



August 2024

**NOTIFICATION: 3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A
Discontinuation Update and Replacement**

Dear Valued Customer,

Earlier this year we wrote to inform you that 3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A (black and blue variants) will be discontinued during 2024 and replaced by a new product; 3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR.

3M Scotch-Weld Void Filling Compound EC-3515 B/A FR is intended as a direct replacement for 3M Scotch-Weld Void Filling Compound EC-3524 B/A and offers the following properties and benefits:

- A two-part, low density, void filling compound based on epoxy chemistry
- Designed for void filling, edge sealing, and for abrasion resistant compound applications
- Low-density material (<0.5 g/cm³ mixed)
- Suitable for room temperature or elevated temperature curing
- Flame resistant per 14 CFR / CS 25.853 (a), Appendix F, Part I (a) (1) (ii), 12-second vertical burn¹
- Can be uniformly mixed by hand or by speed mixing equipment
- Base is either blue or black in color, accelerator is white. Easy to visually determine when the product is uniformly mixed
- Manufactured in two 3M locations: 3M Springfield, Missouri (USA) and 3M Tilloy (France)

3M Scotch-Weld Void Filling Compound EC-3515 B/A FR (Blue and Black variants) is commercially available for sale and can be purchased according to the 3M Standard Product Specification and a number of OEM Specifications (see [Qualification Information](#) for details).

Please find details of the phase out timing of 3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A (black and blue variants) for each manufacturing facility:

Manufacturing Facility: 3M Springfield, USA

Final production of EC-3524 B/A (black and blue variants) manufactured in 3M Springfield, USA, will take place in December 2024 and we request that **all forward dated orders be placed by November 30, 2024**. After this time, no additional orders will be taken.

¹ Tested in accordance with 14 CFR 25.853 (a), Appendix F, Part I (a) (1) (ii), 12-second vertical burn per FAA Policy Statement PS-ANM-25.853-01-R2, Reference 21, Option 1 (in a stand-alone mode, cured test plaque of nominal size: 0.25" x 3" x 12"). Installation approval is the responsibility of the design approval holder or the aircraft owner/operator.

Manufacturing Facility: 3M Tilloy, France

Final production of EC-3524 B/A (black and blue variants) manufactured in 3M Tilloy, France, has now concluded. Remaining stock of the black variant is estimated to **deplete between October and December 2024** subject to demand. Remaining stock of the blue variant has now depleted, and we urge customers to transition to EC-3515 B/A FR Blue.

Please note that 3M reserves the right to limit quantities based on historical purchases.

To assist with the transition from EC-3524 B/A to EC-3515 B/A FR, please refer to the Appendix Section of this letter which contains full details of [Material IDs \(SKUs\)](#), [Frequently Asked Questions](#), and a [Qualification Information](#) table.

Be assured that we are on hand to support you, therefore, please do not hesitate to contact us should you have any questions. For questions relating to specific open orders, please contact your local 3M Customer Service Representative.

We appreciate your continued support of 3M products.

Sincerely,

Chris Enstrom
Global Portfolio Manager
3M Automotive & Aerospace Division

Anna Geary
Global New Product Marketing Manager
3M Automotive & Aerospace Division

Appendix 1:

3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Transition Plan: Frequently Asked Questions

1. EC-3524 B/A and EC-3515 B/A FR Transition Timing & Qualifications

When will EC-3524 B/A be discontinued?	Based on current demand, the expected EC-3524 B/A discontinuation timing is as follows: <ul style="list-style-type: none">• Tilloy Source of Supply (both colours): Final production of EC-3524 B/A (black and blue variants has concluded. Remaining stock of the black variant is estimated to deplete between October and December 2024 subject to demand. Remaining stock of the blue variant has now depleted, and we urge customers to transition to EC-3515 B/A FR Blue.• Springfield Source of Supply (both colours): Final production will take place in December 2024 and we request that all forward dated orders be placed by November 30, 2024.
Will EC-3524 B/A AF and FST versions be discontinued?	No, 3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A FST and EC-3524 B/A Antimony Free (AF) manufactured in Tilloy, France are out of scope and will remain in the portfolio.
When will EC-3515 B/A FR be available to purchase?	EC-3515 B/A FR is commercially available in both colours from both manufacturing sites according to the 3M Standard Product Specification and several OEM specifications (See Qualification Information for more details).
When can I transition to the new EC-3515 B/A FR?	Please refer to the Qualification Information table for more details.

2. EC-3515 B/A FR Product Information

What is the difference between EC-3515 B/A FR and EC-3524 B/A?	3M Scotch-Weld Void Filling Compound EC-3515 B/A FR is intended to be a <u>direct replacement</u> for 3M Scotch-Weld Void Filling Compound EC-3524 B/A. EC-3515 B/A FR has been formulated to have <u>similar handling and mechanical properties</u> to EC-3524 B/A and is also available in blue and black. *Please note that when the blue variant is cured at an elevated temperature, it transitions to a blue/green colour.
Why does EC-3515 B/A FR have 'FR' in the description?	EC-3515 B/A FR is designed to meet 14 CFR / CS 25.853 (a), Appendix F, Part I (a) (1) (ii), 12-second vertical burn*. As a result, we have included FR in the description to designate this product is Flame Resistant. <i>*Tested in accordance with 14 CFR 25.853 (a), Appendix F, Part I (a) (1) (ii), 12-second vertical burn per FAA Policy Statement PS-ANM-25.853-01-R2, Reference 21, Option 1 (in a stand-alone mode, cured test plaque of nominal size: 0.25" x 3" x 12"). Installation approval is the responsibility of the design approval holder or the aircraft owner/operator.</i>

How does EC-3515 B/A FR perform versus EC-3524 B/A?	EC-3515 B/A FR has been extensively tested on industrial scale equipment at both Tilloy and Springfield manufacturing plants. All batches have produced test results which align with EC-3524 B/A historical test data and OEM specification requirements.
Where is EC-3515 B/A FR manufactured?	EC-3515 B/A FR is manufactured in 3M Tilloy, France <u>AND</u> 3M Springfield, MO, USA. Note: Some OEMs have only one plant qualified, please refer to the Qualification Information table for details.
Can 3M provide test data?	Yes, 3M test data can be provided upon request. Please contact your local 3M Account Representative for further support.
Is a Technical Datasheet (TDS) available?	Yes, the Technical Datasheet for EC-3515 B/A FR is publicly available here .
Is a Safety Datasheet (SDS) available and where can I find it?	The SDS can be obtained from the 3M Global SDS search website for up-to-date SDS information: https://www.3m.com/3M/en_WW/sds-search-select-location/ IMPORTANT NOTE: Safety Datasheets are periodically updated, always refer to the online directory for the most recent SDS.
What is the shelf life of the product?	Shelf life is 6 months from date of shipment in the original unopened packaging when stored at 59-77°F/15-25°C.
What is the recommended storage temperature for EC-3515 B/A FR?	EC-3515 B/A FR should be stored at room temperature.

3. Packaging

Is EC-3515 B/A FR available in the same packaging as EC-3524 B/A?	<p>The packaging of EC-3515 B/A FR has been harmonized between plants. EC-3515 B/A FR is available in the following sizes:</p> <ul style="list-style-type: none"> • 1.6kg Kit (equivalent to the current EC-3524 B/A 0.5 Gallon Blue kit from Springfield) • 15Kg Kit <p>*4kg and 1 kg Kits <u>are not</u> available.</p> <p>Both sizes are available in a ‘bag-in-bag’ packaging format; a metallic outer bag and an internal poly bag (see example on next page).</p>
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Packaging Example:



How many EC-3515 B/A FR kits are packed in a case / box (shipper unit)?

- There are 2 x 1.6kg Kit per case
- There is 1 x 15Kg Kit per case

This applies to both colours and plants.

4. Supply Information

<p>Are Material IDs (SKUs) available for EC-3515 B/A FR?</p>	<p>Yes, EC-3515 B/A FR material IDs (SKUs) are available. Please refer to the Material ID tables for details and note that there are individual Material IDs for specific regions or countries.</p>
<p>How should I interpret the EC-3515 B/A FR material ID description nomenclature?</p>	<p>There are individual EC-3515 B/A FR material ID's for specific regions or countries to improve description clarity. The nomenclature can be interpreted as follows:</p> <p>Example 1:</p> <p>EC-3515 BA FR Black (FR) 1.6kg 2/CS EMEA</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>↑</p> <p>Source of Supply FR = Tilloy, France</p> </div> <div style="text-align: center;"> <p>↑</p> <p>Sold-to Area or Country (Product is labelled for EMEA countries)</p> </div> </div> <p>Example 2:</p> <p>EC-3515 BA FR Blue (USA) 1.6kg 2/CS USA</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>↑</p> <p>Source of Supply USA = Springfield, USA</p> </div> <div style="text-align: center;"> <p>↑</p> <p>Sold-to Area or Country (Product is labelled for USA)</p> </div> </div>
<p>What is the MOQ for EC-3515 B/A FR?</p>	<p>1.6Kg Kit MOQ: 2 Kits 15Kg Kit MOQ: 1 Kit</p>
<p>What is the lead time for EC-3515 B/A FR?</p>	<p>EC-3515 B/A FR is currently manufactured on a Made-to-Order basis. Lead times vary based on manufacturing location and delivery location. Please consult 3M bCOM or your local 3M Customer Service Representative for details.</p>
<p>What is the price of EC-3515 B/A FR?</p>	<p>Pricing can be obtained from your local 3M Account or Customer Service Representative.</p>
<p>Can I have a sample of EC-3515 B/A FR?</p>	<p>Please contact your local 3M Account Representative for sample requests.</p>

APPENDIX 2

Material IDs

NEW: 3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black Material IDs

Product	Material Number	Short Material Description	Material Description	Kit Size	SOS	Colour	Labelled for:
EC-3515 B/A FR	7100301846	EC-3515 BA FR Black (FR) 1.6kg 2/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS FR) 1.6 kg kit, 2 per case, EMEA	1.6 Kg	Tilloy, France	Black	Europe
EC-3515 B/A FR	7100302077	EC-3515 BA FR Black (FR) 1.6kg 2/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS FR) 1.6 kg kit, 2 per case, USA	1.6 Kg	Tilloy, France	Black	USA or Global (excluding Europe)
EC-3515 B/A FR	7100283402	EC-3515 BA FR Black (USA) 1.6kg 2/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS US) 1.6 kg kit, 2 per case, EMEA	1.6 Kg	Springfield, USA	Black	Europe
EC-3515 B/A FR	7100283399	EC-3515 BA FR Black (USA) 1.6kg 2/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS US) 1.6 kg kit, 2 per case, USA	1.6 Kg	Springfield, USA	Black	USA or Global (excluding Europe)
EC-3515 B/A FR	7100301847	EC-3515 BA FR Black (FR) 15kg 1/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS FR) 15kg kit, 1 per case, EMEA	15 Kg	Tilloy, France	Black	Europe
EC-3515 B/A FR	7100301848	EC-3515 BA FR Black (FR) 15kg 1/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS FR) 15kg kit, 1 per case, USA	15 Kg	Tilloy, France	Black	USA or Global (excluding Europe)
EC-3515 B/A FR	7100283395	EC-3515 BA FR Black (USA) 15kg 1/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS US) 15kg kit, 1 per case, EMEA	15 Kg	Springfield, USA	Black	Europe
EC-3515 B/A FR	7100283398	EC-3515 BA FR Black (USA) 15kg 1/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Black (SoS US) 15kg kit, 1 per case, USA	15 Kg	Springfield, USA	Black	USA or Global (excluding Europe)

APPENDIX 2

Material IDs

NEW: 3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue Material IDs

Product	Material Number	Short Material Description	Material Description	Kit Size	SOS	Colour	Labelled for:
EC-3515 B/A FR	7100297361	EC-3515 BA FR Blue (FR) 1.6kg 2/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS FR) 1.6 kg kit, 2 per case, EMEA	1.6 Kg	Tilloy, France	Blue	Europe
EC-3515 B/A FR	7100300652	EC-3515 BA FR Blue (FR) 1.6kg 2/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS FR) 1.6 kg kit, 2 per case, USA	1.6 Kg	Tilloy, France	Blue	USA or Global (excluding Europe)
EC-3515 B/A FR	7100283308	EC-3515 BA FR Blue (USA) 1.6kg 2/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS US) 1.6 kg kit, 2 per case, EMEA	1.6 Kg	Springfield, USA	Blue	Europe
EC-3515 B/A FR	7100283423	EC-3515 BA FR Blue (USA) 1.6kg 2/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS US) 1.6 kg kit, 2 per case, USA	1.6 Kg	Springfield, USA	Blue	USA or Global (excluding Europe)
EC-3515 B/A FR	7100283414	EC-3515 BA FR Blue (USA) 1.6kg 2/CS JP	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS US) 1.6 kg kit, 2 per case, JAPAN	1.6 Kg	Springfield, USA	Blue	Japan
EC-3515 B/A FR	7100297490	EC-3515 BA FR Blue (FR) 15kg 1/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS FR) 15kg kit, 1 per case, EMEA	15 Kg	Tilloy, France	Blue	Europe
EC-3515 B/A FR	7100300651	EC-3515 BA FR Blue (FR) 15kg 1/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS FR) 15kg kit, 1 per case, USA	15 Kg	Tilloy, France	Blue	USA or Global (excluding Europe)
EC-3515 B/A FR	7100283417	EC-3515 BA FR Blue (USA) 15kg 1/CS EMEA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS US) 15kg kit, 1 per case, EMEA	15 Kg	Springfield, USA	Blue	Europe
EC-3515 B/A FR	7100283415	EC-3515 BA FR Blue (USA) 15kg 1/CS USA	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS US) 15kg kit, 1 per case, USA	15 Kg	Springfield, USA	Blue	USA or Global (excluding Europe)
EC-3515 B/A FR	7100283400	EC-3515 BA FR Blue (USA) 15kg 1/CS JP	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR Blue (SoS US) 15kg kit, 1 per case, JAPAN	15 Kg	Springfield, USA	Blue	Japan

APPENDIX 2

Material IDs

EC-3524 B/A Black Material IDs to be discontinued:

Product	Material Number	Short Material Description	Material Description	Kit Size	SOS	Colour
EC-3524 B/A	7100150843	EC-3524 B/A BLACK 1KG 2/CS	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Black 1Kg Kit	1 Kg	Springfield, USA	Black
EC-3524 B/A	7100172704	SW 3524 B/A BLACK 4KG KIT FRDEUK	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Black 4Kg Kit	4 Kg	Tilloy, France	Black
EC-3524 B/A	7100206440	SW EC-3524 B/A BLACK 4KG KIT US ONLY	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Black 4Kg Kit, USA only	4 Kg	Tilloy, France	Black
EC-3524 B/A	7100220624	SW VOID FILL EC-3524 B/A BLACK 15KG KIT	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Black 15Kg Kit	15 Kg	Springfield, USA	Black
EC-3524 B/A	7100172361	SW 3524 B/A BLACK 15KG KIT	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Black 15Kg Kit	15 Kg	Tilloy, France	Black
EC-3524 B/A	7100176236	EC 3524 B/A BLACK KIT 15KG 1/CS GBFRDENL	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Black 15Kg Kit	15 Kg	Tilloy, France	Black

APPENDIX 2

Material IDs

EC-3524 B/A Blue Material IDs to be discontinued:

Product	Material Number	Short Material Description	Material Description	Kit Size	SOS	Colour
EC-3524 B/A	7000000862	EC-3524 B/A BLUE 0.5 GALLON KIT 2/CS	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 0.5 Gallon Kit	0.5 Gallon	Springfield, USA	Blue
EC-3524 B/A	7010719948	EC-3524 1GAL KIT ASKKU3JP	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 1 Gallon Kit	1 Gallon	Springfield, USA	Blue
EC-3524 B/A	7012764167	EC3524 S/WELD TM B/A 1/2 GALKIT BLUE 2KI	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 0.5 Gallon Kit	0.5 Gallon	Springfield, USA	Blue
EC-3524 B/A	XT000546348	EC-3524 B/A 1/2 GALLON KIT{DG & A	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 0.5 Gallon Kit	0.5 Gallon	Springfield, USA	Blue
EC-3524 B/A	7010304413	EC-3524 B/A BLUE 0.5 GALLON KIT 2/CS DEF	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 0.5 Gallon Kit	0.5 Gallon	Springfield, USA	Blue
EC-3524 B/A	7100172953	SW 3524 B/A BLUE 4KG KIT FRDEUK	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 4Kg Kit	4 Kg	Tilloy, France	Blue
EC-3524 B/A	7100216160	VOID FILL EC-3524 B/A BLUE 10 GAL KIT	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 10 Gallon Kit	10 Gallon	Springfield, USA	Blue
EC-3524 B/A	7100172828	SW 3524 B/A BLUE 15 KG KIT GB/F/IT/PL	3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A Blue 15Kg Kit	15 Kg	Tilloy, France	Blue

APPENDIX 3
Qualification Information

					3M Springfield Manufacturing Location	3M Tilloy Manufacturing Location			
		3M™ Scotch-Weld™ Void Filling Compound EC-3524 B/A	3M™ Scotch-Weld™ Void Filling Compound EC-3515 B/A FR						
OEM	Void Filling Compound Colour	Current Specification Reference	Qualified in Springfield, USA (Yes / No)	Qualified in Tilloy, France (Yes / No)	New Specification Reference	Springfield Qualification Status	Springfield Estimated Qualification Completion Timing	Tilloy Qualification Status	Tilloy Estimated Qualification Completion Timing
Boeing	Blue	BMS 5-28, TYPE 9	Yes	No	BMS 5-28, TYPE 9	IN PROGRESS	Q3 2024	Not Applicable	N/A
Pratt & Whitney	Blue	PWA 36756, REV. E	Yes	No	PWA 36756-2	New Specification Active	Complete	In Progress	Q4 2024
	Blue	CPW 561, REV. B	Yes	No	CPW 561, REV. C, CPW 561-3	New Specification Active	Complete	In Progress	Q4 2024
Rolls Royce	Black	MSRR1001, 8, MAT 20	No	Yes	RRMS 45002-5	New Specification Active	Complete	New Specification Active	Complete
	Blue	MSRR1001, 8, MAT 20	Yes	Yes	RRMS 45002-4	New Specification Active	Complete	New Specification Active	Complete
Safran	Black	DMR76-059, Issue C	Yes	Yes	IN-8100-002	New Specification Active	Complete	New Specification Active	Complete
	Blue	DMR 76-008	No	Yes	IN-8100-001	New Specification Active	Complete	New Specification Active	Complete
	Blue	HS DFO-037	No	Yes	IN-8100-001	New Specification Active	Complete	New Specification Active	Complete
	Blue	BLGE 561901	No	Yes	IN-8100-001	New Specification Active	Complete	New Specification Active	Complete

New Specification Active Specification is active and can be ordered

IMPORTANT NOTE: Please note that additional OEM qualifications (not listed above) will be announced once available. Alternatively, please refer to the [3M Specification Support Portal](#) for more information.