

3M Science.
Applied to Life.™



3M™ Industrial and Sustainable Adhesives

Performance. Productivity. Sustainability.

Streamline your assembly operation with convenient, efficient 3M™ Industrial and Sustainable Adhesives

Solvent and Water Based Adhesives

Unite Performance, Productivity and Sustainability

3M™ Solvent and Water Based Adhesives start with the customer. Their process, their requirements and their wishes. Then the 3M team of industry experts, in conjunction with our comprehensive technology portfolio, offers customers versatility, efficiency and confidence to answer their “what if?”



Performance

Find the RIGHT product for your assembly with the RIGHT questions:

- What substrates are being bonded?
- What are the issues with your current product?
- Are there any environmental Health and Safety requirements?
- Are there specific product attributes needed?
- Are there specific manufacturing requirements?
- What is the size of the substrate being sprayed?

Sustainability

Low Emissions. High Standards.

Going “green” does not mean that you have to give up on performance. For 40 years our engineers have been developing water-based and low VOC adhesives that have been used in the most demanding applications.

**So, are you ready to go “green?”
We’re ready to take you there.**



Productivity

Our goal is to make your business as efficient and effective as possible. How the adhesive gets to your assembly is equally as important as the adhesive itself. We work with you to integrate the best delivery system for your process.



Aerosols

- Convenient for smaller jobs or multiple stations
- Easy to use and no equipment



Cylinders

- Self-contained and pressurized
- Portable, low maintenance
- Minimal equipment investment
- Optimized spray pattern cuts waste and maximizes coverage



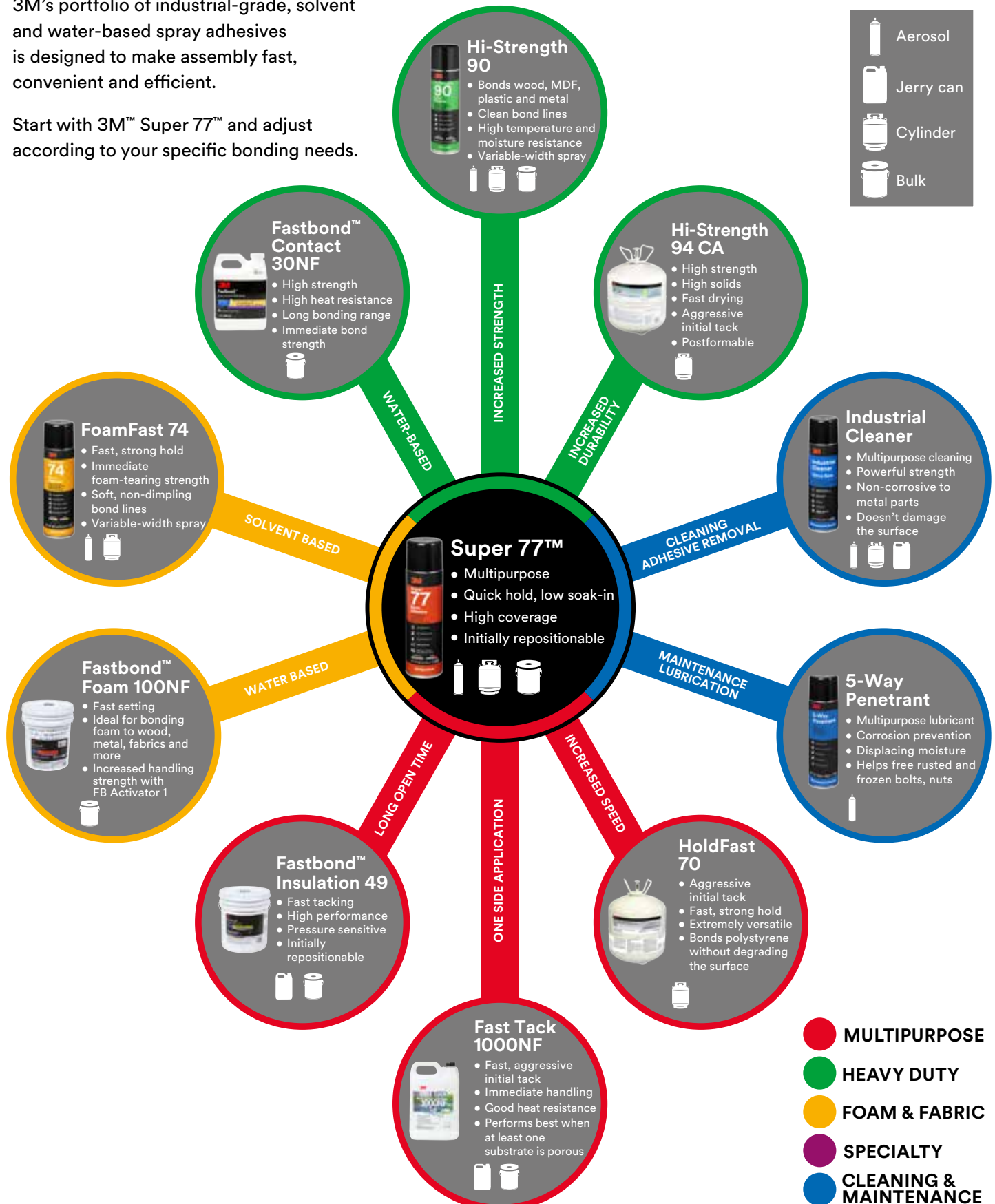
Bulk

- Cost effective
- Heavy use, many pieces, very large surface area
- Integrate into existing equipment

Industrial grade. Trusted by professionals.

3M's portfolio of industrial-grade, solvent and water-based spray adhesives is designed to make assembly fast, convenient and efficient.

Start with 3M™ Super 77™ and adjust according to your specific bonding needs.



Multipurpose Adhesives — Solvent and Water Based

Insulation, Light Fabrics, Cardboard and Other Light Duty Bonding

Those working with HVAC, General Industrial, Signage, Exhibit/P.O.P. and packaging can effectively bond insulation, light fabrics, cardboard and paper with these versatile adhesives.

- Insulation attachment (polystyrene*, fiber glass, foam, etc.)
- General assembly
- Temporary holding (third hand)
- P.O.P. displays
- Carton sealing, palletizing and label attachment

*Not all products are compatible with polystyrene



3M multipurpose adhesives are commonly used for installation of shoddy material, venting insulation and other foams and fabrics. Our product line offers the most versatility for adhesive delivery. 3M™ Super 77™ Multipurpose Spray Adhesive, for example, can be sprayed from bulk containers, cylinders or aerosol cans.

MULTI-PURPOSE — Solvent Based Adhesives			
Key Product	Product	Requirement	Size Availability
	77	LOW SOAK IN, MIST SPRAY	  
	70	Fast Tacking	

MULTI-PURPOSE — Water Based Adhesives			
Key Product	Product	Requirement	Size Availability
	1000NF	ONE SURFACE BONDING	
	49	Long open time, long tack time	



When thinking insulation, don't stop at heating and ventilation. In this application, our adhesives can be used for installation of foam for acoustical soundproofing.



The variety of applications for these multi-purpose adhesives is nearly endless. From adhering pool table felt, to building architectural models, and even bonding protective materials like dense foams into electronics, musical instrument or sensitive equipment cases. 3M has a spray adhesive solution to fit customers' needs.

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Woodworking and Large Surface Lamination — Solvent and Water Based

Wood, Metal and Rubber Flooring

Woodworking, transportation, construction, and general industrial markets can effectively bond metals, wood, rubber, carpet and flooring (vinyl tiles) with this line of adhesives. Some applications include transportation flooring and carpet, store fixtures and furniture.

- High pressure laminate (HPL)
 - Countertops
 - Furniture
 - Display fixtures
- Edge banding
- Specialty vehicle flooring
- Wood furniture
- Trade show displays



Marine and specialty vehicle applications, like installing carpet, rubber or synthetic flooring, are perfect for 3M sprayable adhesives. Our quick tack, low VOC and cylinder delivery are common benefits in this market.

HEAVY DUTY — Solvent Based Adhesives		
Product	Requirement	Size Availability
90	HIGH STRENGTH	  
94 CA	Fast Tacking, postformable	

HEAVY-DUTY — Water Based Adhesives		
Product	Requirement	Size Availability
30NF	HIGH STRENGTH	
2000NF	Faster initial strength	
1000NF	One surface bonding, fast assembly, plasticizer resistance	



Consider trade show exhibits and store fixtures that are often updated several times a year. 3M's adhesive line offers very low cost per square foot bonded for applications where our customers value total applied cost.



3M™ Hi-Strength 90 Spray Adhesive has a long reputation of holding strong in critical applications like this edge banding strip. Also, 3M has multiple adhesives that are postformable. Postforming is where the laminate is heated and bent as much as 360° around a radius.

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Foam and Fabric Adhesives — Solvent and Water Based

Upholstery and Furniture

Users in the furniture manufacturing, upholstery, or transportation industry can rely on these adhesives to permanently bond open cell foam, closed cell foam and fabrics in a variety applications.

- Upholstered furniture and seating
- Headliners
- Office partitions
- General foam bonding



Foam and fabric applications can be very challenging. From soft bond lines to tight radiuses, our lineup can meet the demand. The 3M portfolio of water and solvent based adhesives truly give the customer “flexibility.”

FOAM & FABRIC — Solvent Based Adhesives		
Product	Requirement	Size Availability
74	SOFT BOND LINES	 

FOAM & FABRIC — Water Based Adhesives		
Product	Requirement	Size Availability
100NF	HIGH COVERAGE	
100NF + Activator	Faster initial strength	
1000NF	One surface bonding, higher heat resistance	



Aerosol adhesives provide either web or mist spray patterns with higher solid content than our competitors. This combination allows 3M adhesives to sit on the surface versus soaking in. More adhesive on the surface results in less adhesive usage and a better bond for the customer.



These solvent and water based adhesives are often used as a “third hand” to hold lightweight materials in place until they can be sewn or held in place by other assembly methods.

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High Performance Specialty Adhesives — Solvent and Water Based

Rubber, Plastic, Metal and More

Industrial, Automotive, and Military professionals can rely on these adhesives to effectively bond rubber, plastics and specialty composites.

- Sealing and gasketing
- Chemical resistance
- Unique environments
 - Harsh environments
 - MIL specs
 - Chemical resistance



In washing machine repair, 3M™ Neoprene High Performance Rubber and Gasket Adhesive 1300 bonds with high immediate strength and seals the doughnut ring seal in the outer tub.

SPECIALTY — Rubber and Gasket Adhesives		
Product	Requirement	Size Availability
1300L	NEOPRENE OR SBR BONDING	
847	Vinyl bonding, plasticizer resistant	
4799	EPDM bonding	
80	High temperature resistance	

SPECIALTY — Plastic Adhesives		
Product	Requirement	Size Availability
1099	RESISTS WATER, OIL AND PLASTICIZER	
4693	Polyolefin bonding	
2262	Clear drying	

SPECIALTY — Metal Adhesives		
Product	Requirement	Size Availability
1357	RESISTS HEAT AND CONTINUOUS LOAD STRESS	

SPECIALTY — Composite Adhesives		
Product	Requirement	Size Availability
71	INFUSION, DRY LAY UP	

SPECIALTY — Polystyrene Adhesives		
Product	Requirement	Size Availability
78 HT	HIGH TEMPERATURE RESISTANCE, NO SURFACE DEGRADATION	

	Aerosol		Cylinder		Bulk
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With excellent resistance to fuel and oil, 3M™ Nitrile High Performance Rubber and Gasket Adhesive 847 bonds and seals chemical drum gaskets in place.



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3M™ Cleaning and Maintenance

Convenience and a Fistful of Work Power for Maintenance and Production

In thousands of factories and plants, these cleaning chemicals are proven daily to save time and effort in maintenance and production. Lubricating, cleaning, inhibiting rust, and other tough jobs become finger-touch easy.

Compact container fits in a tool box to go readily to any job site and can help you reduce storage space and cost. With targeted application you get more usable product for your money.

3M cleaning chemicals contain no methylene chloride, chlorofluorocarbons (CFCs) or 1,1,1-trichloroethane (methyl chloroform).



3M™ 5-Way Penetrant lubricates cutting tools and tables. Fast, easy application helps prevent buildup of adhesive, wax, inks and paints. Won't stain or become gummy.



For fast, easy cleanup of gears, 3M™ Industrial Cleaner and Adhesive Remover helps soften and loosen grease, oil and grime. After using this heavy-duty degreaser/cleaner, just wipe away with a shop towel.



3M™ Industrial Cleaner and Adhesive Remover removes adhesive without damaging surface underneath.

MAINTENANCE AND CLEANING						
Product	Key Characteristics	Available Format	Color	Application Method	Spray Pattern	VOC Content
Industrial Cleaner and Adhesive Remover	Citrus based. Non-corrosive. Cleans oil, grease, tar and grime. Removes adhesive without damaging the surface underneath.	Aerosol Jerry Can	Transparent	Spray	Mist	91%
5-Way Penetrant	Helps free rusted and frozen bolts, nuts and more. Displaces moisture and "dries out" electronics. Light-duty lubricant works well with delicate precision instruments. Inhibits corrosion during storage.	Aerosol	Amber	Spray	Mist	30%

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3M™ Industrial and Sustainable Adhesives Product Selector

Surface / Surface	Paper & Cardboard	Fabric, Felt & Cork	Flexible Foam: Urethane, Latex	Rigid Foam: Non Polystyrene	Wood, MDF, Particle Board	High Pressure Laminate, Melamine	Metal, Steel & Aluminum	Plastic - ABS, PVC, Phenolic, Acrylic	FRP: Fiber Reinforced Plastic	Painted Surfaces	Glass Fiber	Rubber - Nitrile, Neoprene, SBR	Vinyl - plasticized	Insulation - polyester, polyurethane	Leather	Rigid Foam: PS
Paper & Cardboard	77, 49	77, 70, 49	77 74, 100NF	74, 100NF	90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Fabric, Felt & Cork		77, 70, 49	77 74, 100NF	74, 100NF	90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Flexible Foam: Urethane, Latex			77 74, 100NF	74, 100NF	90, 94CA, 30NF	74 90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Rigid Foam: Non Polystyrene				74, 100NF	90, 94CA, 30NF	74 90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Wood, MDF, Particle Board				74, 100NF	90, 94CA, 30NF	74 90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
High Pressure Laminate, Melamine					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Metal, Steel & Aluminum					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Plastic - ABS, PVC, Phenolic, Acrylic					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
FRP: Fiber Reinforced Plastic					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Painted Surfaces					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Glass Fiber					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	71
Rubber - Nitrile, Neoprene, SBR					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	N/A
Vinyl - plasticized					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	N/A
Insulation - polyester, polyurethane					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT
Leather					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	N/A
Rigid Foam: Polystyrene					90, 94CA, 30NF	90, 94CA, 30NF	90 1357 30NF	90 847 30NF	90 1357 30NF	90, 94CA, 30NF	71	80, 847	80, 847	78HT	80	78HT

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Product	Key Characteristic	Heat Resistance	Shear STR (kPa)	Bonding Range - One Surface
MULTI-PURPOSE				
49	Fast tacking, high performance, pressure sensitive adhesive for lightweight materials. Low VOC.	121°C	345	5 min - 8 hr
70	Extremely versatile and very fast tacking. Unique wide web spray pattern with heavy body and low soak-in. Bonds polystyrene without degrading surface.	88°C	≤ 1.379	1 - 60 min
77	Low soak-in for long lasting bond. High coverage and aggressive tack. Bonds quickly in 15 seconds.	66°C	≤ 2.068	15 sec - 15 min
1000NF	One-part immediate handling strength. Low overspray and high coverage. Bonds a wide variety of substrates with high temperature resistance.	149°C	≤ 2.758	1 - 5 min
HEAVY DUTY				
10	Brushable and rollable with higher coverage.	149°C	N/A	Not recommended
30NF	Non-flammable water-based contact adhesive. Extremely high strength, high temperature resistant.	149°C	≤ 2.758	Not recommended
2000NF	Water dispersed, activated adhesive. Immediate bonding and handling strength without forced drying.	149°C	≤ 2.758	Not recommended
90	High strength. High temperature resistance.	121°C	≤ 4.136	Not recommended
94CA	High solids for increased coverage. Unique non-telegraphing spray pattern with postformable strength. Low VOC.	99°C	≤ 3.447	Not recommended
FOAM & FABRIC				
74	Extremely fast tack. Soft non-dimpling glue line. Immediate foam tearing strength.	77°C	≤ 1.379	30 sec - 15 min
100NF	One-part, fast setting foam and fabric adhesive. Can be activated for immediate bonding.	110°C	≤ 2.068	30 sec - 20 min
SPECIALTY				
71	A high tack, resin compatible adhesive for resin infused composite applications	96°C	N/A	10 sec - 15 min
75	Adheres in seconds. Extra long tack range. Repositionable.	43°C	≤ 345	15 sec - 1 min
76	Fast tacking. One surface bonds. Variable width lace spray pattern.	110°C	≤ 1.379	1 - 10 min
78HT	Bonds polystyrene with no surface degradation. High temperature resistance. Can be used for roofing membrane attachment.	121°C	≤ 1.379	1 - 5 min
80	High strength. High temperature resistance. Fast setting.	149°C	≤ 4.136	Not recommended
847	Quick drying and flexible with fuel and oil resistance. Able to reactivate with heat and solvent. Curable with heat.	120°C	N/A	Not recommended
847H	High viscosity. Able to reactivate with heat and solvent. Curable with heat.	120°C	N/A	Not recommended
1022	Good resistance to most migratory plasticisers. Excellent resistance to fuel and aliphatic hydrocarbons.	120°C	N/A	Not recommended
1099	Fast drying and heat curable. Resists weathering, water, oil, plasticizer migration and aliphatic fuels.	120°C	N/A	Not recommended
1300L	Lower viscosity for spraying. Fast-drying and heat resistant for rubber and metal.	149°C	N/A	Not recommended
1357	Rapid build up to a very high strength bond for metal. Resists heat and continuous load stress.	149°C	≤ 4.136	Not recommended
2141	Adheres to neoprene, SBR, butyl, leather, vinyl and various rubbers. Excellent fuel and oil resistance.	82°C	N/A	1 - 2 min
2262	Clear and non-staining. Resists plasticizer migration for bonding many flexible vinyls. Fast tack.	80°C	N/A	2 - 5 min
4235	Water-dispersed, pressure sensitive adhesive with moderate tack to allow for immediate repositioning. Good for LSE plastics.	90°C	N/A	Not recommended
4475	Clear plastic adhesive. Fast drying. Strong environmental resistance.	80°C	N/A	Not recommended
4693	Excellent plastic adhesive. Long tack range. Water and heat resistant.	80°C	N/A	Not recommended
4799	Water and heat resistant. Dries rapidly. EPDM bonder.	82°C	N/A	Not recommended
Activator 1	Fastbond™ Spray Activator.	N/A	N/A	N/A

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Solids %	Bonding Range - Two Surfaces	Initial Tack	Base Polymer	Solvent vs Water-based	Spray Pattern	Application Method	Color
55%	5 min - 8 hr	High	Acrylic	Water	Pebble	Brush / Roll / Spray	Clear, Red
21%	1 - 60 min	High	Synthetic Elastomer	Solvent	Lace	Spray	Clear
25%	15 sec - 15 min	High	Synthetic Elastomer	Solvent	Mist	Spray	Clear
49%	1 - 10 min	Medium	Acrylic	Water	Mist	Spray	Clear, Purple
23%	10 - 60 min	Low	Polychloroprene	Solvent	Lace	Brush / Roll	Light Yellow
49%	15 min - 4 hr	Low	Polychloroprene	Water	Pebble	Brush / Roll / Spray	Clear, Blue
49%	30 sec - 2 hr	Low	Polychloroprene	Water	Mist	Co-Spray	Clear, Blue
13%	1 - 10 min	Low	Synthetic Elastomer	Solvent	Lace	Spray	Clear
28%	1 - 15 min	Low	Synthetic Elastomer	Solvent	Pebble	Spray	Clear
22%	30 sec - 15 min	Medium	Synthetic Elastomer	Solvent	Lace	Spray	Clear, Orange
47%	30 sec - 20 min	Medium	Polychloroprene	Water	Mist	Spray	Clear, Lavendar
19%	1 - 30 min	Medium	Acrylic	Solvent	Mist	Spray	Clear, Green
9%	15 sec - 1 hr	Low	Synthetic Elastomer	Solvent	Mist	Spray	Clear
13%	1 - 60 min	High	Synthetic Elastomer	Solvent	Lace	Spray	Clear
15%	1 - 60 min	Medium	Synthetic Elastomer	Solvent	Lace	Spray	Blue
13%	3 - 30 min	Low	Synthetic Elastomer	Solvent	Lace	Spray	Yellow
36%	Up to 15 min	Medium	Nitrile	Solvent	Brush	Brush / Flow	Brown
51%	Up to 10 min	Medium	Nitrile	Solvent	Brush	Brush / Flow	Brown
24%	5 min	Medium	Nitrile	Solvent	Brush / Spray	Spray	Dark Brown
34%	Up to 40 min	High	Nitrile	Solvent	Brush / Spray	Brush / Spray	Light Tan
30%	Up to 8 min	High	Polychloroprene	Solvent	Brush / Spray	Brush / Spray	Yellow
25%	10 - 30 min	High	Polychloroprene	Solvent	Lace	Brush / Spray	Light Yellow
28%	5 - 15 min	High	Polychloroprene	Solvent	Brush / flow	Brush / Spray	Light Yellow
27%	2 - 20 min	High	Synthetic Elastomer	Solvent	Brush / Flow	Brush / Flow	Clear
55%	40 min - 30+ days	Medium	Acrylate	Water	Mist	Spray	Clear
43%	10 min	Medium	Synthetic Elastomer	Solvent	Brush / Flow	Brush / Flow	Clear
26%	10 - 60 min	Medium	Synthetic Elastomer	Solvent	Lace	Brush / Spray	Clear
32%	10 - 10 min	Medium	Synthetic Rubber	Solvent	Brush / Trowel	Brush / Trowel	Black
N/A	N/A	N/A	N/A	Water	Mist	Spray	Clear

3M™ Cylinder Spray Adhesives

Efficient, Portable and Easy to Use

3M™ Cylinder Spray Adhesives have benefits over more traditional spray methods. Whether your priorities are improving speed of application, reducing complexity or eliminating equipment maintenance and other costs, 3M Cylinder Spray Adhesives get you there.

Advantages and benefits:

- Very efficient over large surface areas, high speed of application and reduced overspray
- Convenient, portable and easy to use delivery system
- Various spray patterns
- Maintenance free and very low equipment costs
- Easy to learn, use and train new employees to spray



Spray patterns from 3 - 45 cm are achievable using 3M™ Cylinder Spray Adhesives and various spray tips.

Product Selection

The lead products for 3M™ Cylinder Adhesives are:

- 3M™ Postforming 94 CA Cylinder Spray Adhesive
- 3M™ Holdfast 70 Cylinder Spray Adhesive

The majority of applications can be done with these two cylinder products.



3M™ Postforming 94 CA Cylinder Spray Adhesive is a low telegraphing that dries quickly to reach postformable strength in 1-5 minutes. A 1-15 minute open time provides flexibility in assembly speed.



For fast, easy foam board installation, simply spray and stick with 3M™ HoldFast 70 Cylinder Spray Adhesive. Bonds foam to concrete, waterproofing, OSB and more without damaging the foam.

Most common applications:

- High pressure laminate
- Foam/paper core steel door
- Upholstery
- Metal lamination
- Insulation bonding

Where to find these applications:

- Cabinet/countertop shops
- Elevator interiors
- Fixture/display/exhibit manufacturing
- Office furniture
- Theatre/production sets
- Acoustic panel/partition



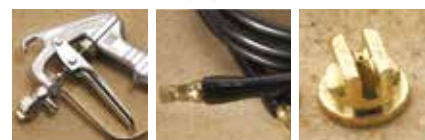
3M™ Cylinder Spray Adhesives do not atomize spray patterns with added airline. This means you get consistent even spray patterns, potentially saving rework and cleanup.

3M™ Cylinder Spray Adhesive Quick Reference Guide

Product	Application	Solids (%)	Open Time (min)	Spray Pattern	Recommended Tips
MULTI-PURPOSE					
70	Construction, Marine, RV, Polystyrene	21	1-60	Lace	QSS tip
77	Multi-Purpose	27	1-30	Mist	250050, 650050
HEAVY DUTY					
90	Laminating	13	1-15	Lace	9501, 6501, 250050
94 CA	Laminating	28	1-15	Pebble	4001, 6501
FOAM & FABRIC					
74	Foam Bonding	22	1-15	Lace	9501, 6501
SPECIALTY					
78 HT	Polystyrene	15	1-60	Lace	9501, 6501

Spray Tip	Angle	Spray Pattern Width
9501	95°	10 - 30 cm
6501	65°	7 - 20 cm
4001	40°	5 - 15 cm
QSS*	—	10 - 40 cm

*For 3M™ HoldFast 70 Spray Adhesive



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Practical Information Regarding Sprayable Adhesives

Key Questions for Adhesive Selection

Asking the right questions related to the application will help you arrive at an adhesive selection quickly and painlessly.

Use A.S.P.E.C.

- What is the **APPLICATION** that is being used to bond the materials in the current manufacturing process?
- What **SUBSTRATES** does the adhesive need to bond to?
- Are there special **PROCESS** details the adhesive needs to accommodate? Such as high temperatures or VOC regulations?
- What kinds of **END USE** stress or environment will the bond be subject to? (e.g., boat carpet and saltwater conditions or exterior applications).
- Given the **COST** of the product, what is the total **VALUE** offered? (e.g., Improved coverage, reduced flammability or speed of application).



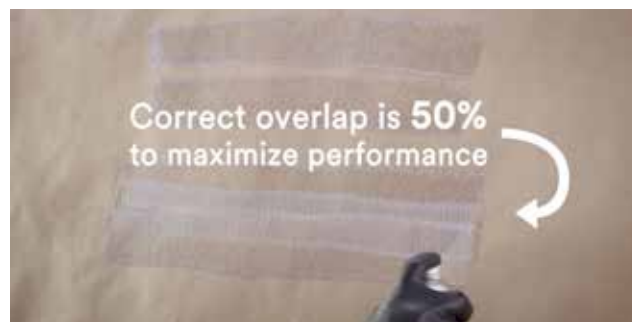
How to Spray Adhesives Correctly

SODA: Speed - Overlap - Distance - Angle

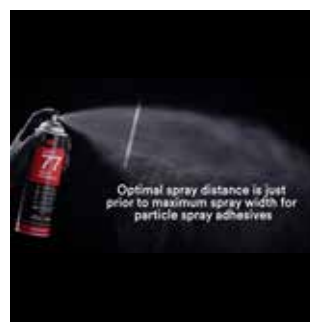
Keep this easy to remember principle in mind every time you are using sprayable adhesives.



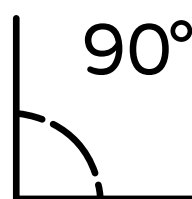
Speed: Keep a constant speed when applying the adhesive



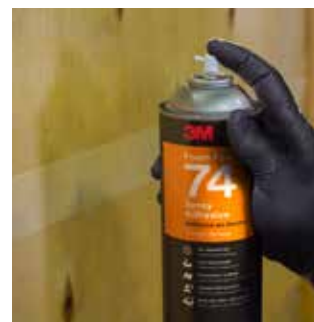
Overlap: Always spray with a 50% overlap



Distance: Optimal distance is just prior to maximum spray width for both mist and lace sprays



Angle: Keep a 90° angle to the surface with the adhesive for optimal coverage



Multipurpose

49

3M™ Fastbond™ Insulation Adhesive 49

- Fast-tacking, high performance, water-based, pressure-sensitive adhesive
- Ideal for lightweight materials such as fiberglass, felt, paper
- Permits immediate repositioning while providing long-lasting strength

Clear	
7000079968	2 liter, Jerry can
7000079967	20 liter, Pail

70

3M™ HoldFast 70 Spray Adhesive

- Extremely versatile, fast-tacking, industrial-grade adhesive
- Unique wide-web spray pattern with heavy body and low soak-in formula
- Bonds polystyrene without degrading the surface

Clear	
7100138478	Large Cylinder

77

3M™ Super 77™ Multipurpose Spray Adhesive

- High tack, high coverage and low soak-in formula
- Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
- Bonds in 15 seconds

Clear	
7000116782	500 ml, Aerosol
7000116822	20 liter, Drum
7100138125	Large Cylinder

1000NF

3M™ Fast Tack Water Based Adhesive 1000NF

- Quick bond in a one-part adhesive
- High coverage with potential for one surface application
- Bonds a wide variety of substrates with high temperature resistance
- Performs best when at least one substrate is porous

Clear		Purple	
7100011610	1 gallon, Jerry can	7100007793	1 gallon, Jerry can
7100007793	5 gallon, Pail	7000046563	5 gallon, Pail
7100169834	52 gallon, Drum	7000046564	52 gallon, Drum

Heavy Duty

10

3M™ Neoprene Contact Adhesive 10

- Economical, fast-grabbing, industrial-grade adhesive
- Variable-width spray pattern
- Forms powerful, permanent bonds to concrete, wood, MDF, laminates and polyethylene

Light Yellow	
7000080206	1 liter, Can
7000080207	5 liter, Can
7000080208	20 liter, Can

30NF

3M™ Fastbond™ Contact Adhesive 30NF

- Water-dispersed, high strength contact adhesive
- Long bonding range with high immediate bond strength
- Bonds most foamed plastics, plastic laminate, wood, plywood, wood veneer, canvas and more

Clear		Blue	
7000080239	1 liter, Can	7100015462	1 liter, Can
7000080242	5 liter, Can	7000080243	5 liter, Can
7000080245	20 liter, Drum	7000080244	20 liter, Drum
7000080246	200 liter, Drum	7000080247	200 liter, Drum

2000NF

3M™ Fastbond™ Contact Adhesive 2000NF

- A water-dispersed, high solids activated adhesive
- Immediate bonding and handling strength without forced drying
- High heat resistance, high strength

Clear		Blue	
7100029348	19 liter, Kit	7100083354	17 liter, Drum
7100029517	220 liter, Kit	7100029519	10 liter, Cubitainer
		7100029518	220 liter, Kit
		7100028967	1000 liter, Tote

90

3M™ Hi-Strength 90 Spray Adhesive

- High strength and fast-tack adhesive performance
- Bonds to concrete, wood, MDF, laminates and polyethylene
- High temperature and moisture resistance

Clear	
7000116790	500 ml, Aerosol
7000028603	Large Cylinder

94CA

3M™ Hi-Strength Postforming 94CA Spray Adhesive

- Unique, non-telegraphing spray pattern delivers postformable strength
- High solids maximize coverage
- Low VOC

Clear	
7100176092	Large Cylinder

Foam & Fabric

74

3M™ Foam Fast 74 Spray Adhesive

- Fast-tacking adhesive with soft, non-dimpling bond lines
- Immediate foam-tearing strength
- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more

Clear		Orange	
7000046594	Large Cylinder	7000116772	500 ml, Aerosol

100NF

3M™ Fastbond™ Foam Adhesive 100NF

- A water-dispersed, neoprene-based contact adhesive
- One part, rapid setting adhesive
- Ideal for bonding foam to many substrates such as wood, metal, fabrics and more

Clear		Lavendar	
7000080258	20 liter, Pail	7100018691	200 liter, Drum
7000079963	200 liter, Drum		

Specialty

71

3M™ Hi-Tack Composite Spray Adhesive 71

- Specifically designed to optimize the ultimate strength of resin-infused composite parts
- Ideally suited to the dry lay up process to have little to no intrusion in resin infusion to reduce delamination risk
- Fast tack and high strength, with excellent shear holding power
- Consistent fine mist spray with high adhesive solids content for exceptional coverage
- Available in clear, or in green for better visual control during application

Clear		Green	
7010407935	710 ml, Aerosol	7010412264	710 ml, Aerosol
7100178529	Large Cylinder	7100178775	Large Cylinder

75

3M™ Repositionable 75 Spray Adhesive

- Adhesive holds strong yet removes easily for repeated use
- Low soak-in formula
- Bonds lightweight materials without damage and prevents wrinkling when bonded

Clear	
7000116775	500 ml, Aerosol

76

3M™ Hi-Tack 76 Spray Adhesive

- High tack spray adhesive creates quick, strong bonds
- Bonds hard-to-hold surfaces such as plastics to rubber, fabric, cardboard, wood, metal and more
- Variable-width lace spray pattern

Clear	
7000116779	500 ml, Aerosol

78 HT

3M™ Hi-Temperature Polystyrene Insulation 78HT Spray Adhesive

- Permanently bonds to polystyrene foam and other materials
- Will not degrade the foam
- Sprays with a lace pattern optimized for foam

Blue	
7100138817	Large Cylinder

80

3M™ Rubber and Vinyl 80 Spray Adhesive

- High strength adhesive provides strong bonds for vinyl, leather, rubber (except EPDM) and most plastics
- High temperature and plasticizer resistant
- Fast-setting contact adhesive produces rapid results

Yellow	
7000116787	500 ml, Aerosol

847

3M™ Nitrile High Performance Rubber and Gasket Adhesive 847

- Medium viscosity grade adhesive for many brush or flow applications.
- High performance adhesive intended to bond gaskets
- Adheres to nitrile rubber (BUNA), neoprene, SBR, butyl, leather, vinyl and various rubbers
- Excellent fuel, oil and water resistance
- Offers resistance to heat and moisture, performing in temperatures up to 148 °C
- Optional heat cure increases bond strength

Brown	
7000079818	150 ml, Tube
7000079819	1 liter, Can
7000079823	5 liter, Can
7000079817	20 liter, Drum

847H

3M™ Nitrile High Performance Rubber and Gasket Adhesive 847H

- High viscosity grade adhesive for many brush or flow applications requiring gap filling or reduced soak-in.
- High performance adhesive intended to bond gaskets
- Adheres to nitrile rubber (BUNA), neoprene, SBR, butyl, leather, vinyl and various rubbers
- Excellent fuel, oil and water resistance
- Offers resistance to heat and moisture, performing in temperatures up to 148°C
- Optional heat cure increases bond strength

Brown	
7000079843	20 liter, Drum

1022

3M™ Universal Sprayable Adhesive 1022

- Universal Adhesive for bonding plastics, leather, nitrile rubber, rubber etc.
- Strong and permanent bonds are achieved
- Oil, fuel and plasticizer resistant
- Solvent and heat reactivable

Dark Brown	
7000079839	1 liter, Can
7000079840	20 liter, Pail

1099

3M™ Nitrile High Performance Plastic Adhesive 1099

- High performance adhesive forms strong bonds on most vinyls and plastics
- Resists weathering, water, oil, plasticizer migration and fuels
- Provides strong, quick drying flexible bonds
- Optional heat cure increases bond strength

Light Tan	
7000079905	150ml, Tube
7000079821	1 liter, Can
7000033732	5 liter, Can
7000033731	20 liter, Drum
7000079824	200 liter, Drum

1300L

3M™ Neoprene High Performance Rubber and Gasket Adhesive 1300L

- Adheres neoprene, SBR, butyl, and other types of rubbers to other various substrates
- Excellent moisture and heat resistance and will perform up to 148°C
- Can be used as a contact or wet-bond adhesive
- High initial tack

Yellow	
7100036550	1 liter, Can
7100034893	5 liter, Can
7100036384	20 liter, Drum

1357

3M™ Neoprene High Performance Contact Adhesive 1357

- High performance laminating contact adhesive
- Adheres, sheet metals, such as stainless steel, aluminum, cold rolled steel and many plastics to numerous other substrates
- Excellent moisture and heat resistance and will perform up to up to 148°C
- High load bearing capacity

Light Yellow	
7100038272	1 liter, Can
7100038129	20 liter, Drum

2141

3M™ Neoprene Rubber and Gasket Adhesive 2141

- High performance adhesive forms strong bonds in as little as 15 minutes
- Adheres to neoprene, SBR, butyl, leather, vinyl and various rubbers
- Excellent fuel and oil resistance
- Heat and chemical resistant allows for use in unique and harsh environments
- Offers long tack range for precise placement

Light Yellow	
7000046346	1 quart, Can

2262

3M™ Plastic Adhesive 2262

- High performance adhesive forms strong bonds on most vinyls and plastics
- Resists weathering, water, plasticizer migration and fuels
- Non-yellowing formula for outdoor use
- Provides strong, quick drying flexible bonds
- Proven to not stain flexible vinyls

Light Tan	
7000000818	1 quart, Can

4235

3M™ Water Based Adhesive 4235

- Water-dispersed, pressure sensitive adhesive
- Moderate tack to allow for immediate repositioning
- Strength builds to a high level within 24 hours
- Bonds to many substrates such as glass, paper, cardboard, galvanised and stainless steel, bare and clad aluminum, polystyrene, LSE plastics, PVC, ABS, plexiglass, rubber, etc.

Clear	
7000079873	1 liter, Can
7000079874	20 liter, Drum
7000079875	200 liter, Drum

4475

3M™ Industrial Plastic Adhesive 4475

- High performance adhesive forms strong bonds on most plastics, such as ABS, polycarbonate and PMMA
- Resists weathering, water and cleaning products
- Non-yellowing formula for outdoor use
- Provides strong, quick drying flexible bonds
- Proven to not stain surfaces

Clear	
7000000920	150 ml, Tube

4693

3M™ High Performance Industrial Plastic Adhesive 4693

- High performance adhesive forms strong bonds on most plastics, polypropylene (PP), polyethylene (PE) and polyolefin blends (TPO)
- Bonds well to other plastics, such as ABS, PMMA and nylons, polyesters, rigid polystyrene
- Resists weathering, water and cleaning products
- Provides strong, quick drying flexible bonds

Clear	
7000046574	1 quart, Can
7000046575	1 gallon, Can
7000000923	5 gallon, Pail

4799

3M™ Industrial Adhesive 4799

- Heat and water resistant adhesive offering long-lasting endurance
- Bonds firmly and sticks reliably to EPDM and rubber
- Ideal for weather stripping, rubber sheet seaming/sealing

Black	
7000000926	150 ml, Tube

AC 1

3M™ Fastbond™ Activator 1

- High solids and high coverage with mist, spray application
- Convenient, portable and easy to use delivery system
- Very efficient speed of application and reduction of overspray
- Designed to speed the adhesion process of FB 30NF, FB 2000NF, FB 100NF

Light Yellow	
7000080250	2 liter, Jerry can
7000080254	200 liter, Drum

Cleaning and Maintenance

IC

3M™ Industrial Cleaner and Adhesive Remover

- Removes grease, oil, ink and most adhesives without the need to soak
- Provides mold-release agents
- Removes adhesive without damaging the surface underneath

Clear	
7100178338	500 ml, Aerosol
7100178336	200 ml, Aerosol
7100180981	5 liter, Jerry can
7100138123	Mini Cylinder

5-Way

3M™ 5-Way Penetrant

- Helps free rusted and frozen bolts, nuts and more
- Displaces moisture and “dries out” electronics
- Light-duty lubricant works well with delicate precision instruments
- Inhibits corrosion during storage

Amber	
7000116758	500 ml, Aerosol

Cylinder Accessories

3M™ Cylinder Applicators

- Spray gun dispenses adhesive in a controlled pattern
- Trigger guard prevents accidental discharge of adhesive and adjusts output
- Easy attachment and removal with an adjustable wrench

Applicators	
7000028628	Applicator, Standard Output (with Spray Tip 9501)
7000028629	Applicator, Reduced Output (with Spray Tip 4001)
7000028630	Applicator, High Output (with Spray Tip QSS)

3M™ Cylinder Hoses

- Flexible, inert nylon/synthetic rubber hose
- Available in varying lengths
- Straightforward, simple design allows for quick assembly with an adjustable wrench

Applicators	
7000046656	Hose, 6 ft
7000028624	Hose, 12 ft
7000046657	Hose, 25 ft

3M™ Cylinder Spray Tips

- Variety of angles and spray patterns based on coverage need
- Supplies uniform coverage and drying times
- Easy attachment and removal

Applicators	
7000028626	Spray Tip 4001 (5 - 15 cm)
7000046658	Spray Tip 6501 (7 - 20 cm)
7000046661	Spray Tip 9501 (10 - 30 cm)
7000046659	Spray Tip QSS (10 - 40 cm)



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