

MATERIAL SAFETY 3M
DATA SHEET 3M Center
 St. Paul, Minnesota
 55144-1000
 1-800-364-3577 or (651) 737-6501 (24 hours)

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DIVISION: ENGINEERED ADHESIVES
TRADE NAME:

Scotch-Weld(TM) Acrylic Adhesive DP-820
ID NUMBER/U.P.C.:
62-3277-1430-9 - - - 62-3277-1435-8 00-21200-89347-6
62-3277-3530-4 00-21200-89349-0 62-3277-3830-8 00-21200-89348-3

ISSUED: May 17, 2001
SUPERSEDES: February 06, 2001
DOCUMENT: 06-7238-6

This product is a kit or a multipart product which consists of multiple,
independently packaged components. An MSDS for each of these components is
included. Please do not separate the component MSDSs from this cover page.
The document numbers of the MSDSs for components of this product are:
06-4927-7
06-7141-2

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

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be correct as of the date issued. 3M MAKES NO WARRANTIES, EXPRESSED OR
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DIVISION: ENGINEERED ADHESIVES
 TRADE NAME:
 Scotch-Weld(TM) Acrylic Adhesive DP-820, Part A or Scotch-Weld(TM)
 Acrylic Adhesive 820, Part A
 ID NUMBER/U.P.C.:
 62-3377-8530-7 00-21200-89351-3
 ISSUED: May 17, 2001
 SUPERSEDES: February 06, 2001
 DOCUMENT: 06-7141-2

1. INGREDIENT	C.A.S. NO.	PERCENT
METHYL METHACRYLATE.....	80-62-6	60.0 - 80.0
acrylic polymer blend - Vendor Trade Secret (V.T.S.) ++.....	TradeSecret	15.0 - 30.0
3,5-DIETHYL-1,2-DIHYDRO-1-PHENOL-2- PROPYLPYRIDINE.....	34562-31-7	5.0 - 10.0

++ Material is a trade secret of our supplier and the CAS number is
 unknown to 3M.

This product contains the following toxic chemical or chemicals subject to
 the reporting requirements of Section 313 of Title III of the Emergency
 Planning and Community Right-To-Know Act of 1986 and 40 CFR Part 372:
 METHYL METHACRYLATE

2. PHYSICAL DATA
BOILING POINT:..... 214.00 F
VAPOR PRESSURE:..... 29.0000 mmHg @ 68F
VAPOR DENSITY:..... 3.5 Air=1
EVAPORATION RATE:..... 3 BuOAc=1
SOLUBILITY IN WATER:..... moderate
SPECIFIC GRAVITY:..... .96 Water=1
PERCENT VOLATILE:..... 30.00 - 60.00 % by wt
pH:..... 4.5 - 5.5
VISCOSITY:..... 40000 - 60000 centipoise

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2. PHYSICAL DATA (continued)

MELTING POINT:..... N/D

APPEARANCE AND ODOR:

Paste, Off-white, pungent acrylic odor

3. FIRE AND EXPLOSION HAZARD DATA

FLASH POINT:..... 51.00 F
FLAMMABLE LIMITS - LEL:..... 2.00 % by vol
FLAMMABLE LIMITS - UEL:..... 12.50 % by vol
AUTOIGNITION TEMPERATURE:..... N/D

EXTINGUISHING MEDIA:

Water, Carbon dioxide, Dry chemical, Foam

SPECIAL FIRE FIGHTING PROCEDURES:

Wear full protective clothing, including helmet, self-contained, positive pressure or pressure demand breathing apparatus, bunker coat and pants, bands around arms, waist and legs, face mask, and protective covering for exposed areas of the head.

UNUSUAL FIRE AND EXPLOSION HAZARDS:

See Hazardous Decomposition section for products of combustion. Vapors may travel long distances along the ground or floor to an ignition source and flash back.

NFPA HAZARD CODES: HEALTH: 2 FIRE: 3 REACTIVITY: 2
UNUSUAL REACTION HAZARD: none

4. REACTIVITY DATA

STABILITY: Stable

INCOMPATIBILITY - MATERIALS/CONDITIONS TO AVOID:

Amines, Reducing Agents, Heat, Reactive Metals, Sparks and/or Flames. Heat is generated during cure. Do not cure a mass larger than 50 grams in a confined space to prevent a premature reaction (exotherm) with production of intense heat and smoke.

HAZARDOUS POLYMERIZATION: Hazardous polymerization may occur.

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

4. REACTIVITY DATA (continued)

HAZARDOUS DECOMPOSITION PRODUCTS:

Carbon Monoxide and Carbon Dioxide, Oxides of Nitrogen, Toxic Vapors,
Gases or Particulates.

5. ENVIRONMENTAL INFORMATION

SPILL RESPONSE:

Refer to other sections of this MSDS for information regarding
physical and health hazards, respiratory protection, ventilation, and
personal protective equipment. Ventilate area. Extinguish all
ignition sources. Collect spilled material. Place in an approved
metal container.

RECOMMENDED DISPOSAL:

Incinerate in an industrial or commercial facility in the presence of
a combustible material. Dispose of completely cured (or polymerized)
material in a sanitary landfill.

ENVIRONMENTAL DATA:

Not determined.

REGULATORY INFORMATION:

Volatile Organic Compounds: 0.00 gms/liter.
VOC Less H2O & Exempt Solvents: 0.0 gms/liter.

Since regulations vary, consult applicable regulations or authorities
before disposal. In the event of an uncontrolled release of this
material, the user should determine if the release qualifies as a
reportable quantity.

EPCRA HAZARD CLASS:

FIRE HAZARD: Yes PRESSURE: No REACTIVITY: No ACUTE: Yes CHRONIC: Yes

6. SUGGESTED FIRST AID

EYE CONTACT:

Immediately flush eyes with large amounts of water. Get immediate
medical attention.

SKIN CONTACT:

Wash affected area with soap and water.

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

6. SUGGESTED FIRST AID (continued)

INHALATION:

If signs/symptoms occur, remove person to fresh air. If signs/symptoms continue, call a physician.

IF SWALLOWED:

Do not induce vomiting. Drink two glasses of water. Call a physician.

7. PRECAUTIONARY INFORMATION

EYE PROTECTION:

Avoid eye contact. Wear vented goggles. Wear safety glasses with side shields.

SKIN PROTECTION:

Avoid skin contact. Wear appropriate gloves when handling this material. A pair of gloves made from the following material(s) are recommended: butyl rubber, polyvinyl alcohol, fluoroelastomer (Viton).

RECOMMENDED VENTILATION:

Curing ovens must be exhausted to outdoors or to a suitable emission control device. If exhaust ventilation is not adequate, use appropriate respiratory protection. Provide ventilation adequate to control vapor concentrations below recommended exposure limits and/or control spray or mist.

RESPIRATORY PROTECTION:

Avoid breathing of vapors created during the cure cycle. Avoid prolonged breathing of vapors. Avoid breathing of dust created by cutting, sanding or grinding. Select one of the following NIOSH approved respirators based on airborne concentration of contaminants and in accordance with OSHA regulations: half-mask dust respirator, half-mask organic vapor respirator, full-face organic vapor respirator.

PREVENTION OF ACCIDENTAL INGESTION:

Wash hands after handling and before eating. Do not ingest.

RECOMMENDED STORAGE:

Store in a cool place. Store away from heat. Keep container dry. Keep container in well-ventilated area. Keep out of the reach of children.

FIRE AND EXPLOSION AVOIDANCE:

Keep container tightly closed. Flammable liquid and vapor. Keep away from heat, sparks, open flame, and other sources of ignition. No smoking while handling this material. Do not heat under

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

7. PRECAUTIONARY INFORMATION (continued)

confinement.

EXPOSURE LIMITS

INGREDIENT	VALUE	UNIT	TYPE	AUTH	SKIN*
METHYL METHACRYLATE.....	100	PPM	TWA	OSHA	
METHYL METHACRYLATE.....	50	PPM	TWA	ACGIH	
		SENSITIZER			
METHYL METHACRYLATE.....	100	PPM	STEL	ACGIH	
		SENSITIZER			
acrylic polymer blend - Vendor Trade Secret (V.T.S.) ++.....	NONE	NONE	NONE	NONE	
3,5-DIETHYL-1,2-DIHYDRO-1-PHENOL-2- PROPYLPYRIDINE.....	NONE	NONE	NONE	NONE	

* SKIN NOTATION: Listed substances indicated with 'Y' under SKIN refer to the potential contribution to the overall exposure by the cutaneous route including mucous membrane and eye, either by airborne or, more particularly, by direct contact with the substance. Vehicles can alter skin absorption.

SOURCE OF EXPOSURE LIMIT DATA:

- ACGIH: American Conference of Governmental Industrial Hygienists
- OSHA: Occupational Safety and Health Administration
- NONE: None Established

8. HEALTH HAZARD DATA

EYE CONTACT:

Moderate Eye Irritation: signs/symptoms can include redness, swelling, pain, tearing, and hazy vision.

Vapors from heated material may cause eye irritation.

Dust created by cutting, grinding, sanding, or machining may cause eye irritation.

SKIN CONTACT:

Allergic Skin Reaction: signs/symptoms can include redness, swelling, blistering, and itching.

Moderate Skin Irritation: signs/symptoms can include redness, swelling, itching, and dryness.

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

8. HEALTH HAZARD DATA (continued)

INHALATION:

Illness may occur after a single overexposure by inhalation to relatively large quantities of this material.

Nervous System Effects: signs/symptoms can include emotional changes, lack of coordination, tremors and sensory loss.

Central Nervous System Depression: signs/symptoms can include headache, dizziness, drowsiness, incoordination, slowed reaction time, slurred speech, giddiness and unconsciousness.

Irritation (upper respiratory): signs/symptoms can include soreness of the nose and throat, coughing and sneezing.

Vapors of heated material may cause respiratory system irritation.

Dust from cutting, grinding, sanding or machining may cause irritation of the respiratory system.

IF SWALLOWED:

Irritation of Gastrointestinal Tissues: signs/symptoms can include pain, vomiting, abdominal tenderness, nausea, blood in vomitus, and blood in feces.

REPRODUCTIVE/DEVELOPMENTAL TOXINS:

METHYL METHACRYLATE (80-62-6) is not classifiable as to its potential reproductive effects in humans.

SECTION CHANGE DATES

HEADING SECTION CHANGED SINCE February 06, 2001 ISSUE

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DIVISION: ENGINEERED ADHESIVES
 TRADE NAME:
 Scotch-Weld(TM) Acrylic Adhesive DP-820, Part B or Scotch-Weld(TM)
 Acrylic Adhesive 820, Part B
 ID NUMBER/U.P.C.:
 62-3277-8530-9 00-21200-89350-6
 ISSUED: May 17, 2001
 SUPERSEDES: February 06, 2001
 DOCUMENT: 06-4927-7

1. INGREDIENT	C.A.S. NO.	PERCENT	
METHYL METHACRYLATE.....	80-62-6	40	- 60
CHLOROSULFONATED POLYETHYLENE.....	68037-39-8	10	- 30
ACRYLIC POLYMER -N.J. TRADE SECRET REGISTRY NO. 800941-5008P++.....	TradeSecret	5	- 10
ACRYLIC POLYMER-N.J. TRADE SECRET REGISTRY NO. 800941-5007P++.....	TradeSecret	3	- 7
MALEIC ACID.....	110-16-7	1	- 5
2,6-DI-TERT-BUTYL-P-CRESOL.....	128-37-0	0.5	- 1.5
CUMENE HYDROPEROXIDE.....	80-15-9	0.5	- 1.5

++ Material is a 3M supplier trade secret.

This product contains the following toxic chemical or chemicals subject to
 the reporting requirements of Section 313 of Title III of the Emergency
 Planning and Community Right-To-Know Act of 1986 and 40 CFR Part 372:

METHYL METHACRYLATE
 CUMENE HYDROPEROXIDE

2. PHYSICAL DATA	
BOILING POINT:.....	214.00 F
VAPOR PRESSURE:.....	29.0000 mmHg @ 68F
VAPOR DENSITY:.....	3.5 Air=1
EVAPORATION RATE:.....	3 BuOAc=1
SOLUBILITY IN WATER:.....	moderate

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

2. PHYSICAL DATA (continued)

SPECIFIC GRAVITY:..... 1.03 Water=1
PERCENT VOLATILE:..... 60.00 % by vol
pH:..... N/A
VISCOSITY:..... 40000 - 60000 centipoise
MELTING POINT:..... N/D

APPEARANCE AND ODOR:
Liquid, Off-white, pungent acrylic odor

3. FIRE AND EXPLOSION HAZARD DATA

FLASH POINT:..... 51.00 F
FLAMMABLE LIMITS - LEL:..... 2.00 % by vol
FLAMMABLE LIMITS - UEL:..... 12.50 % by vol
AUTOIGNITION TEMPERATURE:..... N/D

EXTINGUISHING MEDIA:
Water, Carbon dioxide, Dry chemical, Foam

SPECIAL FIRE FIGHTING PROCEDURES:
Wear full protective clothing, including helmet, self-contained,
positive pressure or pressure demand breathing apparatus, bunker coat
and pants, bands around arms, waist and legs, face mask, and
protective covering for exposed areas of the head.

UNUSUAL FIRE AND EXPLOSION HAZARDS:
See Hazardous Decomposition section for products of combustion.
Vapors may travel long distances along the ground or floor to an
ignition source and flash back.

NFPA HAZARD CODES: HEALTH: 2 FIRE: 3 REACTIVITY: 2
UNUSUAL REACTION HAZARD: none

4. REACTIVITY DATA

STABILITY: Stable

INCOMPATIBILITY - MATERIALS/CONDITIONS TO AVOID:
Amines, Reducing Agents, Heat, Reactive Metals, Sparks and/or Flames.
Heat is generated during cure. Do not cure a mass larger than 50
grams in a confined space to prevent a premature reaction (exotherm)
with production of intense heat and smoke.

HAZARDOUS POLYMERIZATION: Hazardous polymerization may occur.

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

4. REACTIVITY DATA (continued)

HAZARDOUS DECOMPOSITION PRODUCTS:

Carbon Monoxide and Carbon Dioxide, Oxides of Nitrogen, Toxic Vapors,
Gases or Particulates.

5. ENVIRONMENTAL INFORMATION

SPILL RESPONSE:

Refer to other sections of this MSDS for information regarding
physical and health hazards, respiratory protection, ventilation, and
personal protective equipment. Ventilate area. Extinguish all
ignition sources. Collect spilled material. Place in an approved
metal container.

RECOMMENDED DISPOSAL:

Incinerate in an industrial or commercial facility in the presence of
a combustible material. Dispose of completely cured (or polymerized)
material in a sanitary landfill.

ENVIRONMENTAL DATA:

Not determined.

REGULATORY INFORMATION:

Volatile Organic Compounds: 0.00 gms/liter EPA Method 24.
VOC Less H2O & Exempt Solvents: 0 gms/liter EPA Method 24.

Since regulations vary, consult applicable regulations or authorities
before disposal. In the event of an uncontrolled release of this
material, the user should determine if the release qualifies as a
reportable quantity. U.S. EPA Hazardous Waste Number = D001
(Ignitable)

U.S. EPA Hazardous Waste Code U162 (Methylmethacrylate)
CERCLA Reportable quantity 1000 Pounds (Pure methylmethacrylate)

EPCRA HAZARD CLASS:

FIRE HAZARD: Yes PRESSURE: No REACTIVITY: No ACUTE: Yes CHRONIC: Yes

6. SUGGESTED FIRST AID

EYE CONTACT:

Immediately flush eyes with large amounts of water. Get immediate
medical attention.

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

6. SUGGESTED FIRST AID (continued)

SKIN CONTACT:

Wash affected area with soap and water.

INHALATION:

If signs/symptoms occur, remove person to fresh air. If signs/symptoms continue, call a physician.

IF SWALLOWED:

Do not induce vomiting. Drink two glasses of water. Call a physician.

7. PRECAUTIONARY INFORMATION

EYE PROTECTION:

Avoid eye contact. Wear vented goggles. Wear safety glasses with side shields.

SKIN PROTECTION:

Avoid skin contact. Wear appropriate gloves when handling this material. A pair of gloves made from the following material(s) are recommended: butyl rubber, polyvinyl alcohol, fluoroelastomer (Viton).

RECOMMENDED VENTILATION:

Curing ovens must be exhausted to outdoors or to a suitable emission control device. If exhaust ventilation is not adequate, use appropriate respiratory protection. Provide ventilation adequate to control vapor concentrations below recommended exposure limits and/or control spray or mist.

RESPIRATORY PROTECTION:

Avoid breathing of vapors created during the cure cycle. Avoid prolonged breathing of vapors. Avoid breathing of dust created by cutting, sanding or grinding. Select one of the following NIOSH approved respirators based on airborne concentration of contaminants and in accordance with OSHA regulations: half-mask dust respirator, half-mask organic vapor respirator, full-face organic vapor respirator.

PREVENTION OF ACCIDENTAL INGESTION:

Wash hands after handling and before eating. Do not ingest.

RECOMMENDED STORAGE:

Store in a cool place. Store away from heat. Keep container dry. Keep container in well-ventilated area. Keep out of the reach of children.

Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

 7. PRECAUTIONARY INFORMATION (continued)

FIRE AND EXPLOSION AVOIDANCE:

Keep container tightly closed. Flammable liquid and vapor. Keep away from heat, sparks, open flame, and other sources of ignition. Do not heat under confinement.

EXPOSURE LIMITS

INGREDIENT	VALUE	UNIT	TYPE	AUTH	SKIN*
METHYL METHACRYLATE.....	100	PPM	TWA	OSHA	
METHYL METHACRYLATE.....	50	PPM	TWA	ACGIH	
	SENSITIZER				
METHYL METHACRYLATE.....	100	PPM	STEL	ACGIH	
	SENSITIZER				
CHLOROSULFONATED POLYETHYLENE.....	NONE	NONE	NONE	NONE	
ACRYLIC POLYMER -N.J. TRADE SECRET					
REGISTRY NO. 800941-5008P++.....	NONE	NONE	NONE	NONE	
ACRYLIC POLYMER-N.J. TRADE SECRET					
REGISTRY NO. 800941-5007P++.....	NONE	NONE	NONE	NONE	
MALEIC ACID.....	NONE	NONE	NONE	NONE	
2,6-DI-TERT-BUTYL-P-CRESOL.....	10	MG/M3	TWA	ACGIH	
2,6-DI-TERT-BUTYL-P-CRESOL.....	10	MG/M3	TWA	OSHA	
CUMENE HYDROPEROXIDE.....	1	PPM	TWA	AIHA	Y

* SKIN NOTATION: Listed substances indicated with 'Y' under SKIN refer to the potential contribution to the overall exposure by the cutaneous route including mucous membrane and eye, either by airborne or, more particularly, by direct contact with the substance. Vehicles can alter skin absorption.

SOURCE OF EXPOSURE LIMIT DATA:

- ACGIH: American Conference of Governmental Industrial Hygienists
- AIHA: American Industrial Hygiene Assoc. Workplace Environmental Exposure Level Guideline
- OSHA: Occupational Safety and Health Administration
- NONE: None Established

 8. HEALTH HAZARD DATA

EYE CONTACT:

Moderate Eye Irritation: signs/symptoms can include redness, swelling, pain, tearing, and hazy vision.

Vapors from heated material may cause eye irritation.

Dust created by cutting, grinding, sanding, or machining may cause

 Abbreviations: N/D - Not Determined N/A - Not Applicable CA - Approximately

8. HEALTH HAZARD DATA (continued)

eye irritation.

SKIN CONTACT:

Allergic Skin Reaction: signs/symptoms can include redness, swelling, blistering, and itching.

Moderate Skin Irritation: signs/symptoms can include redness, swelling, itching, and dryness.

INHALATION:

Central Nervous System Depression: signs/symptoms can include headache, dizziness, drowsiness, incoordination, slowed reaction time, slurred speech, giddiness and unconsciousness.

Irritation (upper respiratory): signs/symptoms can include soreness of the nose and throat, coughing and sneezing.

Vapors of heated material may cause respiratory system irritation.

Dust from cutting, grinding, sanding or machining may cause irritation of the respiratory system.

IF SWALLOWED:

Irritation of Gastrointestinal Tissues: signs/symptoms can include pain, vomiting, abdominal tenderness, nausea, blood in vomitus, and blood in feces.

REPRODUCTIVE/DEVELOPMENTAL TOXINS:

METHYL METHACRYLATE (80-62-6) is not classifiable as to its potential reproductive effects in humans.

SECTION CHANGE DATES

HEADING SECTION CHANGED SINCE February 06, 2001 ISSUE

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