



Scotch-Weld™ Epoxy Adhesive

2216 B/A

Technical Data

October 2018

Product Description 3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A is a flexible, two-part, room temperature curing epoxy with high peel and shear strength, available in three versions. 2216 B/A Gray meets DOD-A-82720.

Typical Uncured Physical Properties Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Product	3M™ Scotch-Weld™ Epoxy Adhesive					
	2216 B/A Gray		2216 B/A Tan NS		2216 B/A Translucent	
	Base	Accelerator	Base	Accelerator	Base	Accelerator
Color:	White	Gray	White	Tan	Translucent	Amber
Base:	Modified Epoxy	Modified Amine	Modified Epoxy	Modified Amine	Modified Epoxy	Modified Amine
Net Wt.: (lb/gal)	11.1-11.6	10.5-11.0	11.1-11.6	10.5-11.0	9.4-9.8	8.0-8.5
Viscosity: (cps) (Approx.) Brookfield RVF #7 sp. @ 20 rpm	75,000 - 150,000	40,000 - 80,000	75,000 - 150,000	550,000 - 900,000	11,000 - 15,000	5,000 - 9,000
Mix Ratio: (by weight)	5 parts	7 parts	5 parts	7 parts	1 part	1 part
Mix Ratio: (by volume)	2 parts	3 parts	2 parts	3 parts	1 part	1 part
Work Life: 100 g Mass @ 75°F (24°C)	90 minutes	90 minutes	120 minutes	120 minutes	120 minutes	120 minutes

Features

- Excellent for bonding many metals, woods, plastics, rubbers, and masonry products.
- Base and Accelerator are contrasting colors.
- Good retention of strength after environmental aging.
- Resistant to extreme shock, vibration, and flexing.
- Excellent for cryogenic bonding applications.
- Excellent for potting parts subject to thermal cycling.
- The tan NS Adhesive is non-sag for greater bond-line control.
- The translucent can be injected.
- Meets DOD-A-82720.

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A

Typical Cured Physical Properties

Product	3M™ Scotch-Weld™ Epoxy Adhesive		
	2216 Gray	2216 Tan NS	2216 Translucent
Color	Gray	Tan	Translucent
Shore D Hardness ASTM D 2240	50-65	65-70	35-50
Time to Handling Strength	8-12 hrs.	8-12 hrs.	12-16 hrs.

Typical Cured Electrical Properties

Product	3M™ Scotch-Weld™ Epoxy Adhesive	
	2216 Gray	2216 Translucent
Arc Resistance	130 seconds	
Dielectric Strength	408 volts/mil	630 volts/mil
Dielectric Constant @ 73°F (23°C)	5.51–Measured @ 1.00 KHz	6.3 @ 1 KHz
Dielectric Constant @ 140°F (60°C)	14.17–Measured @ 1.00 KHz	—
Dissipation Factor 73°F (23°C)	0.112 Measured @ 1.00 KHz	0.119 @ 1 KHz
Dissipation Factor 140°F (60°C)	0.422–Measured @ 1.00 KHz	—
Surface Resistivity @ 73°F (23°C)	5.5 x 10 ¹⁶ ohm–@ 500 volts DC	—
Volume Resistivity @ 73°F (23°C)	1.9 x 10 ¹² ohm-cm–@ 500 volts DC	3.0 x 10 ¹² ohm-cm @ 500 volts DC

Typical Cured Thermal Properties

Product	3M™ Scotch-Weld™ Epoxy Adhesive	
	2216 Gray	2216 Translucent
Thermal Conductivity	0.228 Btu-ft/ft ² h °F	0.114 Btu-ft/ft ² h °F
Coefficient of Thermal Expansion	102 x 10 ⁻⁶ in/in/°C between 0-40°C 134 x 10 ⁻⁶ in/in/°C between 40-80°C	81 x 10 ⁻⁶ in/in/°C between -50-0°C 207 x 10 ⁻⁶ in/in/°C between 60-150°C

Typical Cured Outgassing Properties

Outgassing Data
NASA 1124 Revision 4

	% TML	% CVCM	% Wtr
3M™ Scotch-Weld™ Epoxy Adhesive 2216 Gray	.77	.04	.23

Cured in air for 7 days @ 77°F (25°C).

Handling/Curing Information

Directions for Use

1. For high strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user. For suggested surface preparations of common substrates, see the following section on surface preparation.
2. These products consist of two parts. Mix thoroughly by weight or volume in the proportions specified on the product label and in the uncured properties section. Mix approximately 15 seconds after a uniform color is obtained.

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A

Handling/Curing
Information
(continued)

3. For maximum bond strength, apply product evenly to both surfaces to be joined.
4. Application to the substrates should be made within 90 minutes. Larger quantities and/or higher temperatures will reduce this working time.
5. Join the adhesive coated surfaces and allow to cure at 60°F (16°C) or above until firm. Heat, up to 200°F (93°C), will speed curing.
6. The following times and temperatures will result in a full cure:

Product	3M™ Scotch-Weld™ Epoxy Adhesive		
	2216 Gray	2216 Tan NS	2216 Translucent
Cure Temperature	Time	Time	Time
75°F (24°C)	7 days	7 days	30 days
150°F (66°C)	120 minutes	120 minutes	240 minutes
200°F (93°C)	30 minutes	30 minutes	60 minutes

7. Keep parts from moving until handling strength is reached. Contact pressure is necessary. Maximum shear strength is obtained with a 3-5 mil bond line. Maximum peel strength is obtained with a 17-25 mil bond line.
8. Excess uncured adhesive can be cleaned up with ketone type solvents.*
Adhesive Coverage: A 0.005 in. thick bondline will typically yield a coverage of 320 sq. ft/gallon

Application and
Equipment
Suggestions

These products may be applied by spatula, trowel or flow equipment. Two-part mixing/proportioning/dispensing equipment is available for intermittent or production line use. These systems are ideal because of their variable shot size and flow rate characteristics and are adaptable to many applications.

Surface Preparation

For high strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user. The following cleaning methods are suggested for common surfaces.

Steel or Aluminum (Mechanical Abrasion)

1. Wipe free of dust with oil-free solvent such as acetone or alcohol solvents.*
2. Sandblast or abrade using clean fine grit abrasives (180 grit or finer).
3. Wipe again with solvents to remove loose particles.
4. If a primer is used, it should be applied within 4 hours after surface preparation.

*When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use. Use solvents in accordance with local regulations.

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A

Surface Preparation (continued)

Aluminum (Chemical Etch)

Aluminum alloys may be chemically cleaned and etched as per ASTM D 2651. This procedure states to:

1. Alkaline Degrease – Oakite 164 solution (9-11 oz/gal of water) at 190°F ± 10°F (88°C ± 5°C) for 10-20 minutes. Rinse immediately in large quantities of cold running water.

2. Optimized FPL Etch Solution (1 liter):

Material	Amount
Distilled Water	700 ml plus balance of liter (see below)
Sodium Dichromate	28 to 67.3 grams
Sulfuric Acid	287.9 to 310.0 grams
Aluminum Chips	1.5 grams/liter of mixed solution

To prepare 1 liter of this solution, dissolve sodium dichromate in 700 ml of distilled water. Add sulfuric acid and mix well. Add additional distilled water to fill to 1 liter. Heat mixed solution to 66 to 71°C (150 to 160°F). Dissolve 1.5 grams of 2024 bare aluminum chips per liter of mixed solution. Gentle agitation will help aluminum dissolve in about 24 hours.

To etch aluminum panels, place them in FPL etch solution heated to 66 to 71°C (150 to 160°F). Panels should soak for 12 to 15 minutes.

3. Rinse: Rinse panels in clear running tap water.

4. Dry: Air dry 15 minutes; force dry 10 minutes (minimum) at 140°F (60°C) maximum.

5. If primer is to be used, it should be applied within 4 hours after surface preparation.

Plastics/Rubber

1. Wipe with isopropyl alcohol.*

2. Abrade using fine grit abrasives (180 grit or finer).

3. Wipe with isopropyl alcohol.*

Glass

1. Solvent wipe surface using acetone or MEK.*

2. Apply a thin coating (0.0001 in. or less) of 3M™ Scotch-Weld™ Structural Adhesive Primer EC-3901 to the glass surfaces to be bonded and allow the primer to dry a minimum of 30 minutes @ 75°F (24°C) before bonding.

*When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use. Use solvents in accordance with local regulations.

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A

Typical
Adhesive
Performance
Characteristics

A. Typical Shear Properties on Etched Aluminum
ASTM D 1002
Cure: 2 hours @ 150 ± 5°F (66°C ± 2°C), 2 psi pressure

Test Temperature	Overlap Shear (psi)		
	3M™ Scotch-Weld™ Epoxy Adhesive		
	2216 B/A Gray Adhesive	2216 B/A Tan NS Adhesive	2216 B/A Trans. Adhesive
-423°F (-253°C)	2440	—	—
-320°F (-196°C)	2740	—	—
-100°F (-73°C)	3000	—	—
-67°F (-53°C)	3000	2000	3000
75°F (24°C)	3200	2500	1700
180°F (82°C)	400	400	140

Test Temperature	Shear Modulus (Torsion Pendulum Method)
-148°F (-100°C)	398,000 psi (2745 MPa)
-76°F (-60°C)	318,855 psi (2199 MPa)
-40°F (-40°C)	282,315 psi (1947 MPa)
32°F (0°C)	218,805 psi (1500 MPa)
75°F (24°C)	49,580 psi (342 MPa)

B. Typical T-Peel Strength
ASTM D 1876

Test Temperature	T-Peel Strength (piw) @ 75°F (24°C)		
	3M™ Scotch-Weld™ Epoxy Adhesive		
	2216 B/A Gray Adhesive	2216 B/A Tan NS Adhesive	2216 B/A Trans. Adhesive
75°F (24°C)	25	25	25

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A

Typical
Adhesive
Performance
Characteristics
(continued)

C. Overlap Shear Strength After Environmental Aging-Etched Aluminum

Environment	Time	Overlap Shear (psi) 75°F (24°C)		
		3M™ Scotch-Weld™ Epoxy Adhesive		
		2216 B/A Gray Adhesive	2216 B/A Tan NS Adhesive	2216 B/A Trans. Adhesive
100% Relative Humidity @ 120°F (49°C)	14 days 30 days 90 days	2950 psi 1985 psi 1505 psi	3400 psi 2650 psi	1390 psi
*Salt Spray @ 75°F (24°C)	14 days 30 days 60 days	2300 psi 500 psi 300 psi	3900 psi 3300 psi	1260 psi
Tap Water @ 75°F (24°C)	14 days 30 days 90 days	3120 psi 2942 psi 2075 psi	3250 psi 2700 psi	1950 psi
Air @ 160°F (71°C)	35 days	4650 psi	4425 psi	
Air @ 300°F (149°C)	40 days	4930 psi	4450 psi	3500 psi
Anti-icing Fluid @ 75°F (24°C)	7 days	3300 psi	3050 psi	2500 psi
Hydraulic Oil @ 75°F (24°C)	30 days	2500 psi	3500 psi	2500 psi
JP-4 Fuel	30 days	2500 psi	2750 psi	2500 psi
Hydrocarbon Fluid	7 days	3300 psi	3100 psi	3000 psi

*Substrate corrosion resulted in adhesive failure.

D. Heat Aging of 3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A Gray (Cured for 7 days @ 75°F [24°C])

Overlap Shear (psi)	Time aged @ 300°F (149°C)			
Test Temperature	0 days	12 days	40 days	51 days
-67°F (-53°C)	2200	3310	3120	2860
75°F (24°C)	3100	5150	4930	4740
180°F (82°C)	500	1000	760	1120
350°F (177°C)	420	440	560	—

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A

Typical Adhesive Performance Characteristics
(continued)

E. Overlap Shear Strength on Abraded Metals, Plastics, and Rubbers.

Overlap shear strengths were measured on 1" x 1/2" overlap specimens. These bonds were made individually using 1" by 4" pieces of substrate (Tested per ASTM D 1002).

The thickness of the substrates were: cold rolled, galvanized and stainless steel – 0.056-0.062", copper – 0.032", brass – 0.036", rubbers – 0.125", plastics – 0.125". All surfaces were prepared by solvent wiping/abrading/ solvent wiping.

The jaw separation rate used for testing was 0.1 in/min for metals, 2 in/min for plastics, and 20 in/min for rubbers.

Substrate	Overlap Shear (psi)@75°F (24°C)	
	3M™ Scotch-Weld™ Epoxy Adhesive	
	2216 B/A Gray Adhesive	2216 B/A Tan NS Adhesive
Aluminum/Aluminum	1850	2350
Cold Rolled Steel/Cold Rolled Steel	1700	3100
Stainless Steel/Stainless Steel	1900	
Galvanized Steel/Galvanized Steel	1800	
Copper/Copper	1050	
Brass/Brass	850	
Styrene Butadiene Rubber/Steel	200*	
Neoprene Rubber/Steel	220*	
ABS/ABS Plastic	990*	1140*
PVC/PVC, Rigid	940*	
Polycarbonate/Polycarbonate	1170*	1730*
Acrylic/Acrylic	1100*	1110*
Fiber Reinforced Polyester/ Reinforced Polyester	1660*	1650*
Polyphenylene Oxide/PPO	610	610
PC/ABS Alloy / PC/ABS Alloy	1290	1290

*The substrate failed during the test.

Storage

Store products at 60-80°F (16-27°C) for maximum storage life.

Shelf Life

When stored at the recommended temperatures in the original, unopened containers, the shelf life is 24 months from date of manufacture from 3M.

3M™ Scotch-Weld™ Epoxy Adhesive 2216 B/A

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Technical Information

The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer

Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability

Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

ISO 9001

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.



Industrial Adhesives and Tapes Division
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/structuraladhesives

3M and Scotch-Weld are
trademarks of 3M Company.
Printed in U.S.A.

©3M 2018 E78-6900-9583-7 (2/18)