



Solutions for your assembly challenges.

Productivity Solution Co., Ltd

59 Flourish Buidling, 7th floor , Soi Ratchadapisek 18,

Ratchadapisek Rd., Huaykwang

Huaykwang, Bangkok 10310

Tel: +662-119 1955 -6

Fax: +662-119 1959

Mobile: +6682-7880208

5,000+

adhesive and tape SKUs

Do it your way.

- 3M systems are built around *your* manufacturing processes, not the other way around.
- Whether it's structural or non-structural adhesives, bonding tapes or reclosable fasteners, 3M solutions ensure speed, convenience and ease of use.



88,667

employees

Do it together.

- No matter what you need to bond, you can count on 3M's expertise, technologies and 88,667 dedicated employees to help you find solutions.
- From wood, metal, foil, insulation, foam, fabric and panel lamination to specialty high performance and multipurpose materials of every kind, solutions are one call away.

100,000

patents

Do it boldly.

- 3M has been a world leader in bonding technology for decades and we have the patents to prove it.
- Quality, consistency and reliability—the attributes you look for in a bonding solution—help drive our quest for new innovations.



1

chance to do it right

Do it responsibly.

- Sustainability is a natural extension of 3M's corporate values.
- We developed the first water-based contact adhesive ever — more than 40 years ago.
- We have a wide selection of Low VOC products that help contribute to LEED® credits and are GREENGUARD™ Certified.



Adhesives

The best formulas deliver the best performance.

Powerful Adhesive Solutions

3M offers a wide range of innovative adhesives and sealants designed for industrial markets. High quality, precision formulations with proven performance provide reliable, long-term durability for a variety of applications, indoors and out.

3M™ Scotch-Weld™ Structural Adhesives

Improving product and process.

In today's world, successful new products demand advancements in both design and manufacturing processes. Industrial engineering and design professionals around the world depend on 3M™ Scotch-Weld™ Structural Adhesives to help them design beyond the limits of mechanical fasteners to create next generation products.

Trusted innovations from aerospace to office space.

With over 50 years of experience developing innovative structural adhesives for aerospace, automotive and hundreds of other industries, 3M delivers the solutions you can trust. Our advanced formulations create durable bonds, even on challenging materials or in extreme conditions.



Advanced product designs and process innovations.

The benefits of designing and building products with 3M Scotch-Weld Structural Adhesives help drive product success.

- **Freedom of Design:**
Improve aesthetics, reduce weight and noise, enhance corrosion and fatigue resistance and more.
- **Low Odor Advantages:**
Improve your environment with 3M's low odor structural adhesives.
- **Process Efficiencies:**
Speed production with quiet, fast and easy manufacturing processes.
- **Dispensing Options:**
Dispense by hand or with automated equipment.



3M global service and support.

3M supports our customers with the testing, technology and training needed to create better products. Our world-wide support staff has the experience you can rely on for everything from structural adhesive selection to process improvement.



Leverage 3M's
proven selection of
structural adhesives, deep
industry expertise and technical
support to your advantage.

**Design with Confidence.
Build to Last.**

Simplifying adhesive decisions for your application.

What materials will be bonded?

Structural adhesives work by adhering to the top surface of the bonded parts, so it's important to know the exact material and condition on those surfaces. For metals, will the adhesive be applied to bare metal, or will there be a paint or coating on the surface? For plastics, exactly which base resin? Could there be residual release agents on the surfaces used for mold release?

What is the preferred cure speed?

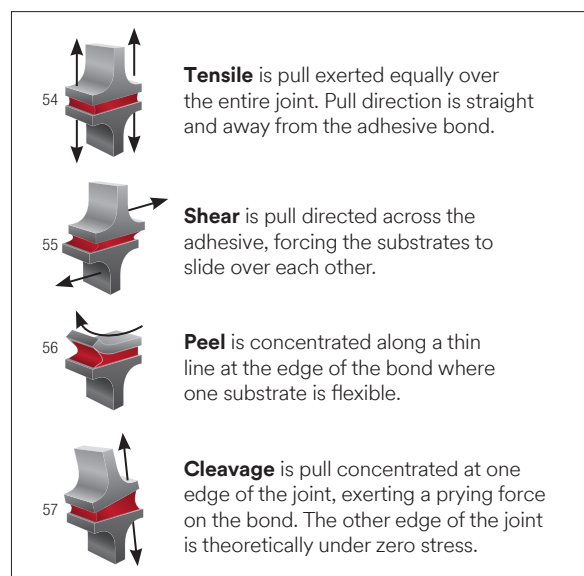
The chosen structural adhesive must have enough work life (open time, pot life) to allow proper mixing and application of the adhesive and assembling of the bonded parts. Smaller assemblies or shorter cycle time production processes may be able to use a faster curing adhesive with a work life of only five minutes or less, while larger assemblies that require alignment and clamping will probably need a work life of 20 minutes or more.

What surface preparation will be required?

Structural adhesives generally prefer clean, rough, dry surfaces for highest bond strength. This typically means either light abrasion and solvent cleaning of the surface, or solvent cleaning followed by chemical etching or applying a primer. Adhesion tests should be performed to determine the adequate surface preparation for a specific application.

What types of joints are best for structural adhesives?

Joint designs that put the adhesive bond under shear, tension, or compression forces will provide the highest strength. Designs that tend to apply peel or cleavage forces to the adhesive, where the applied stresses are not distributed over the entire bond area, will have lower bond strength, but the bond may still be sufficient for the needs of the application. In addition, optimum bond line thickness typically ranges from 0.005" to 0.020". The adhesive qualification process should always include testing of prototype assemblies to ensure the adhesive will provide enough performance.



How are structural adhesives used and applied?

Structural adhesives come in many forms, including low viscosity liquids and non-sag pastes, one- and two-component formulations, short and long work lives, and various package sizes and shapes. Most two-part structural adhesives are available in both bulk containers and convenient, easy-to-use dispense cartridge mixing systems.

What are the general characteristics of the different types of structural adhesives?

All structural adhesives provide at least 1,000 psi of overlap shear strength to aluminum, but each have various properties:

- **Epoxy adhesives** come in both two-part adhesives (that cure upon mixing the two components) and one-part adhesives (that cure with temperature). Generally, they have the highest strength and overall performance, and provide the best resistance to high temperatures, solvents and outdoor weathering. They adhere well to metals, woods and concrete, and flexible epoxy adhesives also bond to some plastics and rubbers. Epoxy adhesives usually require clean, abraded surfaces to obtain maximum bond strength.
- **Acrylic adhesives** are two-part adhesives that provide excellent bond strength and durability, although slightly lower than epoxy adhesives. However, they have several features that make them easier to use, including a much faster cure speed, higher tolerance for oily or unprepared bonding surfaces and the ability to bond a wide variety of materials, including nearly all plastics. Newer acrylic adhesive formulations are room temperature stable with a long shelf life, and some have much lower odor than regular acrylic adhesives.
- **Urethane adhesives** are two-part adhesives that are relatively flexible when cured, have excellent impact resistance and good adhesion to most plastics. They also bond well to woods, concrete and rubbers, but have reduced resistance to solvents and high temperatures. Uncured adhesive components are sensitive to moisture.
- **Cyanoacrylate adhesives** (instant adhesives) are one-component, lower viscosity liquids that cure extremely quickly with just contact pressure and surface moisture. They adhere well, with thin bond lines, to plastics, metals and rubbers. With the use of primers, they can also adhere to low surface energy plastics and elastomers. They have lower flexibility, peel strength and impact resistance compared to other structural adhesives. They are generally used for gasket bonding and smaller assemblies.
- **Anaerobic adhesives** are one-part adhesives that cure on active metal surfaces when oxygen gets excluded from the bond line. They keep your factory running efficiently, reducing maintenance and leakage. They do not bond well to glass, plastics or rubbers, and are primarily used for locking threads and sealing pipe connections.

Key markets and applications for 3M™ Scotch-Weld™ Structural Adhesives.



Aerospace

Key Benefits

- Flame, smoke and toxicity compliance
- UL94 V-0 rated formulation
- Strong, yet flexible formulations

Lead Products

2216 Gray, DP100FR, DP640



Appliance

Key Benefits

- Bonds powder coated materials
- Noise dampening
- Joins plastic and glass to metals

Lead Products

DP125 Gray, DP8810NS, TL42



Electronics

Key Benefits

- Low halogen
- Fast curing
- Potting

Lead Products

DP420LH, DP270, DP8805NS, PR100



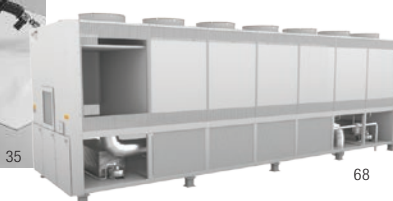
Metalworking

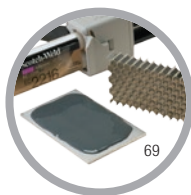
Key Benefits

- High strength
- Reduces surface preparation
- Replaces mechanical fasteners

Lead Products

DP420NS Black, DP8410NS, LSB60NS





Plastic, Composite & Rubber

Key Benefits

- Bonds low surface energy plastics without priming
- Impact resistant composite bonding

Lead Products

DP8010 Blue, DP420NS, PR100



Signage

Key Benefits

- Bonds a variety of materials
- Weather resistant
- UL recognized

Lead Products

DP8805NS, DP8405NS, DP100 Plus



Specialty Vehicle

Key Benefits

- Reduces weight
- High strength
- Vibration and fatigue resistant

Lead Products

DP8810NS, LSB60NS, TL42



Sporting Goods

Key Benefits

- Excellent impact resistance
- High strength for small joints
- Bonds rubber, composites and metals

Lead Products

DP420NS Black, DP8810NS, PR100



3M™ Scotch-Weld™ Structural Adhesives



292

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #	
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)				
3M™ Scotch-Weld™ Rigid Epoxies													
★	DP100 100 (Clear)	General purpose. Rigid bonds.	1:1	13,000	5 minutes	20 minutes	2	900	1,500	300	50mL	00-021200-22648-9	62-3575-1435-5
											200mL	00-021200-87260-0	62-3575-3830-0
											400mL	00-021200-87261-7	62-3575-3530-1
											5 gal. pail B	00-021200-82344-2	62-3575-8531-4
										5 gal. pail A	00-021200-82345-9	62-3675-8531-2	
	DP100FR 100FR (Cream)	Flame retardant. UL94 V-0 rating.	1:1	80,000	6 minutes	20 minutes	2	1,250	2,200	800	50mL	00-048011-56742-6	62-3531-1435-8
											200mL	00-048011-56744-0	62-3531-3830-8
											400mL	00-048011-56743-3	62-3531-3530-4
											5 gal. pail B	00-048011-57229-1	62-3531-8530-9
										5 gal. pail A	00-048011-57230-7	62-3631-8530-7	
	DP100NS 100NS (Translucent)	General purpose. Non-sag.	1:1	95,000	5 minutes	20 minutes	2	900	1,500	300	50mL	00-021200-82255-1	62-3265-1435-3
											200mL	00-021200-87264-8	62-3265-3830-3
											400mL	00-021200-87265-5	62-3265-3530-9
											5 gal. pail B	00-021200-82256-8	62-3265-8530-4
										5 gal. pail A	00-021200-82257-5	62-3365-8530-2	
★	DP190 (Gray)	High performance. Slightly flexible bonds.	1:1	80,000	90 minutes	10 hours	50	1,500	2,500	400	50mL	00-021200-22647-2	62-3553-1435-2
											200mL	00-021200-87840-4	62-3553-3830-2
											400mL	00-021200-87841-1	62-3553-3530-8
											DP270 270 (Black)	Rigid potting compound. Non-corrosive.	1:1
200mL	00-021200-87836-7	62-3266-3830-1											
400mL	00-021200-87837-4	62-3266-3530-7											
1 gal. kit	00-021200-82263-6	62-3266-7430-6											
										5 gal. pail B	00-021200-82264-3	62-3266-8530-2	
										5 gal. pail A	00-021200-82265-0	62-3366-8530-0	
	DP270 270 (Clear)	Rigid potting compound. Non-corrosive.	1:1	12,000	60 minutes	3 hours	2	1,200	2,500	300	50mL	00-021200-82248-3	62-3262-1435-0
											200mL	00-021200-87834-3	62-3262-3830-0
											400mL	00-021200-87835-0	62-3262-3530-6
											5 gal. pail B	00-021200-82250-6	62-3262-8530-1
										5 gal. pail A	00-021200-82251-3	62-3362-8530-9	
	1751 B/A (Gray)	Excellent void filler. Rigid bonds.	3:2	700,000	45 minutes	10 hours	4	1,400	2,000	500	2 oz. tube kit	00-021200-20100-4	62-1751-0530-3
											1 pt. kit	00-021200-20101-1	62-1751-5430-1
											1 qt. kit	00-021200-20103-5	62-1751-6430-0
											1 gal. kit	00-021200-20105-9	62-1751-7430-9
											5 gal. pail B	00-021200-20108-0	62-1751-8530-5
											5 gal. pail A	00-021200-20120-2	62-1752-8530-3
	1838 B/A (Green)	Multi-purpose. Rigid bonds.	4:5	400,000	60 minutes	8 hours	4	1,500	3,000	500	2 oz. tube kit	00-021200-20148-6	62-1838-0530-8
											1 pt. kit	00-021200-20150-9	62-1838-5430-6
											1 qt. kit	00-021200-20152-3	62-1838-6430-5
											1 gal. kit	00-021200-20154-7	62-1838-7430-4
											5 gal. pail B	00-021200-20155-4	62-1838-8530-0
											5 gal. pail A	00-021200-20160-8	62-1839-8530-8
	1838 B/A (Tan)	Multi-purpose. Rigid bonds.	5:6	250,000	60 minutes	8 hours	4	1,500	2,000	500	1 qt. kit	00-021200-22599-4	62-1614-6435-9
											5 gal. pail B	00-021200-22600-7	62-1614-8535-4
											5 gal. pail A	00-021200-22603-8	62-1752-8535-2
											1838L B/A (Translucent)	Multi-purpose. Rigid bonds.	1:1
1 qt. kit	00-021200-22646-5	62-3520-6435-6											
5 gal. pail B	00-021200-82634-4	62-3520-8531-0											
5 gal. pail A	00-021200-82635-1	62-3620-8531-8											
	2158 B/A (Gray)	Multi-purpose. Rigid bonds.	1:1	375,000	2 hours	10 hours	3	1,500	2,000	400	1 pt. kit	00-021200-20258-2	62-2158-5430-8
											1 qt. kit	00-021200-20260-5	62-2158-6430-7
											1 gal. kit	00-021200-20262-9	62-2158-7430-6
											5 gal. pail B	00-021200-20264-3	62-2158-8530-2
											5 gal. pail A	00-021200-20269-8	62-2159-8530-0
												3501 B/A (Gray)	Multi-purpose. Rigid bonds.
400mL	00-021200-45184-3	62-3501-3530-7											
1 pt. kit	00-021200-20843-0	62-3501-5430-8											
1 gal. kit	00-021200-20846-1	62-3501-7430-6											
55 gal. drum	00-051111-91639-1	62-3501-9530-1											

DP = Duo-Pak NS = Non-Sag

★ Consider these products first when evaluating adhesives for your application.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Structural Adhesives (cont.)



Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
3M™ Scotch-Weld™ Flexible Epoxies												
DP100 Plus 100 Plus (Clear)	Very flexible. Colorless.	1:1	8,500	4 minutes	20 minutes	55	3,000	3,500	200	50mL	00-021200-87195-5	62-3272-1435-9
										200mL	00-021200-87266-2	62-3272-3830-9
										400mL	00-021200-87267-9	62-3272-3530-5
										5 gal. pail B	00-021200-87197-9	62-3272-8530-0
										5 gal. pail A	00-021200-87198-6	62-3372-8530-8
DP105 105 (Clear)	Very flexible. Colorless.	1:1	6,500	5 minutes	20 minutes	50	3,500	2,000	150	50mL	00-021200-87203-7	62-3287-1435-7
										200mL	00-021200-87270-9	62-3287-3830-7
										400mL	00-021200-87271-6	62-3287-3530-3
										5 gal. pail B	00-021200-87205-1	62-3287-8530-8
										5 gal. pail A	00-021200-87206-8	62-3387-8530-6
DP110 110 (Gray)	General purpose. Flexible bonds.	1:1	55,000	8 minutes	20 minutes	40	2,700	3,500	250	50mL	00-021200-82470-8	62-3533-1434-7
										200mL	00-021200-87274-7	62-3533-3830-4
										400mL	00-021200-87275-4	62-3533-3530-0
										5 gal. pail B	00-021200-82471-5	62-3533-8531-3
										5 gal. pail A	00-021200-82472-2	62-3633-8531-1
DP110 110 (Translucent)	General purpose. Flexible bonds.	1:1	50,000	8 minutes	20 minutes	40	2,500	2,500	200	50mL	00-021200-82465-4	62-3563-1434-4
										200mL	00-021200-87846-6	62-3563-3830-1
										400mL	00-021200-87847-3	62-3563-3530-7
										5 gal. pail B	00-021200-82466-1	62-3563-8531-0
										5 gal. pail A	00-021200-82467-8	62-3663-8531-8
DP125 125 (Gray)	High performance. Very flexible bonds.	1:1	52,500	25 minutes	2.5 hours	90	3,400	4,300	400	50mL	00-002100-87211-2	63-3291-1435-9
										200mL	00-002100-87842-8	62-3291-3830-9
										400mL	00-002100-87843-5	62-3291-3530-5
										5 gal. pail B	00-002100-87217-4	62-3293-8530-6
										5 gal. pail A	00-002100-87218-1	62-3393-8530-4
DP125 125 (Translucent)	High performance. Very flexible bonds.	1:1	15,000	25 minutes	2.5 hours	85	4,000	2,500	150	50mL	00-021200-87211-2	62-3291-1435-9
										200mL	00-021200-87842-8	62-3291-3830-9
										400mL	00-021200-87843-5	62-3291-3530-5
DP190 (Translucent)	High performance. Flexible bonds.	1:1	10,000	80 minutes	6 hours	60	3,500	1,200	150	50mL	00-021200-87219-8	62-3286-1435-9
										200mL	00-021200-87838-1	62-3286-3830-9
										400mL	00-021200-87839-8	62-3286-3530-5
2216 B/A (Gray)	High performance. Very flexible bonds.	2:3	80,000	90 minutes	10 hours	50	3,000	3,200	400	2 oz. tube kit	00-021200-20351-0	62-2216-0530-6
										1 pt. kit	00-021200-20354-1	62-2216-5430-4
										1 qt. kit	00-021200-20356-5	62-2216-6430-3
										1 gal. kit	00-021200-20358-9	62-2216-7430-2
										5 gal. pail B	00-021200-20360-2	62-2216-8530-8
										5 gal. pail A	00-021200-20365-7	62-2217-8530-6
										55 gal. drum B	00-021200-20361-9	62-2216-9530-7
										55 gal. drum A	00-021200-20366-4	62-2217-9530-5
2216 B/A (Translucent)	General purpose. Very flexible bonds.	1:1	10,000	2 hours	14 hours	70	3,000	1,700	140	2 oz. tube kit	00-021200-20851-5	62-3508-0530-5
										1 pt. kit	00-021200-20852-2	62-3508-5430-3
										1 qt. kit	00-021200-20854-6	62-3508-6430-2
										1 gal. kit	00-021200-20856-0	62-3508-7430-1
										5 gal. pail B	00-021200-64980-6	62-3508-8535-6
										5 gal. pail A	00-021200-64981-3	62-3608-8535-4
										55 gal. drum B	00-021200-20859-1	62-3508-9530-6
										55 gal. drum A	00-021200-20927-7	62-3608-9530-4
2216NS B/A (Tan)	High performance. Non-sag.	2:3	350,000	2 hours	10 hours	50	2,000	2,500	400	5 gal. pail B	00-021200-87179-5	62-3278-8530-7
										5 gal. pail A	00-021200-87180-1	62-3378-8530-5
LSB90 (Off-White)	General purpose. Very flexible bonds.	1:1	25,000	90 minutes	10 hours	40	3,500	2,500	400	400mL	00-051115-63419-2	62-3556-3532-7
										5 gal. pail B	00-051115-63420-8	62-3556-8532-2
										5 gal. pail A	00-051115-63421-5	62-3656-8532-0
										55 gal. drum B	00-051115-63423-9	62-3556-9532-1
										55 gal. drum A	00-051115-63425-3	62-3656-9532-9

DP = Duo-Pak

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Structural Adhesives (cont.)



292

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
3M™ Scotch-Weld™ Toughened Epoxies												
DP405 405 (Black)	Tough durable bonds. High impact resistance.	2:1	40,000	4 minutes	15 minutes	40	4,500	4,500	600	37mL	00-051111-07698-9	62-2814-1435-9
										200mL	00-051111-07700-9	62-2814-3830-9
										400mL	00-051111-07699-6	62-2814-3530-5
										5 gal. pail B	00-051111-07707-8	62-2814-8530-0
										5 gal. pail A	00-051111-07708-5	62-2914-8530-8
DP420 420 (Black)	Tough durable bonds. High impact resistance.	2:1	30,000	20 minutes	2 hours	75	4,500	4,500	1,250	37mL	00-021200-41528-9	62-2778-1435-6
										200mL	00-021200-41530-2	62-2778-3830-6
										400mL	00-021200-41529-6	62-2778-3530-2
										5 gal. pail B	00-021200-41531-9	62-2778-8530-7
										5 gal. pail A	00-021200-41532-6	62-2878-8530-5
55 gal. drum B	00-021200-41533-3	62-2778-9530-6										
55 gal. drum A	00-021200-41534-0	62-2878-9530-4										
DP420 420 (Off-White)	Tough durable bonds. High impact resistance.	2:1	30,000	20 minutes	2 hours	70	4,500	4,500	450	37mL	00-021200-82236-0	62-3280-1435-2
										200mL	00-021200-87832-9	62-3280-3830-2
										400mL	00-021200-87833-6	62-3280-3530-8
										5 gal. pail B	00-021200-82238-4	62-3280-8530-3
										5 gal. pail A	00-021200-82239-1	62-3380-8530-1
1 gal. kit B/A	00-021200-97347-5	62-3280-7530-4										
DP420LH 420LH (Off-White)	Tough durable bonds. Low halogen.	2:1	30,000	20 minutes	2 hours	70	4,500	4,500	1,250	37mL	00-051111-07244-8	62-2818-1435-0
										200mL	00-051111-07697-2	62-2818-3830-0
										400mL	00-051111-07696-5	62-2818-3530-6
										5 gal. pail B	00-051111-07275-2	62-2818-8530-1
										5 gal. pail A	00-051111-07276-9	62-2918-8530-9
DP420NS 420NS (Black)	Tough durable bonds. Non-sag.	2:1	180,000	20 minutes	2 hours	60	4,500	4,500	1,250	37mL	00-021200-39285-6	62-3299-1435-2
										200mL	00-021200-39286-3	62-3299-3832-8
										400mL	00-021200-39287-0	62-3299-3532-4
										5 gal. pail B	00-021200-56587-8	62-3299-8535-2
										5 gal. pail A	00-021200-31309-7	62-3399-8530-1
55 gal. drum B	00-048011-58132-3	62-3299-9530-2										
55 gal. drum A	00-048011-58133-0	62-3399-9530-0										
DP460 460 (Off-White)	Tough durable bonds.	2:1	30,000	60 minutes	4 hours	80	4,500	4,500	700	37mL	00-021200-82225-4	62-3593-1435-8
										200mL	00-021200-87830-5	62-3593-3830-8
										400mL	00-021200-87831-2	62-3593-3530-4
										1 qt. kit	00-021200-82226-1	62-3593-6430-4
										5 gal. pail B	00-021200-82227-8	62-3593-8530-9
5 gal. pail A	00-021200-82228-5	62-3693-8530-7										
DP460NS 460NS (Off-White)	Tough durable bonds. Non-sag.	2:1	125,000	60 minutes	4 hours	70	4,900	4,650	1,350	37mL	00-021200-43670-3	62-2792-1435-7
										200mL	00-021200-43671-0	62-2792-3830-7
										400mL	00-021200-43672-7	62-2792-3530-3
										5 gal. pail B	00-021200-43673-4	62-2792-8530-8
										5 gal. pail A	00-021200-43674-1	62-2892-8530-6
LSB60 (Gray)	Tough durable bonds. High impact resistance.	1:1	30,000	90 minutes	10 hours	15	3,400	4,500	900	400mL	00-051115-63411-6	62-3554-3532-2
										5 gal. pail B	00-051115-63414-7	62-3554-8532-7
										5 gal. pail A	00-051115-63416-1	62-3654-8532-5
										55 gal. drum B	00-051115-63417-8	62-3554-9532-6
										55 gal. drum A	00-051115-63418-5	62-3654-9532-4
LSB60NS (Gray)	Tough durable bonds. Non-sag. High impact resistance.	1:1	180,000	90 minutes	10 hours	30	3,800	4,500	800	400mL	00-051115-63426-0	62-3562-3532-5
										5 gal. pail B	00-051115-63427-7	62-3562-8532-0
										5 gal. pail A	00-051115-63428-4	62-3662-8532-8
										55 gal. drum B	00-051115-63429-1	62-3562-9532-9
										55 gal. drum A	00-051115-63430-7	62-3662-9532-7
LSB360NS (Green)	Tough durable bonds. Non-sag. Extra long work life. Bonds oily metals.	1:1	Paste	10 hours	16 hours	30	4,000	3,900	800	400mL	00-051111-64291-3	62-3560-3530-3

DP = Duo-Pak NS = Non-Sag LH = Low Halogen

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Structural Adhesives (cont.)



292

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
3M™ Scotch-Weld™ Low Odor Acrylics												
DP810 (Black)	Tough durable bonds. High impact resistance.	1:1	20,000	10 minutes	20 minutes	30	1,200	3,600	500	50mL 200mL 1 gal. pail 5 gal. pail 20 liter pail B 20 liter pail A	00-021200-49077-4 00-021200-49079-8 00-048011-56711-2 00-048011-56712-9 00-021200-49080-4 00-021200-49081-1	62-2788-1435-5 62-2788-3830-5 62-2788-7530-7 62-2888-7530-5 62-2788-8730-2 62-2888-8730-0
DP810 810 (Tan)	Tough durable bonds. High impact resistance.	1:1	20,000	10 minutes	20 minutes	30	1,200	3,600	500	50mL 200mL 400mL 20 liter pail B 20 liter pail A	00-021200-31310-3 00-021200-31311-0 00-021200-31312-7 00-021200-45230-7 00-021200-45233-8	62-3298-1435-4 62-3298-3830-4 62-3298-3530-0 62-3298-8730-1 62-3398-8730-9
DP810NS 810NS (Tan)	Tough durable bonds. Non-sag.	1:1	95,000	10 minutes	20 minutes	20	1,200	4,000	500	50mL 200mL 400mL 20 liter pail B 20 liter pail A	00-021200-49082-8 00-021200-49084-2 00-021200-49083-5 00-021200-49085-9 00-021200-49086-6	62-2799-1435-2 62-2799-3830-2 62-2799-3530-8 62-2799-8730-9 62-2899-8730-7
DP8805NS 8805NS (Green)	Low odor. Fast rate of strength build.	10:1	80,000	5 minutes	10 minutes	30	n/a	3,600	900	45mL 400mL 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-051115-68958-1 00-051115-68959-8 00-051115-68979-6 00-051115-68984-0 00-051115-68981-9 00-051115-68980-2	62-2852-1445-8 62-2852-3630-3 62-2852-8530-0 62-2852-9530-9 62-2952-7530-9 62-2952-8530-8
DP8810NS 8810NS (Green)	Low odor. Fast rate of strength build.	10:1	80,000	10 minutes	20 minutes	30	n/a	3,600	800	45mL 400mL 5 gal. pail B 5 gal. pail A 55 gal. drum B 55 gal. drum A	00-051115-68960-4 00-051115-68962-8 00-051115-68982-6 00-051115-68985-7 00-051115-68981-9 00-051115-68980-2	62-2854-1445-4 62-2854-3630-9 62-2854-8530-6 62-2854-9530-5 62-2952-7530-9 62-2952-8530-8
DP8825NS 8825NS (Green)	Low odor. Fast rate of strength build.	10:1	80,000	25 minutes	50 minutes	20	n/a	3,000	800	45mL 490mL 5 gal. pail 55 gal. drum 1 gal. can 5 gal. pail	00-051115-81288-0 00-051115-81289-7 00-051115-81290-3 00-051115-81291-0 00-051115-81415-0 00-051115-81414-3	62-2866-1445-8 62-2866-3630-3 62-2866-8530-0 62-2866-9530-9 62-2962-7530-8 62-2962-8530-2
Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-20°F (-29°C)	75°F (24°C)	150°F (66°C)			
3M™ Scotch-Weld™ Low Surface Energy (LSE) Plastic Acrylics												
DP8005 8005 (Black)	Bonds polyolefins and low surface energy materials.	10:1	25,000	3 minutes	3 hours	9	875	2,000	475	35mL 250mL 1 gal. pail A 5 gal. pail B 5 gal. pail A 50 gal. drum B	00-051111-92166-1 00-051111-92167-8 00-021200-45171-3 00-051111-92168-5 00-021200-45172-0 00-051111-92171-5	62-2779-0437-1 62-2779-3936-9 62-2879-7530-4 62-2779-8536-2 62-2879-8530-3 62-2779-9536-1
DP8005 8005 (Off-White)	Bonds polyolefins and low surface energy materials.	10:1	25,000	3 minutes	3 hours	17	750	2,200	500	35mL 250mL 1 gal. pail A 5 gal. pail B	00-051111-92130-2 00-051111-92131-9 00-021200-41552-4 00-051111-92143-2	62-2786-0437-6 62-2786-3936-4 62-2886-7530-9 62-2786-8536-7
DP8010 8010 (Blue)	Bonds polyolefins and low surface energy materials.	10:1	20,000	10 minutes	1 hour	n/a	2,700	2,700	500	45mL 490mL 1 gal. cont. A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-71600-3 00-051115-71601-0 00-021200-49113-9 00-051115-71669-0 00-021200-49115-3 00-051115-81460-0	62-2863-1445-5 62-2863-3630-0 62-2883-7530-6 62-2863-8530-7 62-2883-8530-5 62-2863-9530-6
DP8010NS 8010NS (Blue)	Bonds polyolefins and low surface energy materials.	10:1	65,000	10 minutes	1 hour	n/a	2,700	2,700	500	45mL 490mL 1 gal. cont. A 5 gal. pail B 5 gal. pail A 55 gal. drum B	00-051115-81451-8 00-051115-81453-2 00-021200-49113-9 00-051115-81454-9 00-021200-49115-3 00-051115-81461-7	62-2865-1445-0 62-2865-3630-5 62-2883-7530-6 62-2865-8530-2 62-2883-8530-5 62-2865-9530-1

DP = Duo-Pak NS = Non-Sag

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Structural Adhesives (cont.)



292

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
3M™ Scotch-Weld™ Standard MMA Acrylics												
DP805 805 (Light Yellow)	Fast strength build. Minimal surface prep.	1:1	110,000	3 minutes	10 minutes	35	2,500	3,500	2,200	50mL	00-021200-83758-6	62-3288-1435-5
										200mL	00-021200-87828-2	62-3288-3830-5
										400mL	00-021200-87829-9	62-3288-3530-1
										5 gal. pail B	00-021200-87233-4	62-3288-8530-6
										5 gal. pail A	00-021200-87234-1	62-3388-8530-4
DP807 807 (Light Yellow)	Short work life. Two-part toughened acrylic adhesive.	1:1	50,000	5 minutes	20 minutes	20	2,000	4,300	800	47mL	00-051115-31635-7	62-3290-1435-1
										200mL	00-051115-31636-4	62-3290-3830-1
										400mL	00-051115-31637-1	62-3290-3530-7
										5 gal. pail B	00-051115-31638-8	62-3290-8530-2
										5 gal. pail A	00-051115-31639-5	62-3390-8530-0
DP812 812 (Yellow)	Medium work life. Two-part toughened acrylic adhesive.	1:1	50,000	10 minutes	20 minutes	20	2,100	4,500	1,000	50mL	00-051115-31641-8	62-3292-1435-7
										200mL	00-051115-31646-3	62-3292-3830-7
										400mL	00-051115-31643-2	62-3292-3530-3
										5 gal. pail B	00-051115-31644-9	62-3292-8530-8
										5 gal. pail A	00-051115-31645-6	62-3392-8530-6
DP820 (Light Yellow)	Tough durable bonds. Minimal surface prep.	1:1	55,000	15 minutes	40 minutes	20	3,100	3,150	1,900	50mL	00-021200-89347-6	62-3277-1435-8
										200mL	00-021200-89348-3	62-3277-3830-8
										400mL	00-021200-89349-0	62-3277-3530-4
DP825 825 (White)	Long work life. Two-part toughened acrylic adhesive.	1:1	50,000	25 minutes	40 minutes	20	2,700	4,500	1,000	47mL	00-051115-31667-8	62-3285-1435-1
										200mL	00-051115-31668-5	62-3285-3830-1
										400mL	00-051115-31669-2	62-3285-3530-7
										5 gal. pail B	00-051115-31670-8	62-3285-8530-2
										5 gal. pail A	00-051115-31671-5	62-3385-8530-0
DP8405NS 8405NS (Green)	High impact. Adhesion to most plastics.	10:1	70,000	5 minutes	15 minutes	50	n/a	4,100	900	45mL	00-051115-68963-5	62-2856-1445-9
										490mL	00-051115-68964-2	62-2856-3630-4
										5 gal. pail	00-051115-68986-4	62-2856-8530-1
										55 gal. drum	00-051115-68987-1	62-2856-9530-0
DP8410NS 8410NS (Green)	High impact. Adhesion to most plastics.	10:1	70,000	10 minutes	25 minutes	50	n/a	4,100	800	45mL	00-051115-70994-4	62-2860-1445-1
										490mL	00-051115-70995-1	62-2860-3630-6
										5 gal. pail	00-051115-70997-5	62-2860-8530-3
										55 gal. drum	00-051115-71101-5	62-2860-9530-2
DP8425NS 8425NS (Green)	High impact. Adhesion to most plastics.	10:1	70,000	25 minutes	50 minutes	50	n/a	3,700	800	45mL	00-051115-81303-0	62-2862-1445-7
										490mL	00-051115-81302-3	62-2862-3630-2
										5 gal. pail	00-051115-81298-9	62-2862-8530-9
										55 gal. drum B	00-051115-81031-6	62-2862-9530-8
3M™ Scotch-Weld™ Flexible Urethanes												
DP604NS 604NS (Black)	Flexible. Non-sag.	1:1	Paste	4 minutes	20 minutes	30	1,400	600	300	50mL	00-021200-96412-1	62-2648-5030-6
										5 gal. pail B	00-021200-96461-9	62-2648-8530-2
										5 gal. pail A	00-021200-96462-6	62-2748-8530-0
										50 gal. drum B	00-021200-96531-9	62-2648-9530-1
										50 gal. drum A	00-021200-96532-6	62-2748-9530-9
DP640 (Brown)	Tough flexible bonds.	1:1	25,000	60 minutes	8 hours	60	3,000	2,000	400	50mL	00-021200-89543-2	62-3549-1435-0
										200mL	00-021200-89545-6	62-3549-3830-0
										400mL	00-021200-89544-9	62-3549-3530-6
3549 (Brown)	Tough flexible bonds. Non-sag.	1:1	30,000	60 minutes	8 hours	60	3,000	2,000	400	2 oz. kit	00-021200-20901-7	62-3549-0501-0
										1 qt. kit	00-021200-20902-4	62-3549-6401-7
										5 gal. pail B	00-021200-20904-8	62-3549-8501-2
										5 gal. pail A	00-021200-20942-0	62-3649-8501-0
DP5001 5001 (Black)	Flexible. Conveyor belt repair.	1:1	100,000	1 minute	15 minutes	n/a	n/a	600	n/a	50mL	00-021200-96414-5	62-3528-5032-5
										400mL	00-051111-98296-9	62-3528-3530-0
DP5106 5106 (Gray)	High strength. Control joint seals.	1:1	34,000	4 minutes	40 minutes	n/a	n/a	1,100	n/a	5 gal. pail B	00-021200-96583-8	62-3627-8535-6
										5 gal. pail A	00-021200-96584-5	62-3527-9535-4

DP = Duo-Pak NS = Non-Sag

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Structural Adhesives (cont.)



292

Product (Color)	Key Features	Mix Ratio (Volume) B:A	Approximate Viscosity at 75°F (24°C) (cP)	Approximate Mixed Work Life at 75°F (24°C)	Approximate Time to Handling Strength at 75°F (24°C)	Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)			Size	UPC	Stock #
							-67°F (-55°C)	75°F (24°C)	180°F (82°C)			
3M™ Scotch-Weld™ Semi-Rigid Urethanes												
DP600 600 (Gray)	Concrete repair. Self-leveling.	1:1	6,000	1 minute	4 minutes	20	3,200	2,300	700	50mL 400mL 8.4 fl. oz. 5 gal. pail B 5 gal. pail A	00-021200-56602-8 00-051111-98303-4 00-021200-96596-8 00-021200-96574-6 00-021200-96575-3	62-2649-5030-4 62-2649-3530-5 62-2649-1233-8 62-2649-8535-9 62-2749-8535-7
DP600NS 600NS (Gray)	Concrete repair. Non-sag.	1:1	Paste	1 minute	4 minutes	8	2,700	2,300	700	50mL 400mL	00-021200-56606-6 00-051111-98312-6	62-2652-5030-8 62-2652-3530-9
DP601 601 (Gray)	Rigid. Self-leveling.	1:1	6,000	1 minute	4 minutes	20	3,200	2,300	700	50mL 5 gal. pail B 5 gal. pail A 50 gal. drum B 50 gal. drum A	00-021200-96410-7 00-021200-96451-0 00-021200-96452-7 00-021200-96507-4 00-021200-96508-1	62-2649-5031-2 62-2649-8530-0 62-2749-8530-8 62-2649-9530-9 62-2749-9530-7
DP601NS 601NS (Gray)	Rigid. Non-sag.	1:1	Paste	1 minute	4 minutes	8	2,700	2,300	700	50mL	00-021200-96407-7	62-2652-5031-6
DP605NS 605NS (Off-White)	Semi-rigid. Non-sag.	1:1	150,000	5 minutes	20 minutes	40	4,000	2,000	600	50mL 200mL 5 gal. pail B 5 gal. pail A	00-021200-82252-0 00-021200-87853-4 00-021200-82253-7 00-021200-82254-4	62-3592-1435-0 62-3592-3830-0 62-3592-8530-1 62-3692-8530-9
DP608 608 (Black)	Flexible. Non-sag.	1:1	Paste	10 minutes	90 minutes	16	3,000	2,500	500	50mL 5 gal. pail B 5 gal. pail A 50 gal. drum B 50 gal. drum A	00-021200-96418-3 00-021200-96513-5 00-021200-96514-2 00-021200-96515-9 00-021200-96516-6	62-3268-5030-2 62-3268-8530-8 62-3368-8530-6 62-3268-9530-7 62-3368-9530-5
DP620NS 620NS (Black)	Flexible. Non-sag.	1:1	Paste	20 minutes	4 hours	40	3,000	2,500	500	50mL 5 gal. Pail B 5 gal. Pail A 50 gal. drum B 50 gal. drum A	00-021200-96416-9 00-021200-96449-7 00-021200-96450-3 00-021200-96505-0 00-021200-96506-7	62-2645-5030-2 62-2645-8530-8 62-2745-8530-6 62-2645-9530-7 62-2745-9530-5
3532 B/A (Brown)	Multi-purpose. Semi-rigid bonds.	1:1	30,000	10 minutes	90 minutes	25	2,500	2,000	300	2 oz. kit 1 qt. kit 5 gal. pail B 5 gal. pail A	00-021200-20878-2 00-021200-20879-9 00-021200-20881-2 00-021200-20935-2	62-3532-0515-6 62-3532-6430-2 62-3532-8515-8 62-3632-8516-4
3535 B/A (Off-White)	Multi-purpose. Semi-rigid bonds.	1:1	30,000	3 minutes	30 minutes	25	2,500	2,000	300	2 oz. kit 1 qt. kit	00-021200-20887-4 00-021200-20888-1	62-3535-0515-9 62-3535-6430-5

DP = Duo-Pak NS = Non-Sag

* Consider these products first when evaluating adhesives for your application.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Low Surface Energy (LSE) Plastic Acrylics

3M's Low Surface Energy Structural Acrylic Adhesives bond to low surface energy plastics such as Polypropylene (PP), Polyethylene (HDPE) and most Thermoplastic Polyolefins (TPOs), providing structural adhesive bond strength that causes the plastic material to fail before the adhesive bond.

DP8010 Blue



3M™ Scotch-Weld™ Concrete Repair Adhesives

3M's Concrete Repair Urethane Adhesives repair cracks and patch holes in minutes, providing minimal disruption to your operations. Products are available for both horizontal and vertical surfaces.

DP600



3M™ Scotch-Weld™ Structural Adhesives (cont.)

Product (Color)	Key Features	Approximate Viscosity at 75°F (24°C) (cP)	Cure Conditions		Floating Roller Peel at 75°F (24°C)	Overlap Shear (psi)				Size	UPC	Stock #
			Time (min.)	Temperature °F (°C)		-67°F (-55°C)	75°F (24°C)	180°F (82°C)	250°F (121°C)			
3M™ Scotch-Weld™ One-Part Heat Cured Epoxies												
1386 (Cream)	High temperature strength. Impact resistance.	150,000	60	350 (177)	10	3,000	5,500	4,500	2,500	1 qt. 5 gal. pail	00-021200-19917-2 00-021200-19919-6	62-1386-6525-2 62-1386-8525-0
1469 (Cream)	High temperature strength. Low viscosity.	60,000	120	350 (177)	2	3,150	3,700	3,700	3,600	1 qt. 5 gal. pail	00-021200-19949-3 00-021200-19950-9	62-1469-6525-6 62-1469-8525-4
2086 (Gray)	High temperature strength. High viscosity.	Paste	60	350 (177)	5	3,000	5,000	5,000	2,200	5 gal. pail	00-021200-20235-3	62-2086-8525-5
2214 Hi-Density (Gray)	High temperature strength. Low temperature curing.	Paste	40	250 (121)	5	3,000	4,500	4,500	1,700	6 oz. cart. 5 gal. pail	00-021200-20813-3 00-021200-20814-0	62-3414-2930-6 62-3414-8530-8
2214 Hi-Temp New Formula (Gray)	High temperature strength. Environmental resistance.	Paste	60	250 (121)	2	2,800	2,800	2,800	2,500	6 oz. cart. 5 gal. pail	00-021200-20833-1 00-021200-20835-5	62-3491-2830-6 62-3491-8530-6
2214 Hi-Temp Original (Gray)	High temperature strength. Environmental resistance.	Paste	40	250 (121)	2	2,000	2,000	3,000	2,500	6 oz. cart.	00-021200-20806-5	62-3402-2930-1
2214 Non-Metallic Filled (Cream)	High temperature strength. Higher insulation value.	Paste	40	250 (121)	7	3,000	4,000	4,500	1,500	6 oz. cart. 5 gal. pail	00-021200-20802-7 00-021200-25496-3	62-3401-0830-7 62-3401-2934-5
* 2214 Regular (Gray)	High temperature strength. Low temperature curing.	Paste	40	250 (121)	5	3,000	4,500	4,500	1,500	6 oz. cart. 1 quart 5 gal. pail	00-021200-20344-2 00-021200-20345-9 00-021200-23047-3	62-2214-2930-1 62-2214-6530-5 62-2214-8530-3
2290 (Amber)	Low solids liquid coating for metal laminations.	60	30	350 (177)	n/a	5,000	5,000	3,500	1,200	1 gal. cart. 5 gal. pail 54 gal. drum	00-021200-76225-3 00-021200-76227-7 00-021200-76228-4	62-3847-7530-0 62-3847-8531-7 62-3847-9530-8

* Consider these products first when evaluating adhesives for your application.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Plastic and Rubber Instant Adhesives

The PR (Plastic & Rubber) series of products bonds to most plastics and rubbers with a range of viscosities that will fit all your application needs.
PR40, PR100, PR600, PR1500, PRGel



3M™ Scotch-Weld™ Super Fast Instant Adhesives

The SF (Super Fast) series products are very fast setting and bond to most surfaces, including leathers and other acidic materials, making them the first choice for fast cure and material versatility.
SF20 & SF100



3M™ Scotch-Weld™ Instant Adhesives



292

Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range °F (°C)	Time to Handling (seconds)	Full Cure (hours)	Size	UPC	Stock #
Plastic and Rubber								
PR Gel (Clear)	Fast cure. Gel viscosity for maximum gap filling.	Gel	-65 to 180 (-54 to 82)	20–60	24	20 gram tube 300 gram cart.	00-051115-25265-5 00-051115-25282-2	62-6152-0362-7 62-6152-3360-8
PR40 (Clear)	Low viscosity for close fitting plastic/rubber parts.	40	-65 to 180 (-54 to 82)	3–20	24	20 gram bottle 500 gram bottle	00-051115-25204-4 00-051115-25205-1	62-6147-0360-1 62-6147-3860-7
PR100 (Clear)	General purpose. Low viscosity plastic bonder.	100	-65 to 180 (-54 to 82)	10–30	24	20 gram bottle 500 gram bottle 500 gram bottle 2 kilo bottle	00-051115-25214-3 00-051115-25939-5 00-051115-25213-6 00-051111-07176-2	62-6164-0360-6 62-6164-3865-1 62-6164-3860-2 62-6164-6860-9
PR600 (Clear)	Medium viscosity with some gap filling for plastic/rubbers.	600	-65 to 180 (-54 to 82)	4–40	24	50mL bottle	00-051115-25241-9	62-6182-0862-3
PR1500 (Clear)	General purpose. High viscosity for gap filling.	1,500	-65 to 180 (-54 to 82)	20–60	24	200 gram bottle 500 gram bottle 500 gram bottle 2 gram tube	00-051115-25222-8 00-051115-25937-1 00-051115-25221-1 00-051115-25205-0	62-6165-0360-3 62-6165-3865-8 62-6165-3860-9 62-6137-0260-4
Surface Intensive								
SI Gel (Clear)	Fast cure. Gel viscosity for maximum gap filling.	Gel	-65 to 180 (-54 to 82)	20–60	24	20 gram tube 300 gram cart.	00-051115-25266-2 00-051115-25284-6	62-6163-0362-4 62-6163-3360-5
SI100 (Clear)	Low viscosity for medium gaps.	100	-65 to 180 (-54 to 82)	3–20	24	200 gram bottle 3 gram tube 500 gram bottle	00-051115-25268-6 00-051115-25290-7 00-051115-25267-9	62-6176-0360-0 62-6176-0363-4 62-6176-3860-6
SI1500 (Clear)	High viscosity for gap filling.	1,500	-65 to 180 (-54 to 82)	5–60	24	50 gram bottle 500 gram bottle	00-048011-61662-9 00-051115-25245-7	62-6178-0862-1 62-6178-3860-2
Low Odor								
LO 100 (Clear)	General purpose. Low viscosity with reduced odor and blooming.	100	-65 to 180 (-54 to 82)	9–20	24	20 gram tube	00-048011-62732-8	62-6128-0360-1
LO 1000 (Clear)	General purpose. High viscosity with reduced odor and blooming, suitable for minor gap filling.	1,000	-65 to 180 (-54 to 82)	20–25	24	20 gram tube	00-051111-91664-3	62-6132-0360-3
General Purpose								
EC Gel (Clear)	Industrial strength thixotropic gel for maximum gap fill.	Gel	-65 to 180 (-54 to 82)	20–60	24	300 gram cart.	00-048011-62659-8	62-6196-3360-5
EC5 (Clear)	Very low viscosity for close fitting plastic/rubber parts. Wicking grade.	5	-65 to 180 (-54 to 82)	10–30	24	20 gram bottle 500 gram bottle	00-051115-81285-9 00-051115-81286-6	62-6192-0360-7 62-6192-3860-3
EC40 (Clear)	General purpose. Fast curing.	40	-65 to 180 (-54 to 82)	5–30	24	20 gram bottle 500 gram bottle	00-048011-62645-1 00-048011-62646-8	62-6190-0360-1 62-6190-3860-7
EC100 (Clear)	General purpose. Fast curing.	100	-65 to 180 (-54 to 82)	10–40	24	20 gram bottle 500 gram bottle	00-048011-62638-3 00-048011-62640-6	62-6188-0360-5 62-6188-3860-1
EC2500 (Clear)	Higher viscosity for porous materials and minor gap filling. Slower cure for repositionability.	2,500	-65 to 180 (-54 to 82)	20–60	24	20 gram bottle 500 gram bottle	00-048011-62642-0 00-048011-62636-9	62-6186-0360-9 62-6186-3860-5

Lead Product

Adhesives

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Instant Adhesives (cont.)

Product (Color)	Key Features	Typical Viscosity (cP)	Temperature Range °F (°C)	Time to Handling (seconds)	Full Cure (hours)	Size	UPC	Stock #
Super Fast								
SF20 (Clear)	Fast cure. Optimum performance on wide range of rubbers and plastics.	20	-65 to 180 (-54 to 82)	4–30	24	1 oz. bottle 1 lb. bottle	00-051111-91667-4 00-051115-25790-2	62-6151-0360-3 62-6151-3860-9
SF100 (Clear)	Fast cure. High strength with EPDM and other elastomers.	100	-65 to 180 (-54 to 82)	4–30	24	20 gram bottle 3 gram tube 1 lb. bottle	00-048011-62631-4 00-048011-62630-7 00-048011-62629-1	62-6174-0361-3 62-6174-0363-9 62-6174-3860-1
Rubber Toughened								
RT5000B (Black)	Rubber toughened for impact resistance. High viscosity for minor gap filling.	5,000	-65 to 180 (-54 to 82)	30	24	20 gram bottle 500 gram bottle	00-051111-916650 00-051115-252006	62-6135-0360-6 62-6135-3860-2
Metal								
MC100 (Clear)	Multi-purpose metal bonder.	100	-65 to 180 (-54 to 82)	4–20	24	1 oz. bottle 1 lb. bottle	00-051111-91663-6 00-048011-62634-5	62-6130-0360-7 62-6130-3860-3
Engineered Grade								
CA4	Fast setting for a variety of plastics and rubbers.	150	-65 to 180 (-54 to 82)	5–40	24	2 gram tube 1 oz. bottle 1 lb. bottle	00-021200-96601-9 00-021200-96600-2 00-021200-96597-5	62-3801-0230-1 62-3801-0330-9 62-3801-3830-5
CA5	Higher viscosity, slower setting version of CA4 for filling gaps. Meets CID A-A-3097, Type II, Class 3.	2,000	-65 to 180 (-54 to 82)	12–60	24	1 oz. bottle 1 lb. bottle	00-021200-74289-7 00-021200-74288-0	62-3802-0330-7 62-3802-3830-3
CA7	Very fast setting. Excellent metal bonder. Better shock and impact resistance.	15–40	-65 to 212 (-54 to 100)	1–30	24	1 oz. bottle 1 lb. bottle	00-021200-21061-7 00-021200-21062-4	62-3812-0330-6 62-3812-3830-2
CA8	Rapid setting. Excellent adhesion to metals, plastics and rubbers. Meets CID A-A-3097, Type II, Class 2.	70–130	-65 to 180 (-54 to 82)	5–40	24	2 gram tube 1 oz. bottle 1 lb. bottle	00-021200-21065-5 00-021200-21066-2 00-021200-21067-9	62-3815-0130-3 62-3815-0330-9 62-3815-3830-5
CA9	Slower setting for parts alignment. Useful for wire tracking and coil terminating. Meets CID A-A3097, Type II, Class 3.	1,000–1,700	-65 to 180 (-54 to 82)	20–70	24	1 oz. bottle 1 lb. bottle	00-021200-21068-6 00-021200-21069-3	62-3817-0330-5 62-3817-3830-1
CA40	Very fast setting. Excellent adhesion to many substrates including flexible vinyl and EPDM rubber.	20	-65 to 180 (-54 to 82)	3–20	24	1 oz. bottle 1 lb. bottle	00-021200-74290-3 00-021200-74291-0	62-3803-0330-5 62-3803-3830-1
CA40H	Higher viscosity version of CA40. Better void filling capabilities.	400–600	-65 to 212 (-54 to 100)	5–40	24	1 oz. bottle 1 lb. bottle	00-021200-21073-0 00-021200-21074-7	62-3829-0330-0 62-3829-3830-6
CA50 Gel	High-viscosity, non-sag gel. Less sensitive to acidic surfaces.	45,000–85,000	-65 to 212 (-54 to 100)	60–120	24	20 gram tube 200 gram tube	00-021200-82332-9 00-021200-83737-1	62-3872-0330-0 62-3872-3630-0
CA100	High peel and impact strength. High thermal shock and heat resistance.	2,500–4,500	-65 to 212 (-54 to 100)	20–70	24	1 oz. bottle 1 lb. bottle	00-021200-82334-3 00-021200-82335-0	62-3873-0330-8 62-3873-3830-4

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Instant Adhesives (cont.)

Product (Color)	Key Features	Typical Viscosity (cP)	Time to Handling (seconds)	Full Cure (hours)	Size	UPC	Stock #
Primers, Activators and Debonders							
AC09	Instant adhesive activator. Non-flammable, solvent-based. California compliant.	1	1–5	24	2 fl. oz bottle 1 liter	00-051111-07795-5 00-051111-07908-9	62-6198-0860-3 62-6198-8360-6
AC77	Instant adhesive primer for bonding of difficult-to-bond plastics such as polyethylene, polypropylene and polyacetal.	< 3	1–5	24	2 fl. oz. bottle 4 liter can 55 gallon	00-048011-62728-1 00-048011-62653-6 00-048011-62654-3	62-3907-0860-0 62-3907-7560-9 62-3907-9560-7
AC79	Instant adhesive primer for bonding of difficult-to-bond elastomers such as silicone, fluoroelastomer and EPDM.	2	1–5	24	2 fl. oz. bottle 8 fl. oz. bottle 4 liter can	00-051115-31388-2 00-051115-31389-9 00-051115-31390-5	62-3916-0860-1 62-3916-3760-0 62-3916-7560-0
AC113	Instant adhesive general purpose accelerator. Will not attack plastics.	< 3	1–5	24	2 fl. oz bottle 8 fl. oz bottle 1 qt. can 4 liter can	00-048011-62681-9 00-048011-62682-6 00-048011-62683-3 00-048011-62684-0	62-6194-0860-2 62-6194-3760-1 62-6194-6560-2 62-6194-7560-1
AC452	Instant adhesive acetone-based accelerator flashes off rapidly. Excellent adhesion. Overspray may attack some plastics.	< 2	1–5	24	2 fl. oz bottle 8 fl. oz bottle 12 oz. aerosol 4 liter can	00-048011-62685-7 00-048011-62686-4 00-048011-62687-1 00-048011-62689-5	62-6195-0860-9 62-6195-3760-8 62-6195-4460-4 62-6195-7560-8
Surface Activator	Clear, colorless organic-based liquid helps speed curing and prime surfaces. Comes with brush and spray pump.	< 10	1–5	24	2 fl. oz. bottle	00-021200-87937-1	62-3804-0830-2

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ Engineered Grade Instant Adhesives

3M™ Scotch-Weld™ Engineered Grade Instant Adhesives combine high performance, excellent adhesion and temperature resistance with the speed of instant adhesives, providing you with differentiated capabilities for your most difficult thin bond line applications. **CA5, CA40, CA40H, CA50 Gel**



83

3M™ Scotch-Weld™ Threadlockers

3M™ Scotch-Weld™ Threadlockers offer a range of products including temporary, permanent and high temperature resistance. These adhesives conform to most industry recognized standards for torque and strength. **TL42, TL62, TL71, TL90**



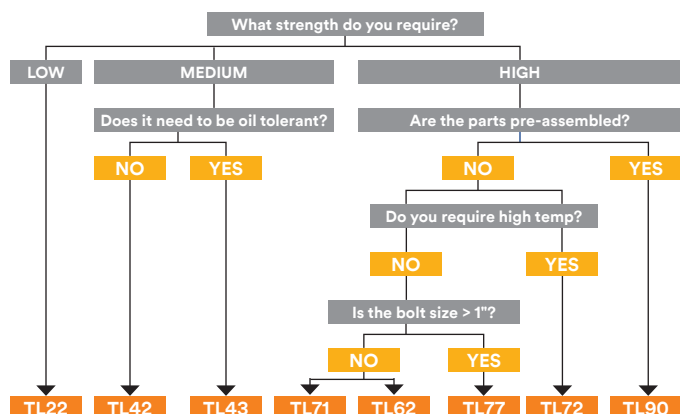
84

3M™ Scotch-Weld™ Anaerobic Adhesives

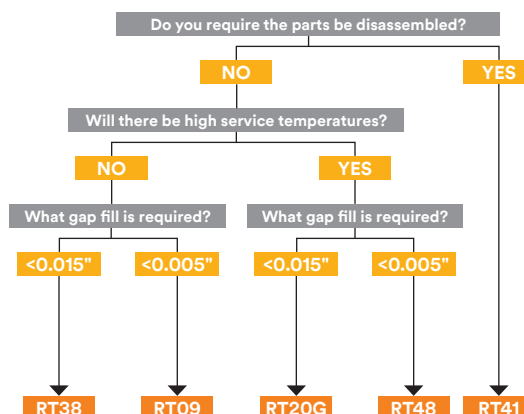


Product (Color)	Key Features	Typical Viscosity (cps)	Temperature Range °F (°C)	Time to Handling (minutes)	Full Cure (hours)	Size	UPC	Stock #
Threadlockers								
TL22 (Purple)	Screwlock. Low removal torque fasteners less than a 1/4" (6mm).	1,200	-65 to 300 (-54 to 149)	< 20	24	10mL bottle 50mL bottle 250mL bottle	00-048011-62601-7 00-048011-62602-4 00-048011-62603-1	62-3493-1060-7 62-3493-5060-3 62-3493-3960-6
TL42 (Blue)	Nutlock. Medium strength. General purpose.	1,200	-65 to 300 (-54 to 149)	< 20	24	1mL pipette 10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-048011-62604-8 00-048011-62605-5 00-048011-62606-2 00-048011-62607-9 00-051115-25124-5	62-3494-0160-4 62-3494-1060-5 62-3494-5060-1 62-3494-3960-4 62-3494-8360-2
TL43 (Blue)	Oil tolerant. Medium strength. General purpose.	3,300	-65 to 300 (-54 to 149)	< 20	24	10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-051115-25138-2 00-051115-25139-9 00-051115-25140-5 00-051115-25141-2	62-3428-1060-3 62-3428-5060-9 62-3428-3960-2 62-3428-8360-0
TL62 (Red)	Studlock. High strength with controlled torque tension.	1,600	-65 to 300 (-54 to 149)	< 20	24	10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-048011-62609-3 00-048011-62610-9 00-048011-62611-6 00-051115-25132-0	62-3495-1060-2 62-3495-5060-8 62-3495-3960-1 62-3495-8360-9
TL71 (Red)	Permanent studlock for bolts and studs up to 1" (25mm).	500	-65 to 300 (-54 to 149)	< 20	24	1mL pipette 10mL bottle 50mL bottle 250mL bottle	00-051115-25125-2 00-048011-62612-3 00-048011-62613-0 00-048011-62614-7	62-3496-0160-9 62-3496-1060-0 62-3496-5060-6 62-3496-3960-9
TL72 (Red)	High temperature studlock with gap filling for larger diameter coarse threaded parts.	7,000	-65 to 450 (-54 to 232)	< 20	24	10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-051115-25133-7 00-051115-25137-5 00-051115-25135-1 00-051115-25136-8	62-3497-1060-8 62-3497-5060-4 62-3497-3960-7 62-3497-8360-5
TL77 (Red)	Heavy duty permanent for fasteners up to 1.5" (38mm) with coarse threads.	7,000	-65 to 300 (-54 to 149)	< 20	24	10mL bottle 50mL bottle 250mL bottle	00-051115-25142-9 00-051115-25143-6 00-051115-25144-3	62-3429-1060-1 62-3429-5060-7 62-3429-3960-0
TL90 (Green)	Penetrating adhesive for pre-assembled fasteners and porosity sealing of welds.	20	-65 to 300 (-54 to 149)	< 20	24	10mL bottle 50mL bottle 250mL bottle 1 liter bottle	00-048011-62615-4 00-048011-62616-1 00-048011-62617-8 00-051115-25150-4	62-3498-1060-6 62-3498-5060-2 62-3498-3960-5 62-3498-8360-3
Pipe Sealant								
HP42	Lock/seal medium pipe threads. Prevents vibration loosening and leaks.	500	-65 to 300 (-54 to 149)	15	24	50mL bottle 250mL bottle	00-054007-99630-9 00-054007-99631-6	62-3474-5060-3 62-3474-3950-7
HP45 (Purple)	High pressure sealant for all hydraulic and pneumatic fittings.	14,000	-65 to 300 (-54 to 149)	4 hours	24	50mL bottle 250mL bottle	00-048011-62721-2 00-048011-62722-9	62-3477-5060-6 62-3477-3960-9
PS65 (White)	General purpose for applications requiring easy disassembly.	Paste	-65 to 300 (-54 to 149)	2 hours	24	50mL tube 250mL tube 1 liter bottle	00-048011-62711-3 00-048011-62712-0 00-048011-62713-7	62-3701-5067-4 62-3701-3967-7 62-3701-8360-0
PS67 (White)	Fast curing pipe sealant for inactive surfaces such as stainless steel.	Paste	-65 to 400 (-54 to 204)	15-30	24	50mL tube 250mL tube 1 liter bottle	00-048011-62714-4 00-048011-62715-1 00-048011-62716-8	62-3478-5067-9 62-3478-3967-2 62-3478-8360-5
PS77	Lock/seal medium to coarse pipe threads. Prevents vibration, loosening and leaks.	15,000 @ 20 RPM	-65 to 300 (-54 to 149)	15	24	50mL tube 250mL tube	00-054007-99635-4 00-054007-99636-1	62-3707-5067-1 62-3707-3967-4

THREADLOCKERS



RETAINING COMPOUNDS

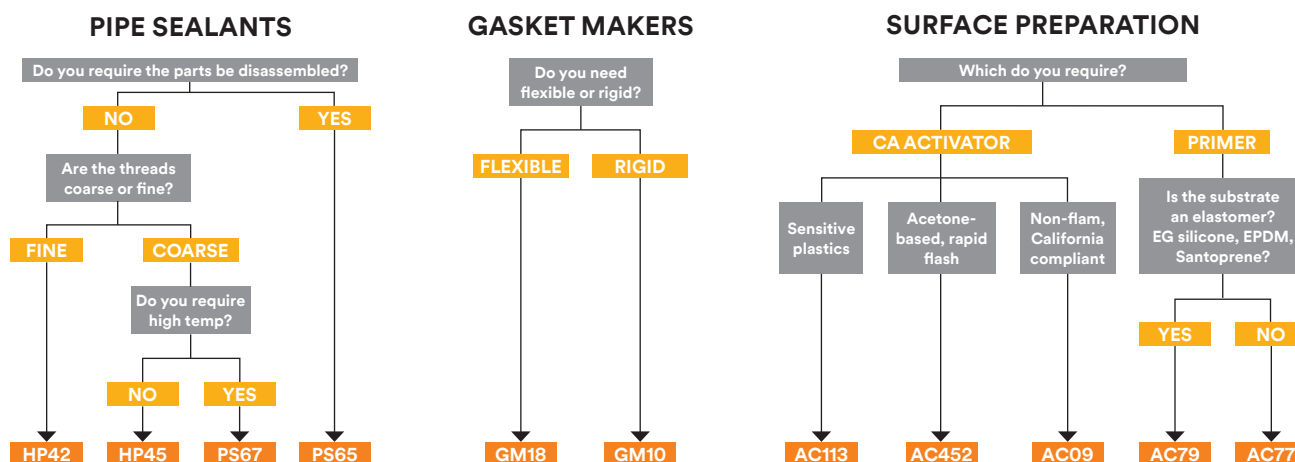


3M™ Scotch-Weld™ Anaerobic Adhesives (cont.)



Product (Color)	Key Features	Typical Viscosity (cps)	Temperature Range °F (°C)	Time to Handling (minutes)	Full Cure (hours)	Size	UPC	Stock #
Retaining Compound								
RT09 (Green)	For tight tolerances and press fit augmentation.	125	-65 to 300 (-54 to 149)	10 – 30	24	10mL bottle	00-048011-62661-1	62-3435-1060-8
						50mL bottle	00-048011-62662-8	62-3435-5060-4
						250mL bottle	00-048011-62663-5	62-3435-3960-7
						1 liter bottle	00-051115-31977-8	62-3435-8360-3
RT20G (Green)	For assembly of automotive/ marine cylinder liners and heat exchanger tubes.	7,000	-65 to 450 (-54 to 232)	30 – 40	24	10mL bottle 10/CV	00-048011-62664-2	62-3434-1060-1
						10mL bottle 300/CV	00-051115-31751-4	62-3434-1360-5
						50mL bottle	00-048011-62665-9	62-3434-5060-7
						250mL bottle	00-048011-62666-6	62-3434-3960-0
RT38 (Green)	Fast setting, high strength for bearings, bushings or sleeves on shafts or in housings.	2,500	-65 to 300 (-54 to 149)	10 – 15	24	10mL bottle	00-051115-81282-8	62-3460-1060-6
						50mL bottle	00-051115-81283-5	62-3460-5060-2
						250mL bottle	00-051115-81284-2	62-3460-3960-5
RT41 (Tan)	Medium strength for cylindrical parts. Easier disassembly for service and bearing re-use.	600	-65 to 300 (-54 to 149)	15 – 20	24	250mL bottle	00-048011-62724-3	62-3484-3960-5
RT48	High strength bonds for cylindrical parts.	600	-65 to 300 (-54 to 149)	10	24	50mL bottle	00-054007-99632-3	62-3480-5060-0
						250mL bottle	00-054007-99633-0	62-3480-3950-4
Gasket Maker								
GM10 (Red)	Masking or dressing gaskets in rigid assemblies. Can be screen printed. High temperature resistance.	Paste	-65 to 400 (-54 to 204)	30	24	50mL tube	00-048011-62652-9	62-3453-5067-2
GM18 (Red)	Instant flexible seal without a primer on mating aluminum flanges.	Paste	-65 to 300 (-54 to 149)	30	24	300 gram cart.	00-048011-62660-4	62-3454-3362-7
						50mL tube	00-048011-62658-1	62-3454-5067-0
Activators								
AC649	Acetone-based green primer for inactive or very cold surfaces. 30-day part life for pre-application. California compliant.	< 3	n/a	< 5	24	2 fl. oz. bottle	00-048011-62708-3	62-3918-0860-7
						8 fl. oz. bottle	00-048011-62709-0	62-3918-3760-6
						4 liter can	00-048011-62707-6	62-3918-7560-6

















Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.



3M™ Scotch-Weld™ EPX™ Applicators and Nozzles

For low volume applications and take-it-to-the-job convenience, the 3M™ EPX™ Plus II and 3M™ EPX™ Metal manual applicators comfortably dispense any of the 3M™ Scotch-Weld™ Duo-Pak Structural Adhesives. For higher volume applications, select the 200mL manual dispenser, or the 200mL or 400mL pneumatic dispenser. For concrete repair, there are both manual or pneumatic options.

Product	Replacement Plunger Orders	37mL (2:1) and 42mL (2:3)	45mL (10:1)	50mL (1:1)	200mL (2:1 & 1:1)	400mL (2:1 & 1:1)	490mL (10:1)	Static Mixing Nozzle Options
3M™ Scotch-Weld™ EPX™ Plus II Applicator Stock #: 62-9170-9930-1 UPC: 0-00-21200-50004-6 	1:1 Plunger Stock #: 62-9170-9911-1 UPC: 0-00-21200-50005-3							3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 37mL and 50mL Stock #: 62-9171-9153-8 UPC: 0-00-21200-50008-4 
	2:1 Plunger Stock #: 62-9170-9921-0 UPC: 0-00-21200-50006-0							3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 37mL and 50mL Stock #: 62-9178-9150-9 UPC: 0-00-51115-81449-0 
	10:1 Plunger Stock #: 62-9160-9910-4 UPC: 0-00-51115-69044-0							3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 37mL and 50mL Stock #: 62-9171-9153-8 UPC: 0-00-21200-50008-4 
								3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 37mL and 50mL Stock #: 62-9178-9150-9 UPC: 0-00-51115-81449-0 
								3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square, 45mL Stock #: 62-9154-9136-9 UPC: 0-00-51115-69043-3 
3M™ EPX™ Metal Applicator 50mL Stock #: 62-9740-9935-0 UPC: 0-00-21200-21789-0 	2:1 Plunger Stock #: 62-9744-9930-3 UPC: 0-00-21200-82314-5							3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 37mL and 50mL Stock #: 62-9171-9153-8 UPC: 0-00-21200-50008-4 
								3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 37mL and 50mL Stock #: 62-9178-9150-9 UPC: 0-00-51115-81449-5 
3M™ EPX™ Pneumatic Applicator 50mL Stock #: 62-9781-9930-5 UPC: 0-00-21200-83528-5 	N/A							3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 37mL and 50mL Stock #: 62-9171-9153-8 UPC: 0-00-21200-50008-4 
								3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 37mL and 50mL Stock #: 62-9178-9150-9 UPC: 0-00-51115-81449-5 
3M™ Scotch-Weld™ EPX™ Manual Applicator 200mL Stock #: 62-9136-9930-2 UPC: 0-00-21200-87977-7 	2:1 Plunger Stock #: 62-9136-9938-5 UPC: 0-00-21200-87981-4							3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 200mL and 400mL Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4 
								3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 200mL and 400mL Stock #: 62-9142-9930-0 UPC: 0-00-21200-87982-1 

Product	37mL (2:1) and 42mL (2:3)	45mL (10:1)	50mL (1:1)	200mL (2:1 & 1:1)	400mL (2:1 & 1:1)	490mL (10:1)	Static Mixing Nozzle Options
3M™ EPX™ 200mL, 250mL, 400mL Manual Applicator  92 Stock #: 62-9148-9930-7 UPC: 0-00-51111-98073-6				■	■		3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 200mL and 400mL Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4  93 3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 200mL and 400mL Stock #: 62-9142-9930-0 UPC: 0-00-21200-87982-1  94
3M™ EPX™ 490mL Manual Applicator  95 Stock #: 62-9182-9930-6 UPC: 0-00-51115-71115-2						■	3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical Orange, 490mL Stock #: 62-9158-9136-0 UPC: 0-00-51115-69042-6  96 3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Green, 490mL Stock #: 62-9184-9490-7 UPC: 0-00-51115-81619-2  97
3M™ Scotch-Weld™ EPX™ Pneumatic Applicator 200mL  98 Stock #: 62-9140-9930-4 UPC: 0-00-21200-87978-4				■			3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 200mL and 400mL Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4  93 3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 200mL and 400mL Stock #: 62-9142-9930-0 UPC: 0-00-21200-87982-1  94
3M™ EPX™ 400mL Pneumatic Applicator  99 Stock #: 62-9145-9930-3 UPC: 0-00-21200-87979-1					■		3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Gold, 200mL and 400mL Stock #: 62-9176-9127-1 UPC: 0-00-21200-97331-4  93 3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical White, 200mL and 400mL Stock #: 62-9142-9930-0 UPC: 0-00-21200-87982-1  94
3M™ EPX™ 490mL Pneumatic Applicator  100 Stock #: 62-9152-9930-9 UPC: 0-00-51115-69041-9						■	3M™ Scotch-Weld™ EPX™ Mixing Nozzle Helical Orange, 490mL Stock #: 62-9158-9136-0 UPC: 0-00-51115-69042-6  96 3M™ Scotch-Weld™ EPX™ Mixing Nozzle Square Green, 490mL Stock #: 62-9184-9490-7 UPC: 0-00-51115-81619-2  97
Standard Caulk Gun	3M™ Concrete Repair Urethane 8.4 oz Cartridges						3M™ Concrete Repair 8.4 oz Cartridge Nozzles Stock #: 62-9637-9935-8 UPC: 0-00-48011-53382-7  101

3M™ Concrete Repair Products

Fast, Convenient Crack and Spall Repair, Expansion Joints, Custom Threading and Anchoring, and More

3M™ Concrete Repair Products offer a complete line of conveniently packaged and dispensed adhesives/sealants for every job from cracks and joints to spalls and more.

Repairs are long lasting with strong, flexible bonds that resist weathering, expansion and contraction.

Fast setting allows you and your customers to drive on repaired surfaces in as few as five minutes. You can choose non-sag or self-leveling formulations for repairs on both vertical and horizontal surfaces. Non-sag formulation facilitates step and ledge repair.



3M™ Concrete Repair 600 self-leveling flows smoothly into cleaned cracks and gaps and hardens in as little as 5 minutes.



50mL and 12 fl. oz. duo-pak cartridges, 5-gallon pails and 55 gallon drums are available to meet your production volume requirements. Nozzle automatically and precisely meters, mixes, and dispenses two-part urethane formulation. Apply material precisely where needed to conserve material.



Make fast work of lengthy expansion or control joints and other larger jobs with the heavy-duty manual applicator and 12 fl. oz. duo-pak cartridges.



3M concrete repair formulations harden to any depth without cracking for custom threading and anchoring.

Product	Size	Description	Work Life	Initial Cure	Full Cure
DP600 Gray Self-Leveling	400mL	Repair of cracks or spalls and setting anchors in floors or horizontal surfaces.	70 sec.	5 min.	1 hr.
DP600 Gray Non-Sag	400mL	Repair of cracks in walls and setting anchors in vertical surface. Repair chipped or broken steps and ledges.	50 sec.	4 min.	1 hr.
Concrete Repair 600 Gray Self-Leveling	8.4 fl. oz.	Flows smoothly into cleaned cracks and gaps. Hardens in as little as 5 minutes. Use in common caulking guns.	70 sec.	5 min.	60 min.
DP5106 Gray	400mL	Helps relieve stress in large segments of concrete floors.	6 min.	40 min.	24 hr.
Manual Dispenser 98073	400mL	Heavy-duty applicator.	n/a	n/a	n/a
Pneumatic Dispenser 87979	400mL	Applicator for high volume jobs.	n/a	n/a	n/a
Mix Tip — Higher Throughput 97331	400mL	General use tip.	n/a	n/a	n/a
Mix Tip — Longer Reach 87982	400mL	Alternative nozzle with longer reach.	n/a	n/a	n/a
Mixing Nozzle (threaded) 53382	8.4 fl. oz.	Mixes Concrete Repair 600.	n/a	n/a	n/a

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ PUR Adhesive Systems

Production Power of Dual Technologies in One Self-Contained System

With the hand-held 3M™ Scotch-Weld™ PUR Adhesive System, you have the practical benefits of two technologies in your assembly operation. This single component system combines structural adhesive benefits and hot melt adhesive speed for wood, plastic and more.

1. Performance benefits typical of structural adhesive technology

- **Greater than 1,000 lbs. holding strength**, exceeding strength of conventional hot melt and PVA adhesives
- **Save finishing steps** with the elimination of nails and other mechanical fasteners in many applications

2. Production benefits typical of hot melt adhesive technology

- **Fast set** and handling strength in as few as 15 seconds helps minimize or eliminate fixturing to speed assembly
- **Low VOCs** and 100% solids eliminate drying and ventilation equipment, and will not attack plastics
- **Choice of open times** and viscosities
- **One-component and moisture-curing** eliminates metering, mixing and curing time and equipment

Thin, flexible bond line to improve fit, appearance and durability



Two pieces of oak are edge spliced with the 3M™ Scotch-Weld™ PUR Adhesive System.

109



After staining, the bond line is hard to find. Look inside the circle.

110



The wood fails before the bond line in this test and many other applications.

111



105

Choice of viscosities and open time to match application requirements for bonding wood to wood as well as wood to other substrates.



38

Bond wood or plastic trim to wood cabinet doors.



106

Bond plastic emblem to glass without fixturing.



107

Bond delicate trim pieces to wood and other materials.



108

Bond mirrors to wood with immediate handling strength to keep assembly moving.



112

Adhesive bead applies neatly to countertop edging to eliminate nails and the extra work of putty and sanding.



113

Adhesive bonds extruded aluminum bracket to the laminate covering of a honeycomb panel.

3M™ Scotch-Weld™ PUR Adhesive Systems



Typical Applications Where Strength and Fast Production Cycles are Required

Household and Office Furnishings

- Wood or plastic decorative trim and moldings for furniture and cabinets
- Edge moldings for countertops, tables, shelving and desks
- Wood or MDF drawer bottoms, backs and facings
- Fabric and leather in furniture upholstery and trim
- Modular office wall partitions

Windows and Doors

- Interior and exterior wood and metal household door assembly
- Bond and seal wood or plastic stiles and rails in shutters
- Wood muntin bars to window glass
- Rubber insulation to wood, plastic or metal

Other Examples

- Fiberglass to wood in marine interiors
- Metal to laminated honeycomb in trade show booths
- Plastic to plastic in point of purchase retail displays

System Components

- Electrically-heated pneumatic applicator dispenses adhesive at 250°F (121°C) with the squeeze of a trigger – Easy to use and maintain system with unique disposable nozzle design
- Adhesives with a range of properties including adhesion in difficult-to-bond jobs such as hardwood miter corners
- Optional pre-heater to keep cartridges ready to use



Bond extruded plastic edge molding to particle board core.



3M™ Scotch-Weld™ PUR Adhesives are suitable for bonding a variety of joint types and configurations, such as this mortise and tenon.



3M™ Scotch-Weld™ PUR Adhesives

Product	Description	Viscosity @ 250°F (121°C) [CPS]	Color	Open Time ¹ (min.)	Set Time ² (sec.)	Shore D	Tensile Strength (PSI)	Elongation (%)
EZ250015	Fast set time for wood and select plastics.	7,000	White/Off-White	1.5	15	65	3,900	750
EZ250030	Fast set time for many plastics including polystyrene and polyacrylic.	13,000	White/Off-White	2	30	50	3,900	725
EZ250060	Medium set time for wood and select plastics.	7,000	White/Off-White	2	60	60	4,200	675
EZ250120	Medium set time, low viscosity and very thin bond line for wood.	3,000	White/Off-White	4	120	60	4,000	625
EZ250150	Long open and set times for wood, plastics, and material combinations such as aluminum or glass to plastics or wood.	9,000	White/Off-White	4	150	45	3,300	700
EZ250200	Long open time and low viscosity for wood, plastics and many other material combinations.	2,750	White/Off-White	3	120	30	1,625	400

1 – The maximum time between the application of the adhesive and when the parts must be joined together. This information is based on 1/8-inch bead and non-metallic substrates at 75°F (20°C).

2 – Also known as fixturing/clamping time. The minimum amount of time required for the adhesive to solidify and hold the parts together (able to support a tensile load of 5 psi).

Shelf Life

For cartridge and 2K foil packs, 12 months is the maximum amount of time an end-user has to use the product while stored within the conditions recommended by 3M.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Scotch-Weld™ PUR Adhesive Systems

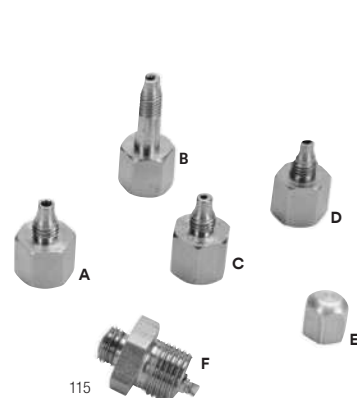


292

Product	Description	Viscosity @ 250°F (121°C) [CPS]	Color(s)	Open Time ¹ (min.)	Set Time ² (sec.)	Shore D	Tensile Strength (PSI)	Elongation (%)
TE015	Extrudable with very fast set time. Bond wood and selected plastics.	7,000	White/Off-White	1.5	15	65	3,950	750
TE030	Extrudable with fast set time. Bond wood and selected plastics.	16,000	White/Off-White	1	30	60	3,800	725
TE031	Extrudable with fast set time. Bond a wide variety of plastics, including polystyrene and polyacrylic.	13,000	White/Off-White, Black	2	30	50	3,900	725
TE040	Extrudable with fast set time. Low viscosity. Strong, flexible bonds. Bond plastics, wood, aluminum and glass.	7,000	White/Off-White, Black	2	40	35	2,750	860
TE100	Extrudable with medium set time. Bond wood and selected plastics. Thin bond lines.	7,000	White/Off-White, Black	2	60	61	4,200	675
TE200	Extrudable with fast set time. Low viscosity. Bond wood and selected plastics. Thin bond lines.	3,000	White/Off-White	4	125	60	4,000	625
TS230	Sprayable/extrudable with long set time. Bond variety of plastics, including polystyrene and polyacrylic. Bond aluminum and glass to plastic and wood.	9,000	White/Off-White, Black	4	150	45	3,300	700
TS115 HGS	Sprayable/extrudable/roll coatable with fast set time. Bond wood, FRP, other plastics to themselves, metal and glass.	16,000	White/Off-White	10	60	47	3,200	600

1 – The maximum time between the application of the adhesive and when the parts must be joined together. This information is based on 1/8-inch bead and non-metallic substrates at 75°F (20°C).

2 – Also known as fixturing/clamping time. The minimum amount of time required for the adhesive to solidify and hold the parts together (able to support a tensile load of 5 psi).



Application-Matched Tips*

- A) 0.090" tip for medium flow applications
- B) 0.072" extension tip for improved sight line in hard-to-reach areas
- C) 0.062" tip for low flow applications
- D) 0.125" tip for high flow application
- E) Threaded cap for sealing tip after use
- F) PUR Applicator Valve Assembly to be used with applicator tips and cap

*For use with optional main nozzle assembly system (UPC: 021200-89514)



Benchmount System

Foot pedal activation for hands-free operation of 3M™ Scotch-Weld™ PUR Easy 250 Applicator.



Container Sizes to Meet Your Production Volume

- 10 fl.oz. cartridges
- 2k foil packs
- 5 gallon pail
- 55 gallon drum

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Hot Melt Spray Adhesives



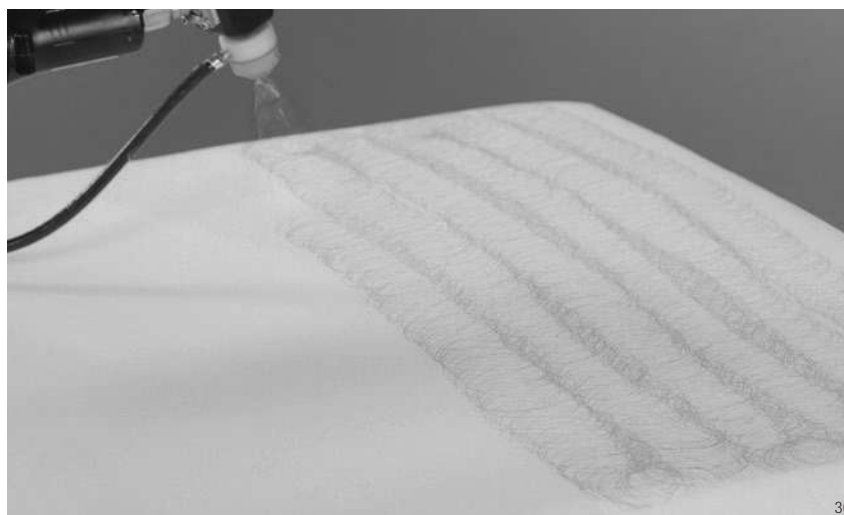
Immediate Bonding of Foam and Other Lightweight Materials

3M™ Hot Melt Spray Adhesive is a fast, effective alternative to solvent-based adhesives for bonding most foams, fabrics, plastics, wood and light-gauge metals. Applications range from furniture cushions to foam inserts, modular office panels to gym floor pads, and more. You simply spray a controlled pattern of 100% solids adhesive right where you want it. Apply to one or both surfaces and bond substrates immediately.

Other features include:

- Up to 10-minute open time for handling convenience and bonding larger areas
- Available in two colors to easily identify spray pattern*
- Bulk format adhesives for ease of use in most delivery systems

*See chart below.



Can bond multiple substrates, large surface areas with 1 or 2 surface applications.



In display cases for jewelry and other retail items, foam is bonded to foam and fabric. Low temperature spray will not damage heat-sensitive substrates.



In carrying case assembly, 3M™ Hot Melt Spray Adhesive bonds foam to foam, plywood, metal or plastic.

Adhesives Characteristics and Suggested Coverage

Product Characteristics	6111	6111 HT/6111 HT Blue	6116
Description	Standard Product	Higher Heat Resistance	Low Viscosity
Color	Tan	Tan/Blue	White
Open Time¹ One Surface (Foam/PVC)	1 min.	3 min.	2 min.
Open Time¹ Two Surface (Foam/Foam)	6 min.	8 min.	6 min.
Heat Resistance²	145°F (63°C)	175°F (79°C)	160°F (71°C)
Peel Adhesion³ (PIW)			
Fir	34.4	25.6	21.4
ABS	12.1	16.5	20.3
Polypropylene	46.3	14.4	16.4
PVC	9.9	16.3	n/a
Cold Rolled Steel	16.5	29.9	20.4
High Density Polyethylene	8.2	2.3	n/a
Typical Coverage	Smooth Surface	Textured Surface	
Two Surface Applications	1–2 grams per square foot	2–3 grams per square foot	
One Surface Application	3–5 grams per square foot	5–7 grams per square foot	

1 – Bonds were made by spraying adhesive onto 3/4 in. thick, 2 lb. density polyester urethane foam. Open time will vary depending on substrate.

2 – Tested per 3M IATD test method C-3093 using 2 lb. dead load.

3 – According to 3M IATD test method C-3012, 180° peel strength was determined at a cross head speed of 2 inches/minute at 73°F (23°C).

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Hot Melt Adhesives and Applicators

The 3M Systems Approach to Help You Improve Productivity and Lower Costs

3M™ Hot Melt Adhesives and Applicators are advanced hand-held systems to help you improve productivity, lower cost and minimize waste.

Adhesives are 100% solids thermoplastic resins that become fluid when heated and quickly wet the bonding surface. They cool, harden and reach bond strength in seconds. You can move assemblies immediately to keep production flowing. This helps eliminate clamps, fixturing and drying, and saves time, energy and space.

Each adhesive is designed and precisely manufactured for efficient use in one of the portable 3M™ Hot Melt Applicators. Bonds wood, plastic, foam, fabric, cardboard and more.



120

3M™ Hot Melt Applicator LT with 3M™ Hot Melt Adhesive 3762LM low temperature (265°F/129°C) adhesive effectively bonds heat-sensitive substrates such as styrene foam to itself, corrugated or other surfaces without damaging the foam.



121

For bonding the guide to a drawer bottom, 3M™ Hot Melt Adhesive 3792 provides high delivery rate and long bonding range.



122

For sample and display boards, attach wood flooring, laminates, foams, fabrics or other materials and small products with 3M™ Hot Melt Adhesive 3792.



123

For economical package sealing, 3M™ Hot Melt Adhesive 3762 is a versatile formulation with a bonding range for production speed. Variety of tips for package types.



124

To help with sound dampening on drawer bottoms, use 3M™ Hot Melt Adhesive 3792.



125

3M™ Hot Melt Applicator LT and 3M™ Hot Melt Adhesive 3792LM applied at low temperature (265°F/129°C) make quick work of welting, gimping, and bonding fabric to wood.



126

For versatility in P.O.P. assembly, 3M™ Hot Melt Adhesive 3792 bonds a variety of plastics, woods and light gauge metals.

Selecting a 3M™ Hot-Melt Applicator to Fit Your Needs



3M™ Hot Melt Applicator LT. Low-medium volume using low melt adhesive.
UPC# 021200-82245



3M™ Hot Melt Applicator LT with Quadrack™ Converter. Medium volume using low melt adhesive.
UPC# 021200-89447



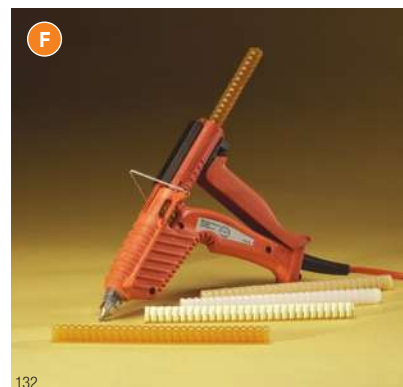
3M™ Pneumatic Hot Melt Applicator PG II LT with Speedloader. High volume using low melt adhesive.
UPC# 021200-89395



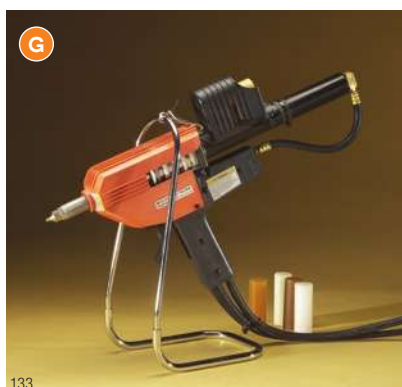
3M™ Hot Melt Applicator AE II LT. Low volume using low melt adhesive.
UPC# 051115-25567



3M™ Hot Melt Applicator TC. Low-medium volume.
UPC# 021200-82244



3M™ Hot Melt Applicator TC with Quadrack™ Converter. Medium volume.
UPC# 021200-89445



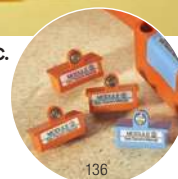
3M™ Pneumatic Hot Melt Applicator PG II with Speedloader. High volume.
UPC# 021200-22033



3M™ Hot Melt Applicator AE II. Low volume.
UPC# 021200-96594



3M™ Hot Melt Applicator EC. Medium volume; variable temperature control.
UPC# 021200-89519



3M™ Hot Melt Applicators

Product	Weight ¹	Output ² (lb/hr)	Temperature ³ °F (°C)	Power (120V)	Adhesive Dia. x L (in.)	Features	Warranty (Months)
Low Melt Applicators							
A LT	10.0 oz.	2.6	265 (129)	150W	5/8 × 2 TC	For use with low melt adhesives.	12
B LT with Quadrack Converter	13.8 oz.	2.6	265 (129)	150W	5/8 × 8 Q	For use with low melt adhesives.	12
C Pneumatic PG II LT with Speedloader	4.3 lbs.	6.0	265 (129)	500W	1 × 3 PG	Pneumatic high output for low melt adhesives.	12
D AE II LT	20.0 oz.	4.0	265 (129)	100W	1/2 × 12 AE	All electric operation for low melt adhesives.	6
Hot Melt Applicators							
E TC	10.0 oz.	3.5	385 (196)	150W	5/8 × 2 TC	Easy to use with standard melt adhesives.	12
F TC with Quadrack Converter	13.8 oz.	3.5	385 (196)	150W	5/8 × 8 Q	Easy to use with standard melt adhesives.	12
G Pneumatic PG II with Speedloader	4.3 lbs.	7.5	385 (196)	500W	1 × 3 PG	Pneumatic high output for standard melt adhesives.	12
H AE II	20.0 oz.	4.0	400 (204)	100W	1/2 × 10 AE 1/2 × 12 AE	All electric operation for standard melt adhesives.	6
Variable Applicators							
I EC	24.0 oz.	5.5	260–450 (127–232)	350W	5/8 × 8 Q	Temperature modules to operate with standard and low melt adhesives.	12

1 – Weight shown is for applicator only; does not include adhesive capacity.

2 – Adhesive output will vary with conditions and the adhesive used. Values are approximate and are based on maximum steady-state flow.

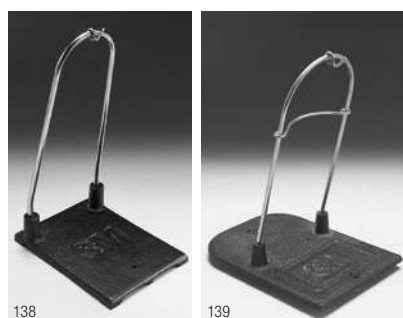
3 – Temperatures shown are nominal control values. Actual temperature will range slightly above and below this value.

Accessories to Improve Your Productivity

Product	Description	UPC	SN
9725	.072" Mini Extension Tip	021200-21786	62-9725-9930-2
9726	"T" Tip Assembly	021200-64542	62-9726-9930-0
9727	"L" Tip with Adapter	021200-64543	62-9727-9930-8
9785	.07" Tapered Aluminum Extension (all applicators)	021200-82554	62-9785-9930-6
9913	2-hole Spreader	021200-21830	62-9913-9930-4
9916	3-hole Spreader	021200-21836	62-9916-9930-7
9917	3-hole 1" Spreader	021200-21837	62-9917-9930-5
9921	.090" Fluted Tip	021200-21840	62-9921-0066-9
9922	.063" Fluted Tip	021200-21841	62-9922-0066-7
9929	High Viscosity Valve (TC, EC, PG II)	021200-64840	62-9929-9930-4
9940	.125" Fluted Tip	021200-22036	62-9940-6920-1
9946	.072" Brass Extension (PG II, PG II LT)	021200-22040	62-9946-6980-2
Heavy-Duty Benchstand	For use with PG II and PG II LT	021200-22039	62-9945-9930-6
	For use with EC, TC and LT	021200-82418	62-9945-9935-5
Bench Mount	Includes bench nozzle assembly (Does not include applicator)	021200-82277	62-9276-9930-6
Bench Nozzle Assembly	For use with bench mounted applicator	021200-21713	62-9233-2781-1
Foot Pedal Assembly	For use with bench mounted applicator	021200-82278	62-9277-9930-4
TC and LT Palm Trigger	For use with Quadrack converter	021200-82701	62-9761-9930-7
Quadrack Converter	To add Quadrack capability to TC and LT applicators	021200-83536	62-9275-9935-7
Valve Assembly Kit	Nozzle and valve replacement for TC, EC, LT	021200-21714	62-9234-9930-5



A general purpose tip (.090) is supplied with each 3M™ Hot Melt Applicator. To increase productivity, optional tips can provide multiple beads, flat ribbons, guided beads for carton sealing and extended reach.



Heavy-Duty Benchstands provide added convenience.



Foot pedal, magazine feeder and benchmount accessories can provide high capacity, hands-free operation for 3M™ Hot Melt PG II and PG II LT Applicators.



Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Hot Melt Adhesives



Product	Color	FDA Listed ¹	UL 94 Listing	Features/Application Ideas
Low Melt Technology: Applied 250–270°F (121–132°C)				
3750LM	Tan	—	n/a	Excellent “hot tack”, fast setting for corrugated, beadboard, repack, recoup. Economical, general purpose. Use with AE II LT applicator only.
3762LM*	Light Amber	Yes	n/a	Excellent “hot tack”, fast setting for corrugated, beadboard, recouperage, repacking chipboard and wood. Economical, general purpose. Use with low melt applicator only.
3776LM	Tan	—	n/a	Bonds variety of plastics, woods and light-gauge metals. Use with low melt applicator only.
3792LM*	Clear	Yes	V2	Clear, multi-purpose for wood, coated paper, polyolefins and other heat-sensitive materials. P.O.P. displays. Use with low melt applicator only.
3798LM*	Light Yellow	Yes	n/a	Removable “gummy glue” for many substrates. Removes easily without residual tack. Use with low melt applicator only.
Hot Melt Technology: Applied 350–385°F (177–196°C)				
3731*	Tan	—	n/a	High heat resistance. Bonds plastics including polyethylene, polypropylene.
3738*	Tan	Yes	V2	High delivery rate and long bonding range. General purpose for foundry sand cores, wood bonding, corrugated, selected plastics and chipboard.
3747	Tan	Yes	n/a	General purpose for wide variety of plastics, wood and lightweight metals.
3748*	Off-White	Yes	V2	Good thermal shock resistance. Non-corrosive to copper for many electronic applications. Bonds polyolefins.
3748 VO	Light Yellow	—	VO	Self-extinguishing version of 3748. Meets UL 1410 requirements.
3750	Tan	—	n/a	Low viscosity for high flow rate, increased production. Good hot tack, quick grab for packaging and woodworking.
3750	Clear	—	n/a	Low viscosity for high flow rate, increased production. Good hot tack, quick grab for packaging and woodworking.
3762	Tan	Yes	V2	Excellent “hot tack”, fast setting for corrugated, beadboard, recouperage, repacking chipboard and wood. Economical, general purpose.
3764*	Clear	Yes	V2	Bonds variety of plastics including polycarbonate, polyethylene, and polypropylene. Flexible at low temperatures.
3779*	Amber	Yes	n/a	High heat resistance. High strength. Good fuel and oil resistance. Electronics.
3789*	Brown	Yes	V2	High performance for plastics. Impact resistant. Bonds vinyl and wood. Good fuel and oil resistance.
3792*	Clear	Yes	V2	Clear, multi-purpose for wood, corrugated, fabric, furniture, upholstery, novelties, and other lightweight materials.
3797	Off-White	Yes	V2	High ball and ring. Low viscosity. Good for electrical potting.
Bulk Only				
3794 Hi Tack PSA	Light Tan	Yes	n/a	Sprayable high tack PSA for bonding plastic, paper, metals, die-cut labels.
6111	Tan	—	n/a	Sprayable 100% solventless adhesive for most foams, fabrics, plastics, particle board and thin metal.
6111HT	Tan, Blue	—	n/a	Similar to 6111 but has higher heat resistance. Available in tan and blue.
6116	Off-White	—	n/a	Similar to 6111 but lower than normal viscosity and mainly used on fabrics.

*Also available in bulk.

1 – Made from components listed as indirect food additives under FDA regulations for adhesives (21 CFR 175.105)

2 – Brookfield Thermosel Viscometer in Centipoise

3 – ASTM E-28-6-7

4 – Highest temperature that the adhesive will support a 2 psi dead load

5 – Canvas to Douglas Fir

6 – Douglas Fir to Douglas Fir

7 – 1/8" semicircular bead, Douglas Fir to Douglas Fir

	Sizes	EC Temp Control Modules	Viscosity CPS ²	Delivery Time for 1" x 3" Cartridge (sec.)	Ball & Ring Melt Point ³ °F (°C)	Heat Resistance ⁴ °F (°C)	Peel Strength PIW ⁵ 72°F (22°C)	Shear Strength PSI ⁶ 72°F (22°C)	Open Time 1/8" Bead ⁷ (sec.)
	1/2" x 12" AE	n/a	4,000 @ 250°F	45	200 (95)	128 (54)	6	475	25
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC 1/2" x 12"	1	4,000 @ 250°F	45	205 (96)	130 (54)	6	480	25
	5/8" x 8" Q 1" x 3" PG 1/2" x 12"	1	8,250 @ 250°F	47	184 (84)	140 (60)	9	600	40
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC 1/2" x 12"	1	10,500 @ 250°F	57	178 (81)	140 (60)	13	350	40
	5/8" x 2" TC	n/a	9,500 @ 250°F	n/a	191 (88)	120 (49)	n/a	n/a	30
	5/8" x 8" Q 1" x 3" PG	5	12,000 @ 375°F	n/a	315 (157)	265 (130)	22	490	30
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC 1/2" x 12" AE	4	2,875 @ 375°F	35	186 (86)	130 (54)	13	375	50
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC 1/2" x 12" AE	4	4,100 @ 375°F	45	220 (104)	145 (63)	20	430	45
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC	4	5,000 @ 375°F	65	292 (144)	175 (79)	18	250	45
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC	4	5,000 @ 375°F	65	305 (152)	175 (79)	15	275	30
	1/2" x 12" AE	n/a	1,900 @ 375°F	30-40	200 (93)	125 (52)	6	500	n/a
	1/2" x 10" AE	n/a	4,800 @ 375°F	35-45	178 (81)	135 (57)	12	250	n/a
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC 1/2" x 12" AE	3	1,870 @ 375°F	30	201 (94)	130 (54)	7	545	35
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC 1/2" x 12" AE	4	6,000 @ 375°F	55	190 (88)	140 (60)	14	390	40
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC	5	7,000 @ 375°F	75	325 (163)	300 (149)	18	700	25
	5/8" x 8" Q 1" x 3" PG	5	5,200 @ 375°F	70	270 (132)	220 (104)	16	570	50
	5/8" x 8" Q 1" x 3" PG 5/8" x 2" TC 1/2" x 12" AE	4	5,000 @ 375°F	45	179 (81)	140 (60)	13	250	50
	1" x 3" PG 5/8" x 2" TC	n/a	2,650 @ 375°F	55	304 (151)	170 (77)	10	350	30
	Bulk pillows	n/a	15,000 @ 325°F	n/a	224 (107)	120 (49)	16	n/a	> 60
	.75" x.75" chips	n/a	3,000–5,000 @ 375°F	n/a	224 (107)	145 (63)	34	n/a	1 surface: 60 2 surface: 360
	.75" x.75" chips	n/a	2,500–4,500 @ 375°F	n/a	284 (140)	175 (79)	26	n/a	1 surface: 180 2 surface: 480
	.75" x.75" chips	n/a	1,300 @ 375°F	n/a	199 (93)	160 (69)	20	n/a	1 surface: 120 2 surface: 300

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

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.



146

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

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



148

149

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.



145

Cylinders

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



147

Aerosols

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



150

Bulk

- Cost effective
- Integrate into existing equipment

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

Solvent Based Adhesives

Product	Requirement	Size Availability
70	FAST TACKING	 
77	Low soak in, mist spray	 
74NF	Non-flammable	

Water Based Adhesives

Product	Requirement	Size Availability
1000NF	ONE-SIDED BONDING	
49	Long open time, long tack time	
100NF	Immediate bonding	



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.



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.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.










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 of applications.

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

Solvent Based Adhesives			
	Product	Requirement	Size Availability
Lead Product	74	SOFT BOND LINES	  
	92	High temperature resistance	 
	74NF	Non-flammable	
	77	Low soak in, mist spray	  

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

	Aerosol		Cylinder		Bulk
---	---------	---	----------	---	------



155

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.”



156

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.



157

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.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

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.




Solvent Based Adhesives

Lead Product

Product	Requirement	Size Availability
94 CA	FAST TACKING, POSTFORMABLE	 
90	High strength	  
94 ET	Longer open time, more aggressive tack	  
98 NF	Non-flammable	 
5	Very high temperature resistance	
1099	Plasticizer resistance, harsh environments	

Water Based Adhesives

Lead Product

Product	Requirement	Size Availability
30NF	HIGH STRENGTH	
2000NF	Faster initial strength	
1000NF	One surface bonding, fast assembly, plasticizer resistance	

 Aerosol  Cylinder  Bulk



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.



Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

High Performance Specialty Adhesives — Solvent and Water Based



Rubber and Plastic

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.

Rubber and Gasket Adhesives			
	Product	Requirement	Size Availability
Lead Product	1300	NEOPRENE OR SBR BONDING	
	1300L	Sprayable, low viscosity	
	847	Vinyl bonding, plasticizer resistant	
	4799	EPDM bonding	
	80	Aerosol	

Plastic Adhesives			
	Product	Requirement	Size Availability
Lead Product	1099	RESISTS WATER, OIL AND PLASTICIZER	
	1099L	Sprayable, low viscosity	
	4693	Polyolefin bonding	
	2262	Clear drying	
	90	Aerosol	



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



Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Cleaners and Lubricants

Convenience and a Fistful of Work Power for Maintenance and Production

In thousands of factories and plants, these aerosol 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 aerosol chemicals contain no methylene chloride, chlorofluorocarbons (CFCs) or 1,1,1-trichloroethane (methyl chloroform).



163



3M™ Silicone Spray Low VOC 60% 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™ Citrus Base Cleaner helps soften and loosen grease, oil and grime. After using this heavy-duty degreaser/cleaner, just wipe away with a shop towel.



Freeing rusted nuts, bolts and frozen threaded parts are only a few of the many applications for 3M™ 5-Way Penetrant.

3M™ Aerosol Chemicals

Product	Key Characteristics	Available Format	Color	Application Method	Spray Pattern	VOC Content
Adhesive Remover	Citrus based. Fast acting. No residue left behind.	1 gallon, 5 gallon, 52 gallon	Pale Yellow	Brush/Roll/Spray	Mist	840g/L
		5 oz. Aerosol	Pale Yellow	Spray	Mist	100%
		18.5 oz. Aerosol	Pale Yellow	Spray	Mist	100%
		Mini Cylinder	Pale Yellow	Spray	Mist	800g/L
Adhesive Remover — Low VOC <20% Clear	Extended dwell time. No residual film. Meets CARB/OTC VOC Requirements. Helps contribute to LEED® credits.	Aerosol	Clear	Spray	Mist	15%
Citrus Base Cleaner	Citrus based. Non-corrosive. Cleans oil, grease, tar and grime.	Aerosol	Transparent	Spray	Mist	91%
Silicone Spray 60% VOC	Excellent lubricant. Fast drying. Long lasting and non-staining.	Aerosol	Clear	Spray	Mist	60%
5-Way Penetrant	Drives out moisture. Frees rusted bolts. Inhibits rust — lubricates, demoteurizes, inhibits corrosion, cleans and penetrates.	Aerosol	Amber	Spray	Mist	30%
Silicone Lubricant	Excellent lubricant. Fast Drying. Long-lasting and non-staining.	Aerosol	Clear	Spray	Mist	95%

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Cylinder Spray Adhesives

Efficient, Portable and Easy to Use

3M Cylinder Spray Adhesives have benefits over more traditional spray methods. Minimal startup costs, reduced downtime, simple hose and applicator setup make cylinders an obvious choice.

Whether your priorities are improving speed of application, making spraying easier or reducing capital equipment maintenance and other costs, 3M Cylinder Spray Adhesives get you there.

Advantages and benefits:

- Very efficient speed of application and reduction of overspray
- Convenient, portable and easy to use delivery system
- Maintenance free and very low equipment costs

Other benefits include:

- More efficient spraying over large surface areas or multiple parts means virtually all adhesive is used and very little is wasted
- Easy to learn, use and train new employees to spray
- Portable for easy transition and setup for multiple stations or field work

Key features include:

- High coverage
- Various spray patterns
- Non-flammable adhesives
- GREENGUARD™ Certified
- Range of open time (worklife)



Spray patterns from 1–18+ inches are achievable using 3M™ Cylinder Spray Adhesives and various spray tips.

Where to Start

Product Selection

The lead products for 3M™ Cylinder Adhesives are:

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

The majority of applications can be done with these three 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. 3M™ Hi-Strength 94 ET Cylinder Spray Adhesive offers all the benefits of 3M™ Postforming 94 CA Cylinder Spray Adhesive, but delivers a higher tack and increased bonding range.



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

Save Yourself the Hassle of Inefficient Spraying

Most common applications:

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

Where to find these applications:

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



171 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.



172 Consistent spray patterns and portable cylinders mean you can realize big improvements in efficiency and save time and labor costs.

3M™ Cylinder Spray Adhesive Quick Reference Guide

Product	Application	Solids (%)	Solids — Bulk (%)	VOCs (g/L)	Open Time (min)	Spray Pattern	Spray Applicator	Recommended Tips
General Purpose								
60 CA	General Purpose	43	42	>80	2–60	Web	Applicator	9501, 6501
Specialty								
70	Construction, Marine, RV, Polystyrene	21	41	544	1–60	Web	Applicator	QSS tip
74	Foam Bonding	22	36	563	1–15	Web	Applicator	9501, 6501
74NF	Foam Bonding	22	28	248	1–60	Web	Applicator	9501, 6501
77	Multi-Purpose	27	36	534	1–30	Mist	Applicator	250050, 650050
78 ET	Polystyrene	17	31	570	1–60	Web	Applicator	9501, 6501
High Performance, High Temperature Laminating								
90	Laminating	13	23	571	1–15	Web	Applicator	9501, 6501, 250050
92	Laminating	23	34	654	1–20	Web	Applicator	9501, 6501, 250050
94 CA	Laminating	28	28	79	1–15	Pebble	Applicator H	4001, 6501
94 ET	Laminating	28	34	<80	1–60	Pebble	Applicator H	9501, 6501, 4001
98NF	Laminating	20	25	254	1–60	Web	Applicator	9501, 6501, 4001

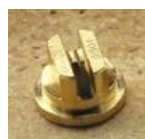
Key Questions

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

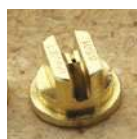
Use A.S.P.E.C.

- What is the **APPLICATION** you are currently using the adhesive for?
- What **SUBSTRATES** does the adhesive need to bond too?
- 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).
- How do you determine the **VALUE** beyond simply the **COST** of a product? (e.g. Improved coverage, reduced flammability or speed of application).

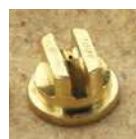
3M™ Cylinder Spray Adhesive Equipment and Accessories



9501



6501



4001



QSS



T-Fitting



Hose Swivel

Spray Tip	Angle	Spray Pattern Width
9501	95°	Wide
6501	65°	Medium
4001	40°	Narrow
QSS*	—	Very Wide
250050	25°	Very Narrow
650050	65°	Medium

*For 3M™ HoldFast 70 Spray Adhesive

173

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

Solvent and Water Based Adhesives



Product	Available Format	Solids Weight Percent (Approx.)	Key Characteristics
Solvent Based Adhesives			
Neoprene Contact 5	5 gallon, 53 gallon	19%	High performance contact adhesive. Sprayable. Fast drying.
Neoprene Contact 10	1 qt, 1 gallon, 5 gallon, 54 gallon	23%	Brushable and rollable with higher coverage. Meets requirements of MMM-A-121, MMM-A-130B and A-A-1936A.
Heavy Duty 20	Aerosol	17%	Fast grab. Variable width spray pattern. Forms strong bonds to a variety of substrates.
Foam & Fabric 24	Aerosol	17%	Aggressive tack. Foam-tearing strength. Variable width lace spray pattern.
Multi-Purpose 27	Aerosol	21%	Fast tack. Lightweight applications. Mist spray pattern.
General Purpose 60 CA	5 gallon, 54 gallon	43%	High solids for increased coverage. High tack general purpose adhesive.
	Large, Int and Jumbo Cylinder	42%	
HoldFast 70	5 gallon, 52 gallon	26%	Extremely versatile and very fast tacking. Unique wide web spray pattern with heavy body and low soak-in. Bonds polystyrene without degrading surface.
	Large, Int and Jumbo Cylinder	21%	
Pressure Sensitive 72	Aerosol	15%	Permanently tacky and repositionable. Long open time. Variable width lace spray pattern.
Foam Fast 74	Aerosol	22%	Extremely fast tack. Soft non-dimpling glue line. Immediate foam tearing strength.
	52 gallon	36%	
	Large, Int and Jumbo Cylinder	22%	
Foam Fast 74 CA (Low VOC)	Aerosol	23%	Extremely fast tack. Soft non-dimpling glue line. Immediate foam tearing strength.
Repositionable 75	Aerosol	9%	Adheres in seconds. Extra long tack range. Repositionable.
Hi-Tack 76	Aerosol	13.5%	Fast tacking. One surface bonds. Variable width lace spray pattern.
Super 77™	Aerosol	25%	Low soak-in for long lasting bond. High coverage and aggressive tack. Bonds quickly in 15 seconds.
	5 gallon, 52 gallon	36%	
	Large Cylinder	27%	
Super 77™ CA Multi-Purpose (Low VOC)	Aerosol	19%	Aggressive tack. Quick bonding. Long bonding range.
Polystyrene 78	5 gallon	19%	Bonds polystyrene with no surface degradation. Fast grabbing and fast drying. Uniform spray pattern for fast and easy application.
	Aerosol		
Polystyrene 78ET	Large, Int and Jumbo Cylinder	17%	Bonds polystyrene with no surface degradation. Extended tack time for long working time. Uniform spray pattern for fast and easy application.
Hi-Temp Polystyrene 78HT	5 gallon, 54 gallon	27%	Bonds polystyrene with no surface degradation. High temperature resistance. Can be used for roofing membrane attachment.
	Large, Int and Jumbo Cylinder	15%	
Rubber And Vinyl 80	Aerosol	13%	High strength. High temperature resistance. Fast setting.
Hi-Strength 90	5 gallon, 52 gallon	23%	High strength. High temperature resistance.
	Large, Int and Jumbo Cylinder	13%	
	Aerosol	13%	
Hi-Strength 90 CA (Low VOC)	Aerosol	23%	High strength.
Hi-Strength 92	5 gallon, 54 gallon	34%	High strength. High temperature resistance. Versatile, high-tack adhesive.
	Large, Int and Jumbo Cylinder	23%	
Hi-Strength 94 ET (Low VOC)	5 gallon, 54 gallon	25%	Bonds many laminates, woods, and particle board. Long open time, low VOC. SCAQMD Rule 1168 compliance; helps contribute to LEED® Credits.
	Large, Int and Jumbo Cylinder	25%	
	Aerosol	21%	Meets CARB / OTC VOC Requirements; helps contribute to LEED® Credits.
Hi-Strength Postforming 94 CA (Low VOC)	5 gallon, 54 gallon	34%	High solids for increased coverage. Unique non-telegraphing spray pattern with postformable strength. Low VOC, SCAQMD 1168 and LEED® Compliant.
	Large, Int and Jumbo Cylinder	28%	
826 Plastic Adhesive	1 qt., 5 gallon	23%	Fast drying for many plastic films. Resists fuels, water and oil. Thin liquid.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

	Adhesive Strength	Color	Application Method	Bonding Range (Two Surfaces)	Flammability	Heat Resistance (SAFT)	Spray Pattern	VOC Content
	High	Light Yellow	Spray	10–60 min.	Flammable	300°F	Web	687g/L
	High	Light Yellow	Brush/Roll	10–60 min.	Flammable	300°F	Web	589g/L
	High	Clear	Spray	1–30 min.	Flammable	210°F	Web	52%
	Medium	Orange	Spray	30 sec.–30 min.	Flammable	170°F	Web	53%
	Low	Clear	Spray	15 sec.–10 min.	Flammable	140°F	Mist	59%
	Medium	Clear	Brush/Roll/Spray	1–60 min.	Flammable	170°F	Pebble	79g/L 73g/L
	Medium	Clear	Brush/Roll/Spray	1–60 min.	Flammable	190°F	Web	562g/L
	Medium	Blue	Spray	1 min.–8 hr.	Flammable	170°F	Web	55%
	Medium	Clear/Orange	Spray	30 sec.–15 min.	Flammable	170°F	Web	<55%
			Brush/Roll/Spray					352g/L
								563g/L
	Medium	Clear/Orange	Spray	30 sec.–15 min.	Flammable	200°F	Web	<25%
	Low	Clear	Spray	5 sec.–60 min.	Flammable	110°F	Mist	58%
	High	Clear	Spray	1–60 min.	Flammable	230°F	Web	55%
	Low	Clear	Spray	15 sec.–15 min.	Flammable	150°F	Mist	54%
			Brush/Roll/Spray					504g/L
			Spray					535g/L
	Low	Clear	Spray	15 sec.–30 min.	Flammable	205°F	Mist	<25%
	Medium	Clear	Spray	1–15 min.	Flammable	190°F	Web	566g/L 62%
	Medium	Clear/Green	Spray	1–60 min.	Flammable	200°F	Web	622g/L
	Medium	Blue	Spray	1–60 min.	Flammable	230+°F	Web	611g/L
	High	Yellow	Spray	3–30 min.	Flammable	300+°F	Web	54%
	High	Clear	Brush/Roll/Spray	1–10 min.	Flammable	250°F	Web	356g/L
			Spray					586g/L
			Spray					54%
	High	Clear	Spray	1–30 min.	Flammable	200°F	Web	<25%
	High	Clear/Red	Spray	1–20 min.	Flammable	250+°F	Web	577g/L
	High	Clear/Red	Spray	1–60 min.	Flammable	210°F	Pebble	<80g/L
		Clear/Red	Brush/Roll/Spray					<80g/L
		Clear	Spray					<20
	High	Clear/Red	Brush/Roll/Spray	1–15 min.	Flammable	210°F	Pebble	79g/L
			Spray					79g/L
	Medium	Amber	Brush/Spray	Up to 45 min.	Flammable	—	Web	731g/L

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

Solvent and Water Based Adhesives



Product	Available Format	Solids Weight Percent (Approx.)	Key Characteristics
Solvent Based Adhesives			
847 High Performance Rubber & Gasket Adhesive	5 oz, 1 qt, 1 gallon, 5 gallon, 54 gallon	36%	Quick drying and flexible with fuel and oil resistance. Able to reactivate with heat and solvent. Curable with heat.
847H High Performance Rubber & Gasket Adhesive	5 gallon	51%	High viscosity. Able to reactivate with heat and solvent. Curable with heat.
1099 High Performance Plastic Adhesive	5 oz, 1 qt, 1 gallon, 5 gallon, 54 gallon	34%	Fast drying and heat curable. Resists weathering, water, oil, plasticizer migration and aliphatic fuels.
1099L High Performance Plastic Adhesive	5 gallon, 54 gallon	24%	Sprayable version of 1099H. Fast drying and heat curable. Resists weathering, water, oil, plasticizer migration and aliphatic fuels.
1300 High Performance Rubber & Gasket Adhesive	5 oz, 1 pt, 1 qt, 1 gallon, 5 gallon,	37%	High immediate strength. Fast-drying and heat resistant for rubber and metal. Meets MIL-M-81288 and MMM-A-121.
1300L High Performance Rubber & Gasket Adhesive	1 qt, 1 gallon, 5 gallon, 54 gallon	30%	Lower viscosity for spraying. Fast-drying and heat resistant for rubber and metal. Meets MMM-A-121.
1357 High Performance Contact Adhesive	5 oz, 1 pt, 1 qt, 1 gallon, 5 gallon, 54 gallon (Light Yellow only 5 gallon and 55 gallon)	25%	Rapid build up to a very high strength bond for metal. Resists heat and continuous load stress. Meets MMM-A-121 requirements.
1357L High Performance Contact Adhesive	5 gallon, 54 gallon	18%	Low viscosity. Resists heat and continuous load stress. Meets MMM-A-121 requirements.
2262 Plastic Adhesive	1 qt, 5 gallon	27%	Clear and non-staining. Resists plasticizer migration for bonding many flexible vinyls. Fast tack.
4475 Industrial Plastic Adhesive	5 oz, 1 qt, 5 gallon	43%	Clear plastic adhesive. Fast drying. Strong environmental resistance.
4491 Industrial Adhesive	5 gallon, 54 gallon	24%	Securely bonds vinyl with resistance to plasticizer migration. Versatile plastic adhesive. Excellent environmental resistance.
4550 Industrial Adhesive	5 gallon, 54 gallon	33%	Adding tack to large surfaces. Translucent. Long bonding range.
4693 High Performance Industrial Plastic Adhesive	5 oz, 1 qt, 1 gallon, 5 gallon, 54 gallon, (High viscosity only 5 oz)	26%	Excellent plastic adhesive. Long tack range. Water and heat resistant.
4799 Industrial Adhesive	5 oz, 1 qt, 1 gallon, 5 gallon	32%	Water and heat resistant. Dries rapidly. EPDM bonder.
Non-flammable Solvent Adhesives			
Foam Fast 74NF	Mini, Large, Int and Jumbo Cylinder	24%	Non-flammable. Fast tack with foam tearing strength. Soft non-dimpling bond line.
Hi-Strength 98NF	5 gallon, 54 gallon	24%	Non-flammable, fast tack adhesive. High temperature resistance.
	Mini, Large, Int and Jumbo Cylinder	21%	Versatile, high-tack adhesive.
Water Based Adhesives			
Fastbond™ Contact Adhesive 30NF	1 qt, 1 gallon, 5 gallon, 52 gallon, 270 gallon	49%	Non-flammable water-based contact adhesive. Extremely high strength, high temperature resistant. Meets MIL-A-24179A, Type I, GREENGUARD® Certified, SCAQMD 1168, LEED® Compliant.
Fastbond™ Contact Adhesive 30H	52 gallon, 270 gallon	48%	Long bonding range with high immediate bond strength. Economical high coverage. Low mist version of 30NF.
Fastbond™ Insulation Adhesive 49	5 gallon box, 5 gallon, 52 gallon, 100 gallon, 255 gallon	55%	Fast tacking, high performance, pressure sensitive adhesive for lightweight materials. Low VOC and GREENGUARD® Certified. UL MAGW2 component recognition.
Fastbond™ Foam Adhesive 100NF	1 gallon, 5 gallon, 52 gallon, 100 gallon, 255 gallon	47%	One-part, fast setting — foam and fabric adhesive. GREENGUARD® Certified. Can be activated for immediate bonding.
Fast Tack 1000NF	1 gallon, 5 gallon, 52 gallon, 255 tote	49%	One-part immediate handling strength. Low overspray and high coverage. Bonds a wide variety of substrates with high temperature resistance .
Fastbond™ 2000NF	5 gallon, 50 gallon, 270 gallon	49%	Water dispersed, activated adhesive. Immediate bonding and handling strength without forced drying. GREENGUARD® Certified.
Pressure Sensitive Adhesive 4224NF	5 gallon , 52 gallon	41%	Water-based, plasticizer resistant adhesive. Permanent pressure sensitive adhesive with an aggressive tack. Low VOC and GREENGUARD® Certified.
Fastbond™ Spray Activator 1	1 qt, 1 liter spray bottle, 5 gallon, 30 gallon	n/a	GREENGUARD® Certified. Low VOC and LEED® Compliant. UL MAGW2 component recognition.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

	Adhesive Strength	Color	Application Method	Bonding Range (Two Surfaces)	Flammability	Heat Resistance (SAFT)	Spray Pattern	VOC Content
	Medium	Brown	Brush/Flow	Up to 15 min.	Flammable	—	Brush	0g/L
	Medium	Brown	Brush/Flow	Up to 10 min.	Flammable	—	Brush	5g/L
	High	Light Tan	Brush/Flow	Up to 40 min.	Flammable	—	Brush/Flow	5g/L
	High	Light Tan	Brush/Spray	Up to 20 min.	Flammable	—	Brush/Flow	443g/L
	High	Yellow	Brush/Flow	Up to 12 min.	Flammable	300°F	Brush/Flow	667g/L
	High	Yellow	Brush/Spray	Up to 8 min.	Flammable	300°F	Brush/Spray	≤706g/L
	High	Gray-Green/ Light Yellow	Brush/Spray	10–30 min.	Flammable	300°F	Web	≤582g/L
	High	Gray-Green	Spray	10–30 min.	Flammable	300°F	Web	515g/L
	High	Clear	Brush/Flow	2–20 min.	Flammable	—	Brush/Flow	177g/L
	Medium	Clear	Brush/Flow	1–10 min.	Flammable	—	Brush/Flow	600g/L
	High	Light Tan	Brush/Roll/Spray	Up to 20 min.	Flammable	—	Web	190g/L
	Low	Clear	Brush/Roll/Spray	10–30 min.	Flammable	—	Web	516g/L
	Medium	Clear	Brush/Spray	10–60 min.	Flammable	—	Web	597g/L
	Medium	Black	Brush/Trowel	1–10 min.	Flammable	—	Brush/Trowel	628g/L
	Medium	Red/Clear	Spray	10–60 min.	Non-flammable	210°F	Web	48g/L
	High	Red/Clear	Spray	10–60 min.	Non-flammable	240°F	Web	935g/L 907g/L
	High	Neutral/Green	Brush/Roll/Spray	30 min.–4 hr.	Non-flammable	300°F	Mist	37g/L
	High	Green	Brush/Roll/Spray	30 min.–4 hr.	Non-flammable	300°F	Mist	37g/L
	Low	Clear	Brush/Roll/Spray	5 min.–8 hr.	Non-flammable	—	Mist	2g/L
	Medium	Neutral/Lavender	Spray	1–20 min.	Non-flammable	—	Mist	0g/L
	High	Neutral/Purple	Spray	1–10 min.	Non-flammable	300°F	Mist	0g/L
	High	Blue/Light Orange/ Neutral	Co-Spray	2 min.–2 hr.	Non-flammable	300°F	Mist	37g/L
	Medium	Blue/Clear	Brush/Roll/ Spray/Trowel	15 min.–8 hr.	Non-flammable	—	Mist	14g/L
	n/a	Clear	Spray	n/a	Non-flammable	—	Mist	0g/L

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

3M™ Adhesive Sealants



292

Flexible Bonding and Sealing Solutions for Avoiding the Elements

Keeping the elements — air, wind, water, dirt, sunlight, fuel, cold, heat — in or out is a design challenge for applications such as specialty vehicle windows, trailer seams, HVAC ductwork, wood doors, boat deck fittings and many more. With 3M™ Adhesive Sealants, you have a wide selection of solutions based on more than 50 years of development and innovation.



174



175

3M™ Polyurethane Sealant 560 moisture cures to a flexible seal/bond between exterior skins and metal framework and between wood flooring and metal framework. Tensile strength up to 580 psi is enough to replace mechanical fasteners in many situations.



177

3M™ Weatherban™ Sealant Tapes are butyl sealants available in a variety of widths and thicknesses. These are used for applications demanding high tack, aggressive adhesion, weather resistance and flexibility.



178

3M™ Marine Adhesive Sealant 5200 Fast Cure cures completely in only 48 hours to a strong flexible bond/seal. Applications include: assembly above or below the waterline such as, hull and stern joints, hull to deck seams, marine hardware and more.



5

3M™ Marine Adhesive Sealant 4000UV has superior UV resistance that is ideal for continuous exposure to sunlight. Applications include specialty vehicle roof seams and marine hardware assembly requiring superior aesthetics.



46

Seam sealing ductwork with 3M™ Polyurethane Sealant 540 will prevent air and dust intrusion. Its flexibility assists with vibration damping.



179

For gaps and seams inside of a specialty vehicle, 3M™ Polyurethane Sealant 540 stays flexible and secure at temperature extremes. This benefit allows for thermal expansion/contraction between dissimilar substrates.



180

3M™ Silane Modified Polymer Adhesive Sealant 740UV has superior UV resistance that is ideal for sealing seams and filling gaps for exterior applications.

Product	Description	Tensile Strength (psi)	Elongation (%)	Skin Time (min)	Hardness (Shore A)	Color (Dry)	Application Method	Typical Handling Strength	Cure Time (mm/24 hr.)	Service Temp. Range °F (°C)
3M™ Polyurethane Adhesive Sealants										
525	Excellent for concrete sealing. Very pliable/flexible.	400	>600	90–150	25	Gray	Bead	n/a	3	-22 to 176 (-30 to 80)
540	Polyurethane. Moisture cures rapidly to flexible seal for many plastics, metal, wood and more.	300	>600	60–90	40	White, Black, Gray	Bead	24 hr.*	3	-40 to 194 (-40 to 90)
550FC	Paintable multi-purpose adhesive sealant. Adheres to a variety of substrates.	450	>600	50–90	45	White, Black, Gray	Bead	24 hr.*	4	-40 to 194 (-40 to 90)
550FC + AC61	Accelerated 2-part technology. Cures quickly. Fast handling strength.	300	>250	8–15	45	White, Black, Gray	Bead	1 hr.*	<24hr. full cure	-40 to 194 (-40 to 90)
550FC + AC63	Properties similar to 550FC + AC61.	300	>250	15–25	45	White, Black, Gray	Bead	2 hr.*	<24hr. full cure	-40 to 194 (-40 to 90)
551	Properties similar to 550FC with longer open time.	450	>600	120–180	45	White	Bead	24 hr.*	4	-40 to 194 (-40 to 90)
560	Similar to 540 but with 580 psi tensile strength for sealing and bonding. May replace mechanical fasteners.	580	>300	50–60	55	White, Black, Gray	Bead	24 hr.*	4	-40 to 194 (-40 to 90)
590	Structural glass bonding. Crash tested (FMVSS 212). 3-hour drive-away time.	1450	>700	25–40	65	Black	Bead	3-hr. drive-away time (FMVSS 212)	3.5	-40 to 194 (-40 to 90)
5010	Moisture-curing polyurethane. Excellent wood bonder.	275	n/a	3–5	n/a	Cream	Bead	24 hr.*	24 hr. full cure	-22 to 212 (-30 to 100)
3M™ Silane Modified Polymer (SMP) Adhesive Sealants										
730	Excellent UV resistance. Clear formulation.	250	>300	25–30	30	Clear	Bead	n/a	3.5	-40 to 194 (-40 to 90)
740UV	Excellent cosmetic sealant. Excellent UV resistance. Low VOC.	145	>300	40–60	30	White, Black, Gray	Bead	24 hr.*	3.5	-40 to 194 (-40 to 90)
760UV	Excellent adhesion. Paintable when wet. Low VOC.	260	>100	10–30	55	White, Black, Gray	Bead	24 hr.*	3.5	-40 to 212 (-40 to 100)
3M™ Water-Based Sprayable Protective Sealant										
320	Easy application with spray equipment. Fast drying. UV, corrosion resistant.	420	250	60	n/a	White, Black, Gray, Dark Gray	Spray	n/a	n/a	-15 to 194 (-25 to 90)
3M™ Weatherban™ Sealants										
5354	High tack butyl adheres aggressively. Easy to compress tape, resists cold flow.	n/a	n/a	n/a	60	Black	Tape	n/a	n/a	n/a
PF5422	Thread reinforced butyl tape. Repositionable with virtually no cleanup. Weather resistant.	33	200	30	30	Black	Tape	n/a	n/a	n/a
PF5423	Non-reinforced thinner product similar to PF5422.	33	200	30	30	Black	Tape	n/a	n/a	n/a
3M™ Marine Adhesive Sealants										
5200	One part polyurethane. Excellent adhesion to wood, gelcoat, fiberglass. Bonds/seals above/below waterline. Long working time. Provides permanent bond.	700	>800	>48 hr.	68	White, Black, Tan, Mahogany	Bead	> 48 hr.*	<1	-40 to 190 (-40 to 88)
5200FC	One part polyurethane. High strength, non-shrinking, non-sagging bonds. Bonds/seals above/below waterline. Up to one hour open time. Provides permanent bond.	600	>900	60–120	60	White	Bead	48 hr.*	3	-40 to 190 (-40 to 88)
4200FC	One part polyurethane. Bonds/seals above/below waterline. Tack free in 1 hour.	300	>600	50–90	40	White, Black	Bead	24 hr.*	3	-40 to 194 (-40 to 90)
4000UV	Silane Modified Polymer (SMP) Adhesive Sealant. Bonds/seals above/below waterline. Superior UV resistance. Tack free in 22 minutes.	500	>700	15–30	40	White, Black	Bead	24 hr.*	3.5	-40 to 194 (-40 to 90)
3000UV	Silane Modified Polymer (SMP) Adhesive Sealant. Bonds/seals above/below waterline. Superior UV resistance. Tack free in 22 minutes.	145	>300	40–60	30	White, Black, Gray	Bead	24 hr.*	3.5	-40 to 194 (-40 to 90)
Marine Silicone	One part, 100% silicone. Excellent UV resistance. Both non-yellowing and mildew resistant.	220	>350	5–10	20	White, Clear	Bead	n/a	3	-40 to 190 (-40 to 88)

*Varies by application.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

Notes:

[illegible]