
3M Science. Applied to Life.™
3M Scotch-Weld™
Structural Adhesive
Duo-Pak Delivery System Updates
Q1 2018

Better dispensing, better results.

As of Q1 2018, the 3M™ Scotch-Weld™ Structural Adhesive Duo-Pak delivery systems will feature updates and improvements to help provide better adhesive delivery and results.

Improvements to the updated delivery systems in the 3M Duo-Paks include:

- New seal to eliminate cartridge leaks
- New isolated outlet to prevent cross-contamination
- Updated cap to prevent accidental bonding of cap to cartridge
- Cartridge volume changes
- Manual plunger and nozzle changes
- Pneumatic applicator changes

New seal to eliminate cartridge leaks

The new pistons use a double lip seal instead of an O-ring seal design to help eliminate leaks due to chemical incompatibilities that cause O-rings to swell and degrade over time.

CURRENT
PISTON SEAL DESIGN



NEW
PISTON SEAL DESIGN



BETTER CHEMICAL COMPATIBILITY

New cartridge end sealing flange

A sealing flange at the rear of the cartridge chambers “locks” the above pistons in position so these products can be qualified for air shipments without leaks around pistons.

New isolated outlet to prevent cross-contamination

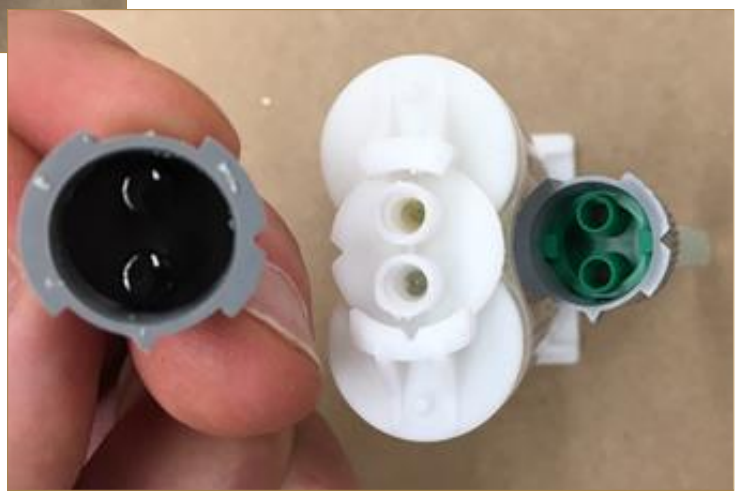
The current cap can be installed backwards on a partially dispensed cartridge, permanently sealing the cartridge shut. This renders the remaining adhesive useless.

The new cap is keyed and cannot be installed backwards, so partially consumed cartridges can be saved and used later.



CURRENT
CARTRIDGE CAP

NEW
CARTRIDGE CAP



LESS CROSS-CONTAMINATION

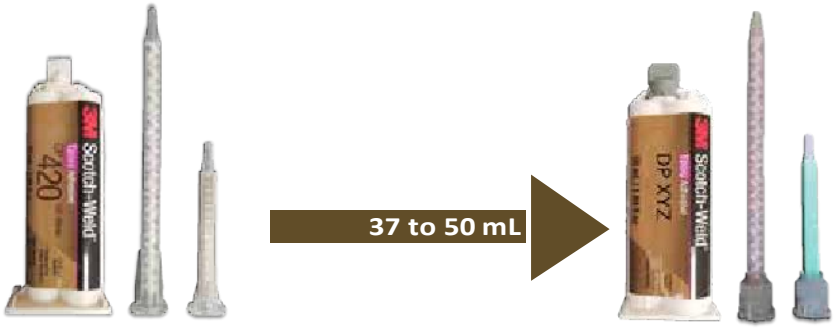
Cartridge volume changes

The contained volume of the 3M Duo-Pack cartridges has changed.

	OLD DELIVERY SYSTEM	NEW DELIVERY SYSTEM
1:1 System	47.0 or 50.0 mL	48.5 mL
2:1 System	37.0 mL	50.0 mL
2:3 System	43 mL	No change – see below*

In addition, the new 1:1 System has one cartridge style, instead of three per the old packaging.

2:1 RATIO STRUCTURAL ADHESIVE



CURRENT
DELIVERY SYSTEM (37 mL)

NEW
DELIVERY SYSTEM (50 mL)

1:1 RATIO STRUCTURAL ADHESIVE



CURRENT
DELIVERY SYSTEM (3 cartridge styles)

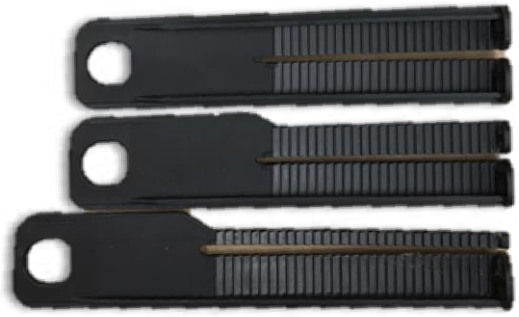
NEW
DELIVERY SYSTEM (1 cartridge style)

*3M EC-2216 is the only Duo-Pak adhesive delivery system that will not change. This product will continue to use the old 2:1 plunger and the helical and square static mixers. However, a pneumatic applicator for this product will no longer be available from 3M.

Manual plunger and nozzle changes

A portion of the 3M™ EPX™ Plus II Manual Applicator Plunger Set has changed. The applicator has remained the same, but the plungers have changed to accommodate the new 50 mL / 2:1 cartridge size. Please refer to the table below to determine which hardware accessories work with the new and improved cartridge delivery system.

CURRENT PLUNGER SET



1:1 PLUNGER

2:1 PLUNGER

10:1 PLUNGER



Applicator

NEW PLUNGER SET



1:1 / 2:1 PLUNGER (Shared)

10:1 PLUNGER (Same as current)

Pneumatic applicator changes

The pneumatic applicator is required only for the larger (50 mL) 2:1 cartridge size. The new model is lightweight and has improved ergonomics. Please refer to the table on the following page to determine which hardware accessories work with the new and improved cartridge delivery system.

CURRENT

PNEUMATIC APPLICATOR



NEW

PNEUMATIC APPLICATOR



Frequently asked questions

Q: Will the chemistry of the products change?

A: No, the chemistry of the adhesives will stay the same.

Q: Will the price of the adhesives change?

A: No, the price per milliliter of adhesive will stay the same.

Q: Will the stock numbers and UPCs change?

A: Yes, the new delivery systems will have updated stock and UPC numbers.

Q: Will static mixers change?

A: Yes, static mixers will change to accommodate the isolated port design of the new cartridges.

Q: How will the plunger set for the EPX Plus II Manual Applicator work with the new delivery system?

A: There will be one shared plunger that works with the 48.5 mL 1:1 series and the 2:1 50 mL series. No plunger changes for the 45 mL 10:1 series.

Q: How will the updates affect the way the delivery system works with the pneumatic applicator?

A: A new pneumatic applicator is designed to work with the 48.5 mL 1:1 series and the 50 mL 2:1 series.

Q: Will the quantity of cartridges per case change?

A: No, the cartridge quantity will stay the same.

Q: Will the country of origin, SDS and TDS for the products change?

A: No, the country of origin, SDS and TDS for the products will stay the same.

Q: How do I get my starter kit?

A: To get your starter kit, please contact your local sales representative or call 1-800-362-3550.

Q: Who do I contact to find my local 3M representative to get more information?

A: Outside the United States, please e-mail bdbrady@mmm.com. Within the United States, contact 1-800-362-3550.

Ordering Information

Product ID	Stock Number	UPC Number	Product Description	Size (mL)	Plunger Needed	Nozzle Needed
Conversion Kit	62-9999-9940-2		INCLUDES: 1 plunger (1:1/2:1 shared) plus 12 square green nozzles		Stock number 62-9170-9913-7	Stock number 62-9154-9148-4
1:1/2:1 Plunger	62917099137 7010415317	00063806010000	3M™ Scotch-Weld™ EPX™ Plus II 1:1/2:1 Plunger for 48.5/50mL, 10 per case		--	--
DP100 Clear	62357514371 7100148763	00638060089941	3M™ Scotch-Weld™ Epoxy Adhesive DP100, Clear, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP100 PLUS Clear	62327214367 7100148750	00638060089767	3M™ Scotch-Weld™ Epoxy Adhesive DP100 Plus, Clear, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP100FR Cream	62353114366 7100148760	00638060089897	3M™ Scotch-Weld™ Epoxy Adhesive DP100FR, Cream, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP100NS Translucent	62326514361 7100148744	00638060089743	3M™ Scotch-Weld™ Epoxy Adhesive DP100NS, Translucent, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP105 Clear	62328714365 7100148733	00638060089811	3M™ Scotch-Weld™ Epoxy Adhesive DP105, Clear, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP110 Gray	62353314313 7100148777	00638060089903	3M™ Scotch-Weld™ Epoxy Adhesive DP110, Gray, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP110 Translucent	62356314385 7100148762	00638060089934	3M™ Scotch-Weld™ Epoxy Adhesive DP110, Translucent, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP125 Translucent	62329114367 7100148734	00638060089835	3M™ Scotch-Weld™ Epoxy Adhesive DP125, Translucent, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP125 Gray	62329314371 7100148735	00638060089859	3M™ Scotch-Weld™ Epoxy Adhesive DP125, Gray, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP125LH Gray	62280414368 7100148746	00638060089705	3M™ Scotch-Weld™ Epoxy Adhesive DP125LH, Gray, 50mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP190 Translucent	62328614367 7100148752	00638060089804	3M™ Scotch-Weld™ Epoxy Adhesive DP190, Translucent, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP190 Gray	62355314360 7010410438	00638060089927	3M™ Scotch-Weld™ Epoxy Adhesive DP190, Gray, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP270 Clear	62326214368 7100148730	00638060089736	3M™ Scotch-Weld™ Epoxy Potting Compound DP270, Clear, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4

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Product ID	Stock Number	UPC Number	Product Description	Size (mL)	Plunger Needed	Nozzle Needed
DP270 Black	62326614369 7100148745	00638060089750	3M™ Scotch-Weld™ Epoxy Potting Compound DP270, Black, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP405 Black	62281414367 7100148728	00638060089712	3M™ Scotch-Weld™ Epoxy Adhesive DP405, Black, 50mL Duo-Pak, 12 per case	50	NEW PLUNGER NEEDED, 2:1, stock number 62-9170-9913-7	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP420 Black	62277814364 7100148731	00638060089668	3M™ Scotch-Weld™ Epoxy Adhesive DP420, Black, 50mL Duo-Pak, 12 per case	50	NEW PLUNGER NEEDED, 2:1, stock number 62-9170-9913-7	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP420 Off-White	62328014360 7100148736	00638060089781	3M™ Scotch-Weld™ Epoxy Adhesive DP420, Off-White, 50mL Duo-Pak, 12 per case	50	NEW PLUNGER NEEDED, 2:1, stock number 62-9170-9913-7	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP420LH Off-White	62281814368 7100148729	00638060089729	3M™ Scotch-Weld™ Epoxy Adhesive DP420LH, Off-White, 50mL Duo-Pak, 12 per case	50	NEW PLUNGER NEEDED, 2:1, stock number 62-9170-9913-7	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP420NS Black	62329914360 7100148758	00638060089873	3M™ Scotch-Weld™ Epoxy Adhesive DP420NS, Black, 50mL Duo-Pak, 12 per case	50	NEW PLUNGER NEEDED, 2:1, stock number 62-9170-9913-7	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP460 Off-White	62359314366 7100148768	00638060089989	3M™ Scotch-Weld™ Epoxy Adhesive DP460, Off-White, 50mL Duo-Pak, 12 per case	50	NEW PLUNGER NEEDED, 2:1, stock number 62-9170-9913-7	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP460NS Off-White	62279214365 7100148751	00638060089682	3M™ Scotch-Weld™ Epoxy Adhesive DP460NS, Off-White, 50mL Duo-Pak, 12 per case	50	NEW PLUNGER NEEDED, 2:1, stock number 62-9170-9913-7	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP5001 Black	62352850333 7100148759	00638060089880	3M™ Scotch-Weld™ Polyurethane Sealant DP5001, Black, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP600 Gray	62264950320 7100148740	00638060089620	3M™ Scotch-Weld™ Concrete Repair DP600 Self-Leveling, Gray, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP600NS Gray	62265250324 7100148747	00638060089644	3M™ Scotch-Weld™ Concrete Repair DP600NS Non-Sag, Gray, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP601 Gray	62264950338 7100148741	00638060089637	3M™ Scotch-Weld™ Urethane Adhesive DP601, Gray, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP601NS Gray	62265250332 7100148749	00638060089651	3M™ Scotch-Weld™ Urethane Adhesive DP601NS, Gray, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP604NS Black	62264850314 7100148738	00638060089613	3M™ Scotch-Weld™ Urethane Adhesive DP604NS, Black, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP605NS Off-White	62359214368 7100148767	00638060089972	3M™ Scotch-Weld™ Urethane Adhesive DP605NS, Off-White, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP620NS Black	62264550310 7100148737	00638060089606	3M™ Scotch-Weld™ Urethane Adhesive DP620NS, Black, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP640 Brown	62354914368 7100148761	00638060089910	3M™ Scotch-Weld™ Urethane Adhesive DP640, Brown, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4

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Product ID	Stock Number	UPC Number	Product Description	Size (mL)	Plunger Needed	Nozzle Needed
DP805 Off-White	62328814363 7010410436	00638060089828	3M™ Scotch-Weld™ Acrylic Adhesive DP805, Off-White, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP810 Black	62278814363 7100148732	00638060089675	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP810, Black, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP810 Tan	62329814362 7100148757	00638060089866	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP810, Tan, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP810NS Tan	62279914360 7100148748	00638060089699	3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP810NS, Tan, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
DP820 Off-White	62327714366 7010412194	00638060089774	3M™ Scotch-Weld™ Acrylic Adhesive DP820, Off-White, 48.5mL Duo-Pak, 12 per case	48.5	Current 1:1 plunger will work, stock number 62-9170-9912-9	NEW NOZZLE NEEDED, square green, stock number 62-9154-9148-4
EPX Mix Nozzle Helical	62917891517 7100148766	00063806010048	3M™ Scotch-Weld™ EPX™ Mix Nozzle Helical, for 48.5/50mL, 72 per case		--	--
EPX Mix Nozzle Helical (2000)	62917899510 7100148756	00063806010055	3M™ Scotch-Weld™ EPX™ Mix Nozzle Helical, for 48.5/50mL, 2000 per case		--	--
EPX Mix Nozzle Square Green	62915491484	00076308864347	3M™ Scotch-Weld™ EPX™ Mix Nozzle Square Green, for 48.5/50mL, 12 per bag, 36 per case		--	--
EPX Mix Nozzle Square Green (1200)	62917199549	00063806010031	3M™ Scotch-Weld™ EPX™ Plus II Square Green Mixing Nozzle, for 48.5/50mL, 1200 per case		--	--
EPX Plus II Applicator	62917099327 7100148764	00063806010017	3M™ Scotch-Weld™ EPX™ Plus II Applicator with 1:1/2:1 and 10:1 Plungers for 48.5/50mL, 10 per case		--	--
EPX Pneumatic Applicator	62978199313 7100148769	00063806010062	3M™ EPX™ Pneumatic Applicator, for 48.5/50mL, 1 per case		--	--

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Industrial Adhesives & Tapes Division
3M Center
Building 225-3S-06
St. Paul, MN 55144-1000
1-800-362-3550
www.3M.com/structuraladhesives

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