

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

3M™ Super 77™ Multipurpose Spray Adhesive

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



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

Heavy Duty

3M™ Hi-Strength 90 Spray Adhesive

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



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

Foam & Fabric

3M™ Foam Fast 74 Spray Adhesive

- Fast-tacking adhesive with soft, non-dimpling bond lines
- Immediate foam-tearing strength
- Ideal for bonding flexible urethane or latex foam to many substrates



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

Specialty

3M™ Polystyrene Insulation 78 Adhesive

- High solids adhesive formulated for expanded polystyrene and foam insulations
- Bonds without cavitating foams
- Fast grabbing, fast drying formula



UPC

Aerosol (Clear)
000-21200-41593-7
000-51111-07279-0, Inverted

Bulk (Clear)
000-48011-53438-1, 5 Gallon Pail

3M™ Rubber and Vinyl 80 Spray Adhesive

- High strength adhesive provides strong bonds for rubber and vinyl
- High temperature and plasticizer resistant
- Fast-setting contact adhesive produces rapid results



UPC

Aerosol (Yellow)
000-21200-82618-4

Maintenance & Cleaning

3M™ Adhesive Remover

- Removes adhesive without damaging the surface underneath



UPC

Aerosol 000-21200-49048-4

3M™ Silicone Lubricant

- 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



UPC

Aerosol 000-21200-85822-2

3M™ Industrial Cleaner

- Removes grease, oil, ink and most adhesives without the need to soak



UPC

Aerosol 000-21200-76394-6

3M™ 5-Way Penetrant

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



UPC

Aerosol 000-21200-21305-2

Low VOC Spray Adhesives



Multipurpose

3M™ Super 77™ CA Multipurpose Spray Adhesive – Low VOC <25%*

- Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
- Low soak-in and long open time



UPC

Aerosol (Clear) 000-51111-97956-3

Heavy Duty

3M™ Hi-Strength 90 CA Spray Adhesive – Low VOC <25%*

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



UPC

Aerosol (Clear) 000-51111-97957-0

Foam & Fabric

3M™ Foam Fast 74 CA Spray Adhesive – Low VOC <25%*

- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more
- Soft, non-dimpling glue lines



UPC

Aerosol (Clear) 000-51111-97967-9 | **Aerosol (Orange)** 000-51111-97958-7

Maintenance & Cleaning

3M™ Adhesive Remover – Low VOC < 20%

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



UPC

Aerosol 000-51111-97974-7

3M™ Silicone Spray – Low VOC 60%

- Reliable lubricant can be used in a wide variety of applications
- Fast drying to maintain productivity
- Long lasting and non-staining



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

Particle Spray

- 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...)

Lace Spray

- 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

- 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

- 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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