

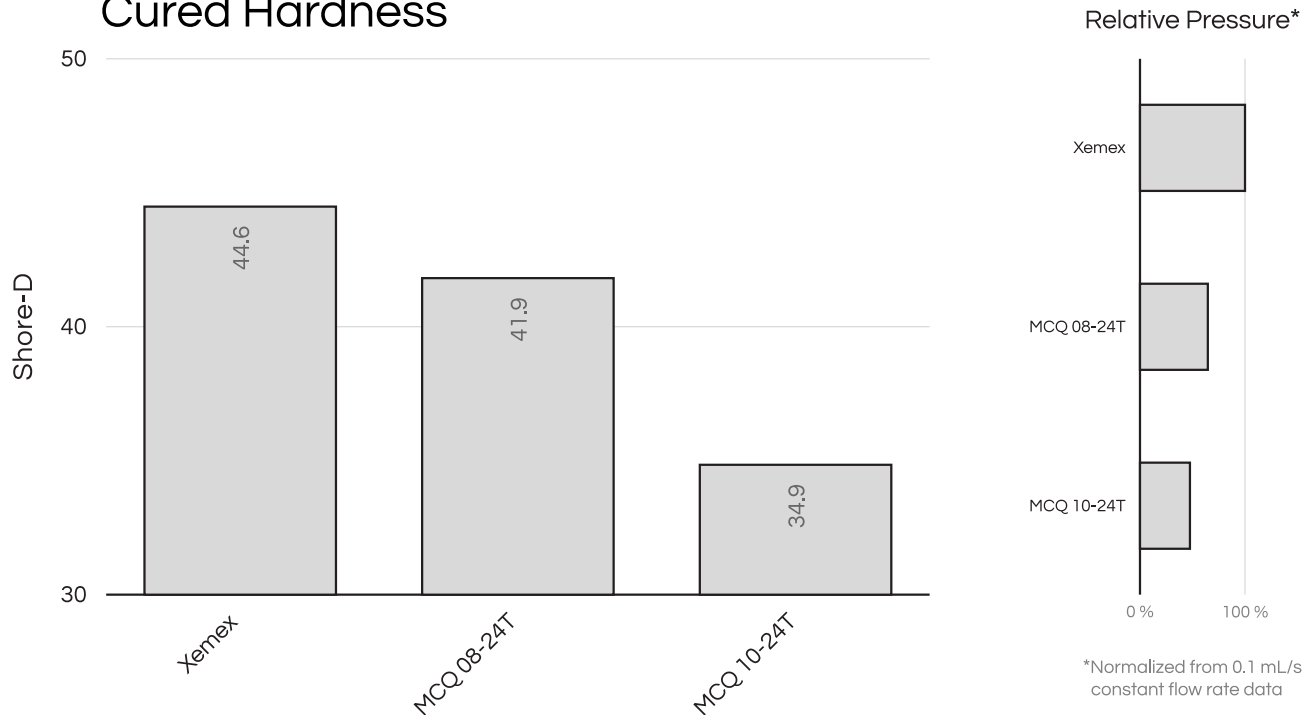


**Purpose** To compare the mixing performance of the Xemex® Static Mixer with commercially available mixers.

**Experimental** The 2-part formulation was dispensed using Re Mixer’s automated cartridge dispenser, having preset flow rate and purge routines. After curing at room temperature for 40 hours, hardness was determined through a single-blind collection using Rex Gauge’s RX-DD Series Durometer, and in accordance with ASTM D2240.

# 3M™ Scotch-Weld® DP190-Gray

## Cured Hardness



**Mixing Performance** The hardness data suggests that Xemex yielded the best mixing performance for 3M™ Scotch-Weld® DP190 Gray adhesive. With a retained volume of only 2.5 mL, Xemex outperformed mixers with 24 elements, which have retained volumes in the order of 5 to 10 mL. These results suggest that Xemex is a strong candidate for applications using DP190 Gray.

**Back Pressure** From this data, one should expect back pressures with Xemex to be higher than MCQ 08-24T and MCQ 10-24T at equivalent flow rates.

Formulation	Type	Mix Ratio**	Mixed** (cP)	Part A**	Part B**	Worklife** (min)	Keywords
3M™ Scotch-Weld® DP190 Gray	Epoxy	1:1	—	75,000 to 150,000	40,000 to 60,000	90	—

Laboratory Technician	Cured Time	Laboratory	Report Prepared by
Lukas Duddleston, MS	40 hours	23±2 °C   35±5 % RH	Lukas Duddleston, MS

\*\*As reported in 3M’s Technical Data Sheet

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