

3M Science.
Applied to Life.™

Apply, bond and go.

Meet the future of bracket bonding. This revolutionary, two-part structural paste adhesive instantly holds parts in place with no sag, no mess and no installation fixtures required. You'll reduce waste, save money and increase productivity.

- ▶ Fast and easy to apply
- ▶ Cures within 90 minutes to handling strength
- ▶ Fewer steps – simplifies your process
- ▶ High mechanical strength
- ▶ Qualified to Aerospace OEM specifications





Strong.

Excellent shear and peel strength on substrates used in the aerospace and transportation sectors.



Fast.

Ideal for bonding fasteners, brackets, studs and standoffs.



Neat.

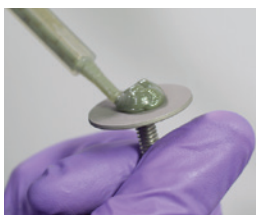
Easy-to-use cartridges ensure precise, neat and consistent application.



Safe.

Low-flow adhesive can be safely used in vertical and overhead applications.

Easy 3-step process:



Step 1:
Apply adhesive to bracket



Step 2:
Bond to desired surface



Step 3:
Go – no support needed

Product information:

Properties	Part B	Part A	Test method
Chemical base	Modified epoxy	Modified amine	
Colour	Yellow	Dark grey	
Consistency	Paste	Paste	
Density	1.10 g/cm ³	1.07 g/cm ³	ISO 2811
Mix ratio by volume	100	50	
Viscosity @ 73°F (23°C)	440 Pa·s	270 Pa·s	Rheometer (AITM 3-0004)
Cure time to handling	435 psi (3 MPa) after 90 min at 73°F (23°C)		EN 2243-1
Shear strength	Up to 5,075 psi (35 MPa)		ISO 4587
Overlap shear strength*	60 min 43.5 psi (0.3 MPa) 90 min 470 psi (3.3 MPa) 104 min 2,132 psi (14.7 MPa) 120 min 2,944 psi (20.3 MPa) 150 min 4,409 psi (30.4 MPa)		EN 2243-1
Temperature range	-67°F to 185°F (-55°C to 85°C)		
Colour in mixed state	Olive green		
Work life	10 min @ 73°F (23°C)		Internal test method**
Extrudability [50 ml Cartridge, 73°F (23°C)]	20 min extrudable from mixing nozzle (EPX Quadro, Art. 300 346: 5.3/16)		
Available packaging	50 ml duo-pack cartridge, others on request		
Dispenser	Scotch-Weld EPX Manual Dispenser III for 50ml cartridges		
Nozzles	Scotch-Weld EPX Quadro Structural Adhesive Nozzles		

*Test conditions: Clad Al 2024 T3, thickness 1.6 mm, surface treatment: CAA + primer BR127, test speed: 10 mm/min.

**Time during which the adhesive can be applied properly.

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3M Aerospace and Commercial Transport Division

3M United Kingdom PLC
3M Centre, Cain Road
Bracknell, Berkshire RG12 8HT
Tel: 0870 6080 060
www.3M.co.uk/ec7202
aerospaceuk@mmm.com

3M Ireland Limited
The Iveagh Building
The Park, Carrickmines
Dublin 18
Tel: 1 800 303 437

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