

3M Industrial Adhesives and Tapes

Questions to Ask for Product Selection

- 1 What materials do you want to bond?
- 2 Do you require a structural or non-structural bond?
- 3 Are you willing to prepare the surfaces?
- 4 What types of stresses will the bond be subjected to?
- 5 What types of environmental conditions will be involved?
- 6 Do you need repositioning time?
- 7 What is the preferred bonding range?
- 8 What application method is appropriate for your production requirements?
- 9 What is the present bonding or joining method?

Spray Adhesives

Multipurpose 	Heavy Duty 	Foam & Fabric 	Specialty 
3M™ Super 77™ Multipurpose Spray Adhesive <ul style="list-style-type: none"> High tack, high coverage and low soak-in formula Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more Bonds in 15 seconds 	3M™ Hi-Strength 90 Spray Adhesive <ul style="list-style-type: none"> High strength and fast-tack adhesive performance Bonds to concrete, wood, MDF, laminates and polyethylene High temperature and moisture resistance 	3M™ Foam Fast 74 Spray Adhesive <ul style="list-style-type: none"> Fast-tacking adhesive with soft, non-dimpling bond lines Immediate foam-tearing strength Ideal for bonding flexible urethane or latex foam to many substrates 	3M™ Polystyrene Insulation 78 Adhesive <ul style="list-style-type: none"> High solids adhesive formulated for expanded polystyrene and foam insulations Bonds without cavitating foams Fast grabbing, fast drying formula
UPC Aerosol (Clear) 000-21200-96474-9, 6 oz. 000-76308-86234-3, 13.44 oz. 000-21200-21210-9, 16.75 oz. Cylinder (Clear) 000-51115-25776-6, Large Bulk (Clear) 000-21200-43793-9, 5 Gallon Pail 000-21200-43813-4, Open Head Steel Drum	UPC Aerosol (Clear) 000-76308-86235-0, 12.23 oz. 000-21200-30023-3, 17.6 oz. 000-51111-07278-3, Inverted Cylinder (Clear) 000-21200-41554-8, Large 000-51115-25774-2, Intermediate 000-51115-25775-9, Jumbo Bulk (Clear) 000-21200-43797-7, 5 Gallon Pail 000-21200-43814-1, Open Head Steel Drum	UPC Aerosol (Clear) 000-51111-50045-9 Cylinder (Clear) 000-21200-49919-7, Large 000-51115-25741-4, Intermediate 000-51115-25742-1, Jumbo Aerosol (Orange) 000-21200-82242-1 Cylinder (Orange) 000-21200-49158-0, Large 000-51111-18853-8, Intermediate 000-51111-18854-5, Jumbo	UPC Aerosol (Clear) 000-21200-41593-7 000-51111-07279-0, Inverted Bulk (Clear) 000-48011-53438-1, 5 Gallon Pail
UPC Aerosol (Clear) 000-21200-49048-4	UPC Aerosol (Clear) 000-21200-85822-2	UPC Aerosol (Clear) 000-21200-76394-6	UPC Aerosol (Clear) 000-21200-21305-2

Maintenance & Cleaning

3M™ Adhesive Remover <ul style="list-style-type: none"> Removes adhesive without damaging the surface underneath 	3M™ Silicone Lubricant <ul style="list-style-type: none"> Reliable lubricant can be used in a wide variety of applications Fast drying to maintain productivity Long lasting and non-staining to keep work surfaces clean 	3M™ Industrial Cleaner <ul style="list-style-type: none"> Removes grease, oil, ink and most adhesives without the need to soak 	3M™ 5-Way Penetrant <ul style="list-style-type: none"> Helps free rusted and frozen bolts, nuts and more Displaces moisture and “dries out” electronics Light-duty lubricant works well with delicate precision instruments
UPC Aerosol 000-21200-49048-4	UPC Aerosol 000-21200-85822-2	UPC Aerosol 000-21200-76394-6	UPC Aerosol 000-21200-21305-2

Low VOC Spray Adhesives



Multipurpose 	Heavy Duty 	Foam & Fabric 	Maintenance & Cleaning 
3M™ Super 77™ CA Multipurpose Spray Adhesive – Low VOC <25%* <ul style="list-style-type: none"> Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more Low soak-in and long open time 	3M™ Hi-Strength 90 CA Spray Adhesive – Low VOC <25%* <ul style="list-style-type: none"> High strength and fast-tack adhesive performance Bonds to concrete, wood, MDF, laminates and polyethylene 	3M™ Foam Fast 74 CA Spray Adhesive – Low VOC <25%* <ul style="list-style-type: none"> Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more Soft, non-dimpling glue lines 	3M™ Adhesive Remover – Low VOC < 20% <ul style="list-style-type: none"> Removes grease, oil, ink and most adhesives without the need to soak or damaging the surface underneath Provides mold-release agents
UPC Aerosol (Clear) 000-51111-97956-3	UPC Aerosol (Clear) 000-51111-97957-0	UPC Aerosol (Clear) 000-51111-97967-9 Aerosol (Orange) 000-51111-97958-7	UPC Aerosol 000-51111-97974-7
			UPC Aerosol 000-51111-07732-0

*Meets CARB/OTC VOC requirements and helps contribute to LEED® credits. Review applicable VOC requirements to ensure local compliance.
 **All products listed are GREENGUARD Gold Certified.

MRO Sprayable Adhesive Tip Sheet (cont.)

Mist Spray vs. Web Spray
<p>Particle Spray</p> <ul style="list-style-type: none"> • Dispersions — suspended particles that can settle (shake/purge) • Translucent glue lines • Non-telegraphing texture, smooth • Fine, misty particle spray • Particle sprays are odd number products (77, 27, 75...)
<p>Lace Spray</p> <ul style="list-style-type: none"> • Solutions — no particles, no settling (shake/purge not needed) • Variable spray pattern • Less overspray • Lace, web spray pattern • Lace sprays are even number products (90, 74, 72...)

Common Reasons for Bond Failure
<ul style="list-style-type: none"> • Insufficient pressure on bond • Wrong adhesive or too thick of coating • Too thin of coating • Stress too great for that type of adhesive • Bonds assembled while adhesive was still wet • Lack of surface preparation • Plasticizers attached and broke down adhesive

Value Story for 3M Aerosol Adhesives
<ul style="list-style-type: none"> • Ultimate convenience in a sprayable adhesive, no equipment, no mess, no set up time, minimal training, extremely portable • Small jobs (doesn't mean small volume!), multiple stations, easy to use, precise placement of spray (lace) portability • Compliments bulk or cylinder adhesives • On job sites or away from spray booths

1. Use 3M™ Multipurpose Adhesive when bonding fiberglass insulation to metal.



2. Use 3M™ Heavy Duty Adhesive when bonding wood and laminate, lamination of large materials like wood, metal, plastic.



3. Use Specialty adhesive, 3M™ Polystyrene 78 Spray adhesive when bonding polystyrene.



4. Use Maintenance and Cleaning, 3M™ Adhesive Remover when removing adhesive residue.



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