

TITLE: Recommended Adhesives for Pelican Protector Cases

PRODUCT AFFECTED: Protector Case - all sizes

INTRODUCTION:

3M Products - Scotch Weld DP8005 or DP 8010 can be used when adhering custom parts such as Peli Quick™ Mounts in a Pelican Protector™ Case.

DETAILS:

Pelican Cases are molded from Polypropylene (PP), and for best results, should be adhered to similar material (see “best results” list below). While Peli Quick Mounts are molded of ABS, you should achieve satisfactory results if the mounts are allowed to cure for 24 hours before attaching elements such as an interface panel.



Use of physical fasteners such as a machine bolt and nut may provide greater shear strength, but will breach the case wall and may, depending on the application, require secondary waterproofing such as silicone or rubber washers.



Scotch Weld is a two part epoxy and a structural plastic adhesive that yields best results with the DP 8005 and DP 8010 formulas. Key advantages include:

- No special surface preparation or activators are needed
- Excellent water, humidity and chemical resistance
- Room temperature curing (solidifying)

Surfaces It Will Bond To:

For Best Results

- Polypropylene (PP)
- Polyethylene (PE) (HDPE) (LDPE)
- TPO (With 8010 only)

Secondary (Bonds Are Not As Strong)

- Fiber Reinforced Plastic (FRP)
- Primed Metals (With 8010 only)
- Polycarbonate
- Wood
- Aluminum (With 8005 only)
- Glass
- Thermoplastic Elastomers (TPE)
- Rigid PVC
- ABS
- Acrylic (PMMA)
- Polystyrene
- Concrete

Materials that are Not Recommended

- PTFE (Teflon)
- Silicone surfaces
- Mold Release Agents
- Polymide
- Nylons

Adhesion Rate Time Table

	DP 8005	DP 8010
Work Life (The time it takes before it gets too stiff to work with)	10 -12 Minutes	2 - 3 Hours
Handling Strength (Set time before it can be handled)	2.5 - 3 Minutes	1.5 – 2 Hours
Full Cure (Strongest bond)	8 - 24 Hours	8 - 24 Hours

3M Contact Information:

Web: www.3m.com

Customer Service:

1-800-362-3550 (US)

1-888-364-3577 (Foreign)

