



# Dispensing Guide for 3M™ Scotch-Weld™ Two-Part Epoxy Adhesive DP420 Black

Technical Bulletin

November 2021

## Uncured Properties

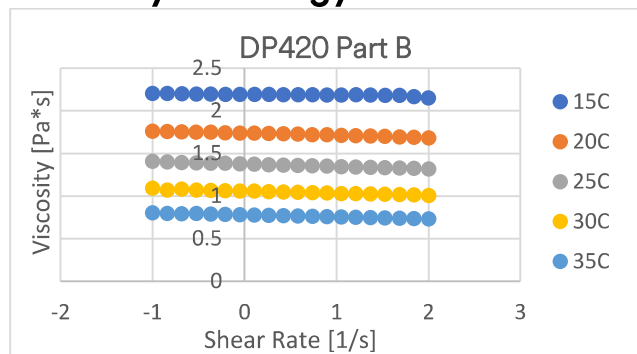
DP420 Black	B Base	A Accelerator
Color	Black	Amber
Ratio by volume	2	1
Ratio by weight	2	0.97
Density (lb/gal)	9.3-9.7	9.0-9.4
Viscosity (cP)	20,000-50,000	8,000-14,000
Thixotropic Index	1.06	1.96

## Packaging

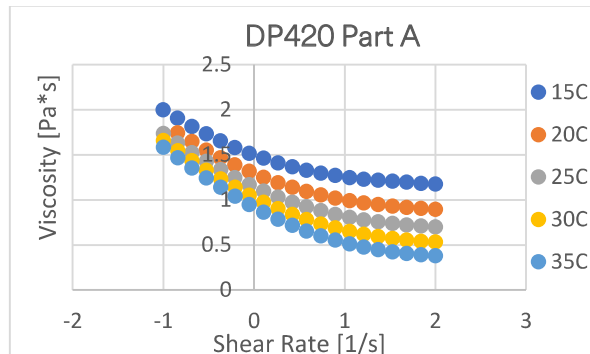
	Description
45-50ml	Mixpac B system
200*/400ml	Mixpac C system
5-gallon pail	Straight sided I.D. of 341.31mm x 285.75mm
55-gallon drum	Straight Sided 603.25mm Dia x 884.22mm H

\*where available

## Viscosity/Rheology



\*Note: Viscosity measurements done by cone and plate



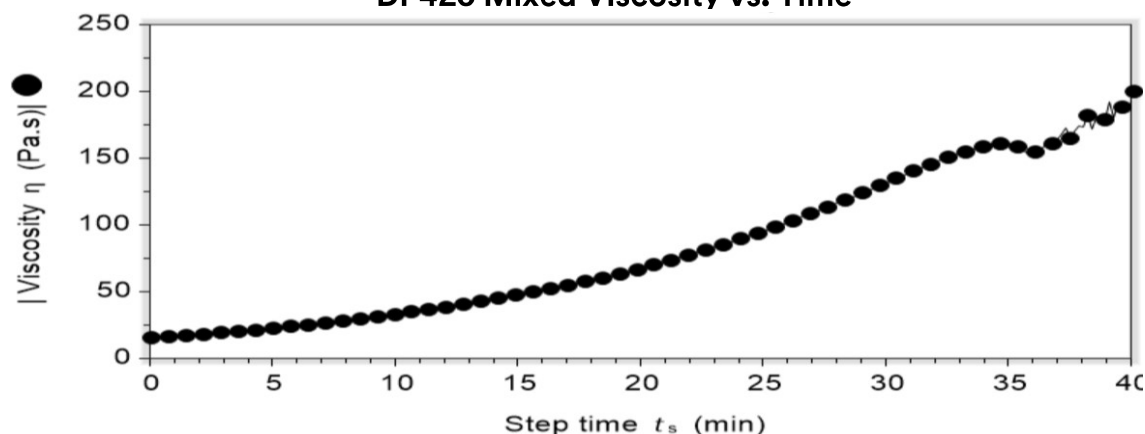
## Cartridge Startup

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 DP420 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 DP420 Part B.

DP420 Mixed Viscosity vs. Time







\*Note: Viscosity vs Time measurement at 25°C

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### Mixing Nozzles

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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