



# Urethane Adhesives and Sealants

*Bonding and sealing when your application demands durability and flexibility*



When substrates move, expand and contract, or require joint flexibility, you'll want to consider 3M urethane adhesives and sealants. You'll have choices for fast, flexible, and strong bonding and sealing for a wide variety of substrates including metal, wood, concrete, and many plastics.

In the selection chart on the back, you'll find open times ranging from 50 seconds to 90 minutes, and handling strength in as few as 5 minutes. 3M also offers a variety of container sizes and dispensing equipment to meet your production volume needs.

## Versatility for many applications

General industrial	MRO	Signs	Transportation
			
<ul style="list-style-type: none"> <li>• Parts assembly</li> <li>• Large panel bonding</li> <li>• Flexible sealing</li> </ul>	<ul style="list-style-type: none"> <li>• Crack repair</li> <li>• Expansion joints</li> <li>• Belt repair</li> <li>• General bonding</li> </ul>	<ul style="list-style-type: none"> <li>• Bond acrylic, polycarbonate</li> <li>• Primed metal</li> <li>• Glass</li> </ul>	<ul style="list-style-type: none"> <li>• Panel bonding</li> <li>• Bumpers</li> <li>• Filletting</li> <li>• Interior</li> </ul>
Products: 604, 605, 620, 640, 5001	Products: 601, 601NS, 620, 5001, 5005	Products: 604, 620, 5006	Products: 540, 560, 620, 640, 5003

# 3M™ Urethane Adhesives and Sealants

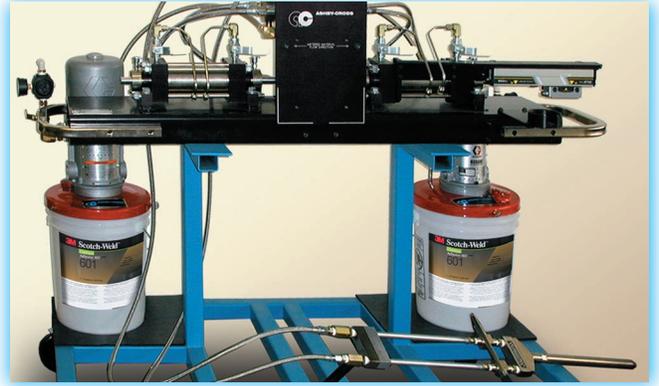
3M Product Number	Color	Viscosity	Work Life (Room Temp)	Handling Time (Room Temp)	Cure Time (Room Temp)	Shore Hardness	Lap Shear Etched Aluminum (PSI at 77°F/25°C) ASTM D1002	Service Temp °F
DP-640	Brown	Non-sag	40 min.	8 hrs.	7 days	65 D	2000	-60 to 250
DP-620 NS	Black	Non-sag	20 min.	4 hrs.	48 hrs.	50 D	2500	-60 to 250
DP-608	Black	Non-sag	8 min.	90 min.	24 hrs.	60 D	2000	-60 to 250
DP-605 NS	Off-white	Non-sag	5 min.	20 min.	48 hrs.	60 D	1450	-60 to 250
DP-604 NS	Black	Non-sag	4 min.	30 min.	6 hrs.	85 A	900	-60 to 250
DP-601	Gray	Self-leveling	70 sec.	5 min.	1 hr.	70 D	2300	-60 to 250
DP-601 NS	Gray	Non-sag	50 sec.	4 min.	1 hr.	70 D	2300	-60 to 250
DP-900*	Beige	NA*	15 sec.	35 sec.	15 min.	NA*	NA*	-60 to 250
DP-5001	Black	Self-leveling	1 min.	15 min.	12 hrs.	72 A	600	-60 to 250
DP-5003	Black	Non-sag	3 min.	60 min.	24 hrs.	75 A	500	-60 to 250
DP-5005	Gray, Black, Beige	Self-leveling	5 min.	9 hrs.	24 hrs.	35 A	150	-60 to 250
DP-5006	Gray	Self-leveling	6 min.	40 min.	24 hrs.	85 A	1100	-60 to 250
540	White, Black, Gray	Non-sag	90 min.	4 to 6 hrs.	24 hrs.	45 A	250	-40 to 194
560	White, Black, Gray	Non-sag	50 min.	4 to 6 hrs.	24 hrs.	55 A	450	-40 to 194

\* Expanding foam for insulation and damming

## Dispensing systems to meet your volume requirements



**Left to right:** Lightweight 3M™ EPX™ Plus II Applicator for low volume applications with 50 ml Duo-Pak cartridges. 12 fl. oz. pneumatic applicator and 12 fl. oz. manual applicator for higher volume applications with 12 oz. Duo-Pak cartridges. Commercially available bulk equipment for use with 5-gallon pails (at right) and 55 gallon drums.



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### Industrial Business Industrial Adhesives and Tapes Division

3M Center Bldg. 21-1W-10  
900 Bush Avenue,  
St. Paul, MN 55144-1000  
1-800-362-3550



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