

**3M** Science.  
Applied to Life.™



3M Spray Adhesives

# Performance. Productivity. Efficiency.

Streamline your assembly operation with convenient, efficient 3M Spray Adhesives.

# Industrial grade. Trusted by professionals.

3M's portfolio of industrial-grade, solvent- and water-based spray adhesives is designed to make assembly fast, convenient and efficient. Start with 3M<sup>™</sup> Super 77<sup>™</sup> Multipurpose Spray Adhesive and adjust according to your specific bonding needs.



\*Compared to 3M<sup>™</sup> Super 77

# Solutions that start with you.

Choosing the right 3M Spray Adhesives starts with you: your processes, your objectives, your bonding challenges. Then the 3M team of adhesive experts goes to work to find the best products to help maximize your product performance, increase your efficiency and streamline your assembly productivity.

## Performance: Find the right adhesive

Choosing the right adhesive for your assembly begins with asking the right questions:

- What kinds of materials are you bonding?
- How large are the materials?
- What specific adhesive attributes are you looking for?
- Do you need time to reposition after adhesion?
- What issues are you having, if any, with your current products?
- What are the environmental, health and safety factors?

## Productivity: Find the right delivery system

How you apply adhesive to your assembly components is often as important as the adhesive itself. 3M will work with you to find the delivery system that optimizes efficiency and works best for your assembly processes. 3M spray adhesives are available in three delivery systems: aerosol, cylinder and bulk.

### Aerosol



- Ultimate convenience for smaller jobs or multiple stations
- No equipment, no mess, no set up
- Easy to use; complements bulk or cylinder systems
- Ideal for field work

### Cylinder



- Self-contained, pressurized, portable
- Minimal equipment investment
- Low maintenance
- Optimized spray patterns cut waste and maximize coverage
- Ideal for larger surface areas and >20 pieces/day

### Bulk



- Easily integrated into existing equipment
- Highly cost efficient—generally the lowest cost per square foot
- Requires trained and experienced operators to maximize value
- Ideal for large surface areas and large industrial manufacturers

# Adhesive Selector: Find the right adhesive by selecting the substrates you're bonding

Choose Adhesive Delivery System



Choose Substrate

Substrate	Aerosol	Cylinder	Solvent-Based Bulk	Water-Based Bulk
Paper, Cardboard	27, 77	77	77	49
Fabric, Felt, Fibreglass, Cork	20, 27, 77	70, 77, 78ET	77	49
Flexible Foam: Urethane, Latex	24, 74	74, 74NF	74	100NF
Rigid Foam: Polystyrene, Beadboard	78	70, 78ET	78	30NF
High Pressure Laminates, Melamine	20, 90, 94ET	94CA, 94ET	94CA, 94ET	30NF
Wood, MDF, Particle Board	20, 90, 94ET	94CA, 94ET	94CA, 94ET	30NF
Metal: Steel, Aluminum	20, 90	90, 94CA, 94ET	90, 94CA, 94ET	30NF
Plastics: ABS, PVC, Phenolic, Acrylic	20, 90	90, 94CA, 94ET	90, 94CA, 94ET	30NF
FRP: Fibreglass-Reinforced Plastic	20, 90	70, 90, 94CA, 94ET	90, 94CA, 94ET	30NF
Painted Surfaces	20, 90	90, 94CA, 94ET	90, 94CA, 94ET	30NF
Rubbers: Nitrile, Neoprene, SBR	20, 80, 90	70, 90, 94CA, 94ET	90, 94CA, 94ET	N/A
Plasticized Vinyl	80	N/A	N/A	4224NF

Substrates are ranked from lightweight, heavy duty to specialty substrates.

# Adhesive Selector: Find the right adhesive by selecting the attributes you need

Product	Heat Resistance	Shear Strength psi	Non-Flammable	Bonding Range – One Surface	Solids* %	Bonding Range – Two Surfaces	Initial Tack	Postforming	Plasticizer Resistant	Spray Pattern	Colour
20	98°C (210°F)	≤ 300		1-10 min	17	1-15 min	Medium			Variable Lace	Clear
24	76°C (170°F)	≤ 300		30 sec-15 min	17	30 sec-30 min	Medium			Variable Lace	Orange
27	60°C (140°F)	≤ 200		15 sec-5 min	21	15 sec-10 min	Medium			Mist	Clear
30NF	149°C (300°F)	≤ 400	✓	NR	49	15 min-4 hr	Low	✓		Pebble	Green, Neutral
49	121°C (250°F)	50	✓	30+ days	55	30+ days	High		✓	Pebble	Clear, Red
70	87°C (190°F)	≤ 200		1-60 min	21/26	1-60 min	High			Heavy Body Lace	Clear
72	76°C (170°F)	≤ 200		NR	15	1-8 hours	High			Variable Lace	Blue
74	82°C (180°F)	≤ 200		30 sec-15 min	22/36	30 sec-15 min	Medium			Variable Lace	Clear, Orange
75	43°C (110°F)	≤ 50		15 sec-1 min	9	15 sec-1 hour	Low			Mist	Clear
76	110°C (230°F)	≤ 200		1-10 min	13.5	1-60 min	High			Variable Lace	Clear
77	65°C (150°F)	≤ 300		15 sec-15 min	25/27/36	15 sec-15 min	High			Mist	Clear
78	87°C (190°F)	≤ 300		1-5 min	19	1-15 min	Medium			Variable Lace	Clear
78ET	93°C (200°F)	≤ 200		1-5 min	17	1-60 min	Medium			Variable Lace	Clear, Green
80	149°C (300°F)	≤ 600		NR	80	3-30 min	Low		✓	Variable Lace	Yellow
90	121°C (250°F)	≤ 600		NR	13/23	1-10 min	Low			Variable Lace	Clear
94CA	98°C (210°F)	≤ 500		NR	23	1-30 min	Low	✓		Pebble	Clear, Red
94ET	93°C (200°F)	≤ 300		NR	21/25	1-60 min	Medium	✓		Pebble	Clear, Red
98NF	115°C (240°F)	≤ 300	✓	1-5 min	21/24	1-60 min	Medium	✓		Variable Lace	Clear, Red
100NF	110°C (230°F)	≤ 300	✓	30 sec-20 min	47	30 sec-20 min	Medium			Pebble	Lavender, Neutral
1000NF	149°C (300°F)	≤ 400	✓	1-5 min	49	1-10 min	Medium		✓	Pebble	Purple, Neutral
2000NF	149°C (300°F)	≤ 400	✓	NR	49	30 sec-2 hr	Low			Pebble	Blue, Light Orange, Neutral
4224NF	49°C (120°F)	≤ 200	✓	30+ days	41	30+ days	High		✓	Pebble	Clear, Blue

\* Solid weight percent can vary by format.



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