

# 3M™ Scotch-Weld™ Cylinder Spray Adhesives

Take the next step  
in bulk productivity...



## Simplify and Save



with the convenience and  
portability of pressurized cylinders

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# 3M

# Convenience and freedom of an aerosol with the productivity of a bulk system

## Convenient 3M cylinder systems

- Increased productivity with fast application and no time-consuming equipment set-up and clean-up
- Freedom from expensive capital equipment and maintenance of spray equipment and compressors
- Precise application to reduce waste

## Choice of formulations to meet a variety of regulatory requirements including:

- Non-flammable adhesive/non-flammable propellant
- No ozone-depleting chemicals
- No HAPs      • Low VOCs      • MACT compliant
- SCAQMD Compliant Contact Adhesives (South Coast Air Quality Management District with some of the toughest standards in the United States)
- California compliant

## Nine adhesives with choice of properties to help optimize production efficiency and end user reliability:

- High solids for high coverage that puts more usable adhesive to work for your money
- Fast tacking for immediate handling
- High strength, high temperature-resistant bonds for demanding applications and continued durability during end product warehousing and shipping



MARKETS

SUBSTRATES

*Compact self-contained pressurized cylinder for on the job convenience.*

## Effective delivery with adjustable-tip spray gun




*Left to right: Wide web pattern for fast coverage and minimized overspray. Narrow web pattern for targeted application. Pebble pattern for minimized telegraphing.*



# Adhesive selection for many markets... performance for many substrates




*Controlled spray eliminates waste associated with puddling, "fire hosing," and uneven stringing pattern (shown above).*

	3M™ Scotch-Weld™ Cylinder Spray Adhesive	Differentiating Features	Application Ideas for Markets and Substrates
General Purpose	General Purpose 60 CA*	<ul style="list-style-type: none"> <li>• Very high coverage</li> <li>• Temporary and permanent bonds</li> <li>• SCAQMD Rule 1168 Compliant</li> <li>• Contact Adhesive</li> <li>• MACT Compliant</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Furniture:</b> bonds soft foam, scrims, and fabric to wood or metal</li> <li>• <b>Bedding:</b> bond foam, felt, or fabric</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds, insulation to walls</li> <li>• <b>Marine:</b> attach carpeting and insulation</li> </ul>
	Super 77™	<ul style="list-style-type: none"> <li>• High solids, high coverage</li> <li>• Fast, aggressive tack</li> <li>• Uniform mist spray pattern; very low soak in</li> <li>• Good heat and moisture resistance</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Furniture:</b> bond foam and fabric</li> <li>• <b>Bedding:</b> bond foam, fabric, embroidery and textiles</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds, insulation to walls</li> </ul>
Specialty	HoldFast 70	<ul style="list-style-type: none"> <li>• Very fast tacking</li> <li>• Temporary and permanent bonds</li> <li>• Heavy body web spray with low soak in on porous or irregular surfaces</li> <li>• Bonds polystyrene without degrading the surface</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds; insulation to walls</li> <li>• <b>Marine:</b> attach carpeting and insulation</li> <li>• <b>Construction:</b> bond EPS insulation to wood and concrete; attach fabric and foam to walls for noise abatement; bond rubber matting to metal concrete forms for pre-cast; bond insulation to metal pipes and boilers</li> <li>• <b>Urethane foam</b> to wood, metal, and plastic</li> </ul>
	Polystyrene Foam Insulation 78 ET*	<ul style="list-style-type: none"> <li>• Extended tack range for temporary or permanent bonds</li> <li>• Bonds polystyrene without degrading the surface</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Store displays:</b> bond fabric, felt, plastic to soft foam, FRP, ABS, wood, or metal</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds; insulation to walls</li> <li>• <b>Construction:</b> bond EPS insulation to wood and concrete</li> <li>• <b>Appliances:</b> attach EPS insulation to metal in refrigerators</li> <li>• <b>HVAC:</b> attach insulation to pipes and ductwork</li> </ul>
High Performance, High Strength, High Temperature	Hi-Strength Postforming 94 CA* 	<ul style="list-style-type: none"> <li>• Postformable high strength</li> <li>• Low telegraphing spray pattern</li> <li>• SCAQMD Rule 1168 Compliant Contact Adhesive</li> <li>• Reduced open time</li> <li>• MACT Compliant; HAPs free</li> <li>• Greenguard™ Indoor Air Quality Certified Safe for Use in Schools</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Fixtures:</b> bond HPL to wood and steel</li> </ul>
	Hi-Strength Laminating 92	<ul style="list-style-type: none"> <li>• High strength</li> <li>• High temperature and creep resistance</li> <li>• MACT compliant; HAPs free</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Motor homes:</b> bond HPL to wood and steel</li> <li>• <b>Marine:</b> bond HPL to wood and steel; attach carpeting and insulation</li> <li>• <b>Construction:</b> attach plastic cornerbead and expansion joints to drywall; laminate drywall to drywall</li> </ul>





	3M™ Scotch-Weld™ Cylinder Spray Adhesive	Differentiating Features	Application Ideas for Markets and Substrates
Non Flammable	FoamFast Non-flammable 74 NF*	<ul style="list-style-type: none"><li>• Fast tacking, quickly reaches foam-tearing strength</li><li>• Soft, non-dimpling glue line</li><li>• Non-flammable solvent and propellant</li></ul>	<ul style="list-style-type: none"><li>• <b>Furniture:</b> bond soft foam to itself, fabric wood, and metal</li><li>• <b>Bedding:</b> bond foam, felt, or fabric</li><li>• <b>Motor homes:</b> bond foam or fabric for interior applications</li></ul>
	Hi-Strength Non-flammable 98 NF*	<ul style="list-style-type: none"><li>• High solids, high coverage</li><li>• Fast drying</li><li>• Permanent bonds</li><li>• Non-flammable solvent and propellant</li></ul>	<ul style="list-style-type: none"><li>• <b>Woodworking and cabinetry:</b> bond HPL to wood for countertops, cabinets, shelves, furniture, and displays</li><li>• <b>Motor homes:</b> bond carpet to wood, metal, or FRP</li></ul>
	Fastbond™ 30 NF 	<ul style="list-style-type: none"><li>• Greenguard™ Indoor Air Quality Certified Safe for Use in Schools</li><li>• Water-based adhesive</li><li>• Very high solids, very high coverage</li><li>• Excellent heat resistance</li><li>• Postformable</li><li>• Non-flammable solvent and propellant</li></ul>	<ul style="list-style-type: none"><li>• <b>Woodworking and cabinetry:</b> bond HPL, particle board, plywood and plastic laminate</li><li>• <b>Appliances:</b> attach EPS insulation to metal in refrigerators</li><li>• <b>Marine:</b> secure rubber flooring and headliners</li></ul>

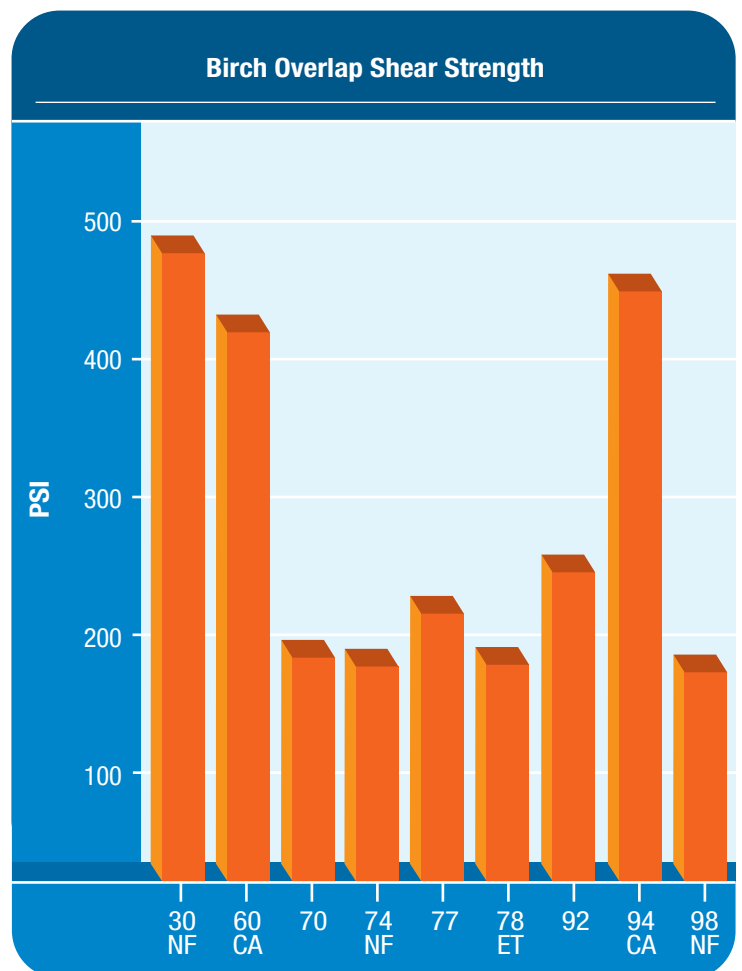
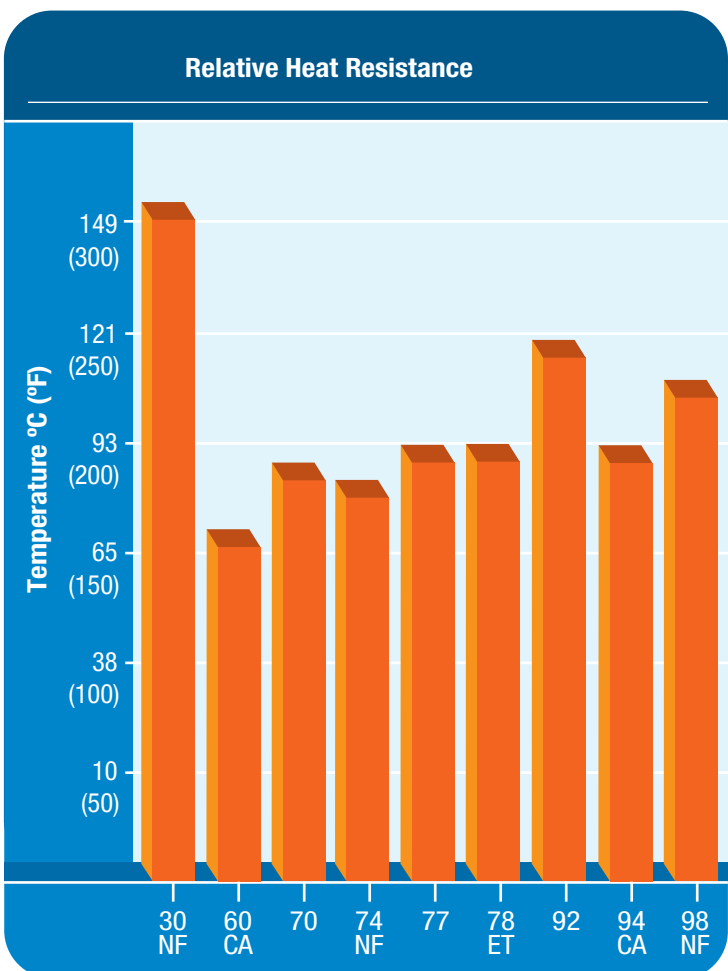
\* CA: California compliant  
ET: Extended Tack  
NF: Non Flammable

# Product Information and Packaging

Product	Flammable Adhesive/Propellant	Solids % w/propellant	Solids % w/o propellant	California Compliant	VOCs (g/liter)	Dry Time (minutes)	Open Time (minutes)
Fastbond™ 30 NF	◆ Yes/Yes	21	41	No	544	1-4	1-60
General Purpose 60 CA*	◆ Yes/Yes	43	42	Yes	>80	2-5	2-60
HoldFast 70	◆ Yes/Yes	21	41	No	544	1-4	1-60
FoamFast Non-Flammable 74 NF*	◆ No/No	22	28	No	248	1-2	1-60
Super 77™	◆ Yes/Yes	27	36	No	534	0.25-0.5	1-30
Polystyrene Foam Insulation 78 ET*	◆ Yes/Yes	17	31	No	570	1-5	1-60
Hi-Strength Laminating 92	◆ Yes/Yes	23	34	No	654	1-4	1-20
Hi-Strength Postforming 94 CA*	◆ Yes/Yes	28	28	Yes	79	1-5	1-15
Hi-Strength Non-Flammable 98 NF*	◆ No/No	20	25	No	254	1-2	1-60

\*Ingredients when dried after application are listed as indirect food additives under FDA regulation 21 CFR 175.105

**Note:** This technical information and data should be considered representative or typical only and should not be used for specification purposes.

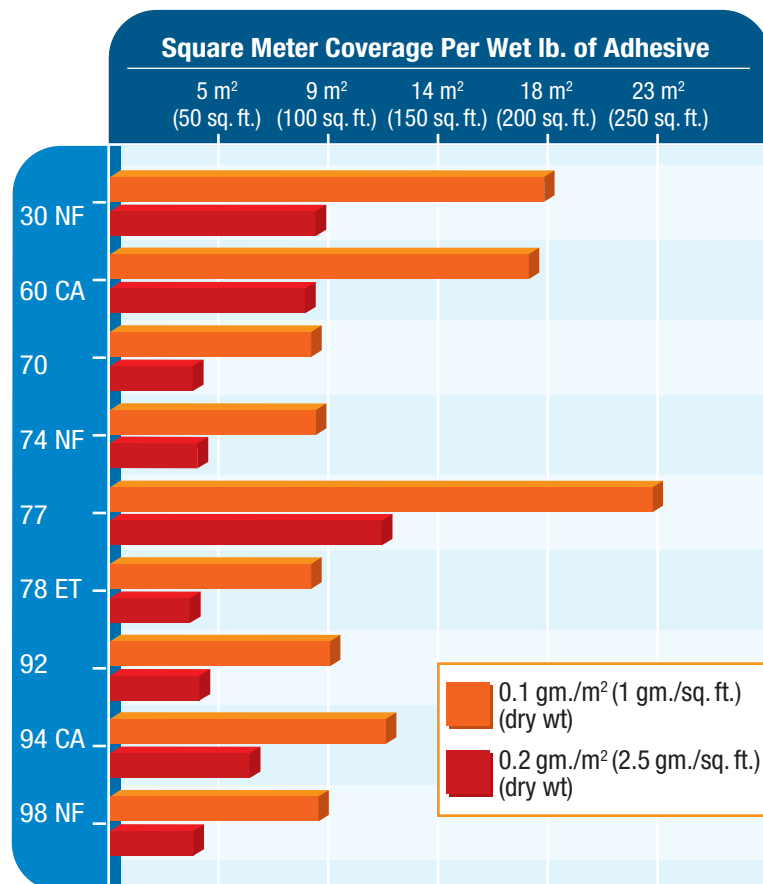


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	Temperature Rating	Spray Pattern	MACT Compliant	Colour
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	No	Clear or Orange
	High	Mist	Yes	Clear or Red
	High	Web	No	Green
	Very High	Web	Yes	Clear or Red
	High	Pebble	Yes	Clear or Red
	High	Web	No	Clear or Red



Size Availability



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Selection Guide for High Performance, High Temperature Laminating Adhesives.	Starting Product	Added Features	Product
	<b>Hi-Strength Laminating 92</b> High temperature and creep resistance	Postformable, CA compliant, reduced open time, low telegraphing	94 CA
		Water-based non-flammable adhesive/non-flammable propellant	30 NF

Product	Cylinder Sizes				Bulk	
	Mini	Large	Intermediate	Jumbo	19 L (5-gal)	208 L (55-gal)
30 NF		●				
60 CA		●	●	●		
70		●	●	●		
74 NF		●				
77		●				
78 ET		●		●		
92		●	●	●		
94 CA	●	●	●	●	●	●
98 NF	●	●	●	●		

# Equipment simplification with 3M™ Scotch-Weld™ Cylinder Spray Adhesives



Compare the equipment and tools needed for a typical compressor and drum operation (above) with the savings and simplicity of the 3M™ Scotch-Weld™ Cylinder Spray Adhesives system (at right).



## 3M™ Scotch-Weld™ Cylinder Spray

### Adhesive Equipment & Accessories

- Cylinder Adhesive Applicator (includes 9501 Tip)
- Cylinder Adhesive Applicator H (includes 4001 Tip)
- Cylinder Adhesive 9501 Spray Tip
- Cylinder Adhesive 4001 Spray Tip
- Cylinder Adhesive 6501 Spray Tip
- Cylinder Adhesive QSS Spray Tip
- Cylinder Adhesive 250050 Spray Tip
- Cylinder Adhesive 650050 Spray Tip
- Cylinder Adhesive Hose Swivel
- Cylinder Adhesive T-Fitting
- Cylinder Adhesive 1.8 m (6-Foot) Hose
- Cylinder Adhesive 3.7 m (12-Foot) Hose
- Cylinder Adhesive 7.6 m (25-Foot) Hose
- Cylinder Adhesive 15 m (50-Foot) Hose

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