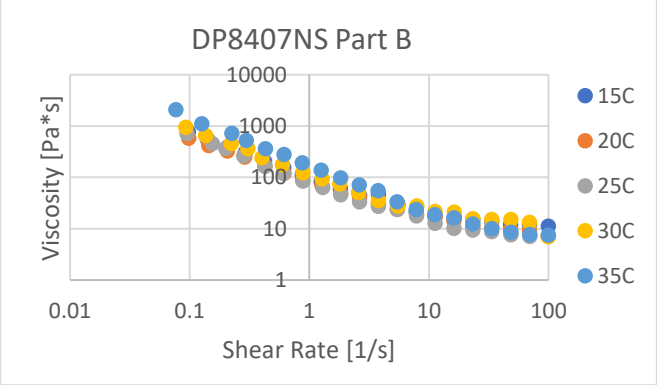
DP8407NS	B Base	A Accelerator
Color	Brown	Dark Grey
Ratio by volume	10	1
Ratio by weight	9	1
Density (lb/gal)	8.18	9.01
Thixotropic Index	4.95	4.9

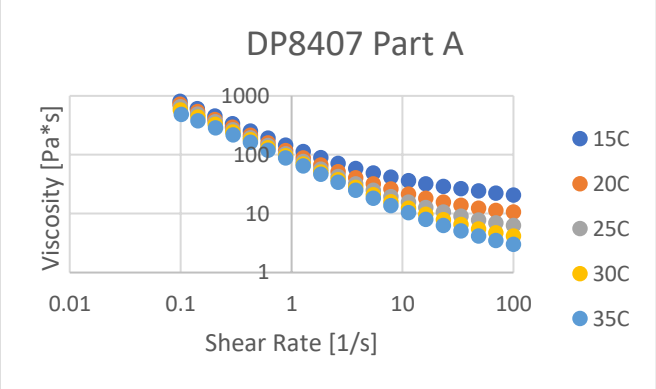
Packaging

	Description
45-50ml	B-System
200*/400ml	F-System
5-gallon pail	Straight sided I.D. of 341.31mm x 301.625mm
55-gallon drum	Straight Sided 596.9mm Dia x 906.78mm H

*where available

Viscosity/Rheology





*Note: Viscosity measurements done by cone and plate

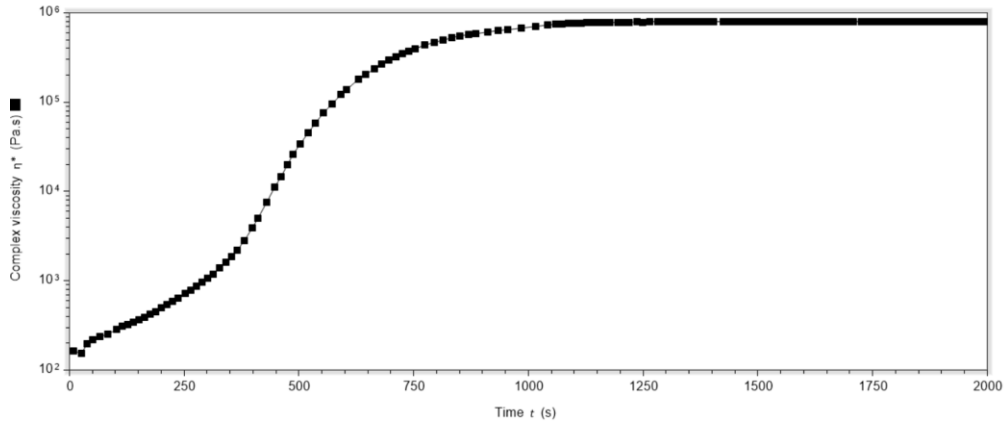
Cartridge Startup

When dispensing from a cartridge level the A&B pistons at initial set up. Material should be purged from the static mixer until a homogenous mix between parts A&B is achieved.

Purge Recommendation

For short purge times between runs the graph below shows the mixed viscosity of 8407NS over time, based on static mixer and purge volume use this graph for a recommended purge time. For a one component purge using bulk dispensers, purge with 8407NS Part B.

DP8407NS Mixed Viscosity vs. Time



*Note: Viscosity vs. time taken at 25°C

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Mixing Nozzles

45ml	490ml	
Quadro Mix Elements:16 Length (mm):90 Volume (ml):1.72 	Helical Mix Elements:18 Length (mm): 221.9 Volume (ml): 12.96 	Quad Mix Elements: 24 Length (mm):136.7 Volume (ml): 6.28 
Sku:7100007806	sku:7100015959	Sku:7100066351

Cleaning of Equipment

Excess uncured adhesive can be cleaned with methyl ethyl ketone (MEK). Follow equipment manufacturing procedures for cleaning of their equipment.

Abrasives

Contains glass beads (0.010” diameter) to control bond line thickness

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