Dispensing Guide for 3M™ Scotch-Weld™ Two-Part Epoxy Adhesive DP6310NS

Technical Bulletin **November 2021**

Uncured Properties

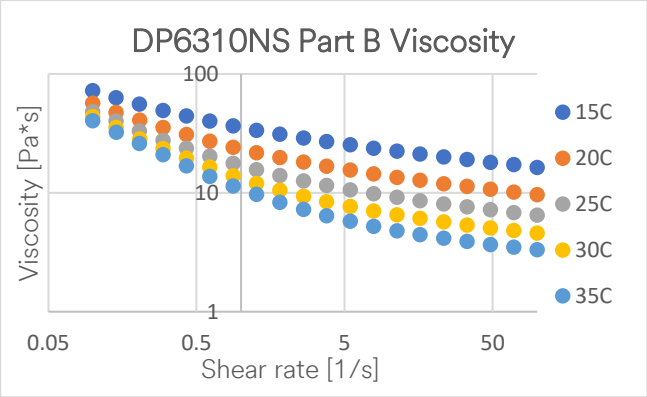
DP6310NS	B Base	A Accelerator
Color	Green	Off White
Ratio by volume	2	1
Ratio by weight	2	1.09
Density (lb/gal)	10-11	10.5-11.5
Viscosity (cP)	15,000-35,000	12,000-20,000
Thixotropic Index	1.7	2.8

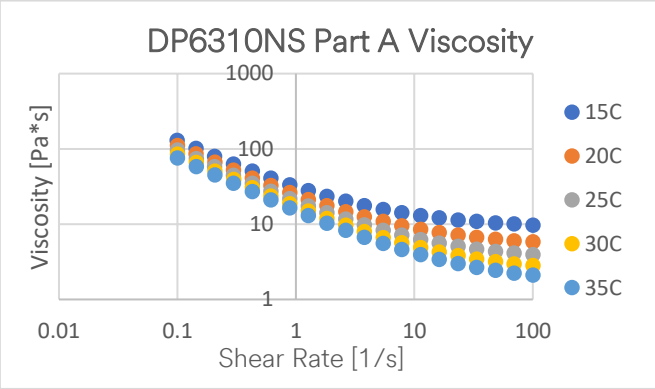
Packaging

	Description
45-50ml	Mixpac B system
200*/400ml	Mixpac C system
5-gallon pail	Straight sided I.D. of 341.31mm x 285.75mm
55-gallon drum	Straight Sided 603.25mm Dia x 884.22mm H

*where available

Viscosity/Rheology





*Note: Viscosity measurements done by cone and plate

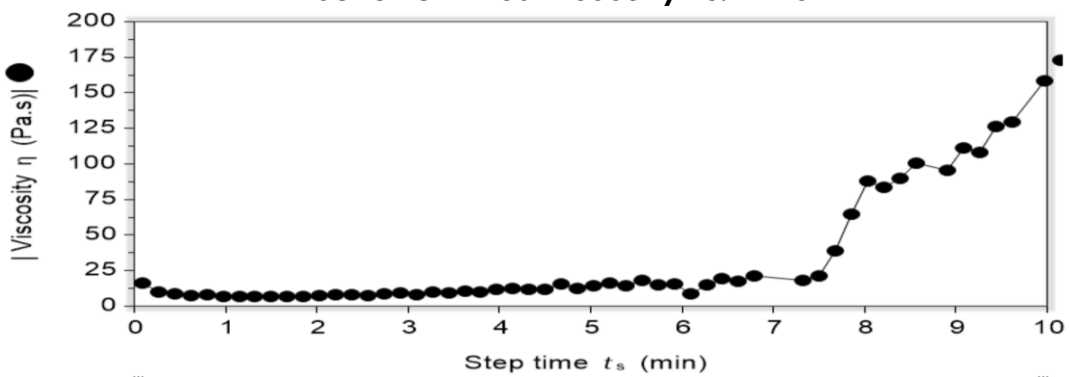
Cartridge Startup

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 DP6310NS 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 DP6310NS Part B.

DP6310NS Mixed Viscosity vs. Time



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

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50ml	200/400ml		
Quadro Mix Elements:16 Length (mm):85 Volume (ml):1.88 	Helical Mix Elements:24 Length (mm): 185 Volume (ml): 4.20 	Quad Mix Elements: 20 Length (mm):126.9 Volume (ml): 5.4 	Helical Mix Elements: 24 Length (mm) 277 Volume (ml): 14.60 
sku:7100148765	sku:7000046633	sku:7000028616	sku: 7000043674

Cleaning of Equipment

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

Abrasives

No abrasive fillers are used in this material.

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