



Aerosol Adhesives

74 • 75 • 76 • 77 • 78 • 90

Product Information

December 2002

Description	3M Aerosol Adhesives are a range of adhesives in aerosol can format. Different formulations are available for a variety of materials, bond strengths and applications.
Features	<ul style="list-style-type: none">• Portable• Convenient• Fast• Low VOCs• Low misting particle* sprays• Low soak-in• Lace** sprays with variable width nozzles, no overspray• High coverage (coverage stated on cans)
Product Range	<p>FoamFast 74 Lace** spray pattern with variable width spray nozzle. Designed to bond foam to itself or to other materials. Gives soft non-dimpling glue line and foam tearing strength. Fast tack, low misting.</p> <p>Repositionable 75 Fine particle* spray gives smooth, clear glue line. Permits materials to be repositioned (up to several days). Resists bleeding, staining or wrinkling.</p> <p>Hi-Tack 76 Provides strong one or two surface bonds. Low misting lace spray pattern with variable width spray nozzle. Ideal when it is only practical to spray one surface. Can be used on polyethylene and polypropylene. Long open time.</p> <p>Super 77 Extremely versatile adhesive with fast, aggressive tack. Securely bonds many lightweight materials. Long bonding range, low soak-in. Fine particle spray with high coverage.</p> <p>Insulation 78 Designed for use on expanded polystyrene foam. Lace spray pattern with variable width spray nozzle.</p> <p>Hi-Strength 90 Gives high strength bonds to a range of heavier weight materials. Bonds polyethylene and polypropylene. Good temperature resistance. Lace spray pattern with variable width spray nozzle. Can also be used as a primer for tape and label application on textured or difficult to bond surfaces.</p>

***Particle spray**: fine spray pattern for use on thin materials like paper, films and foils where a thin, texture free bond line is important.

****Lace spray**: Heavier spray pattern with less soak-in for porous and heavier materials. Gives stronger bonds than particle spray adhesives. Use on foams, heavy fabrics and metals.

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Physical Properties/Typical Performance Characteristics*

	FoamFast 74	Repositionable 75	Hi-Tack 76	Super 77	Insulation 78	Hi-Strength 90
Spray pattern	Lace	Particle	Lace	Particle	Lace	Lace
Colour	Lt orange	Clear	Translucent	Translucent	Clear	Translucent
Bonding range – one surface	NR	1 hour	10 mins	15 mins	5 mins	NR
Bonding range – two surfaces	15 mins	3 hours	1 hour	30 mins	15 mins	15 mins
Type of bond	Permanent	Repositionable	Permanent	Temporary/ Permanent	Permanent	Permanent
Temperature resistance	49°C	49°C	71°C	43°C	60°C	71°C
Initial shear strength	280 kPa	100 kPa	170 kPa	170 kPa	48 kPa	310 kPa
Ultimate shear strength	1410 kPa	450 kPa	690 kPa	1100 kPa	460 kPa	1590 kPa
Peel strength	350 N/100 mm	88 N/100 mm	440 N/100 mm	260 N/100 mm	260-350 N/100 mm	440 N/100 mm

NR = not recommended

* Not recommended for specification purposes

**Selection
considerations**

- Consider whether adhesive can be applied to one or both surfaces
- Consider the strength of bond required, and the temperature resistance required
- On thin, lightweight materials use a particle spray
- On flexible latex or polyurethane foams use FoamFast 74
- On expanded polystyrene foam use Insulation 78. Note: all other products will attack expanded polystyrene foam.

**Application
Information**

Application technique:

- **Spray the adhesive 150-200 mm away from the work.**
- **Spray at the proper speed.** Spraying too slow can create “puddles”, while spraying too fast will deposit too thin an adhesive layer.
- **Always start spraying off the edge of the work and following through past the opposite edge.** It is difficult to start and stop at the very edge of the work and not leave an excessive amount of adhesive
- **Always spray at a 90 degree angle to the work.** This will reduce overspray and ensure an even coating.
- **Overlap your spray stroke** as you start spraying at the top edge and progress down to the bottom edge. Then spray in a cross direction to create a heavy even coating (if required).
- **Spray both surfaces** to achieve the best bond.
- **Apply enough adhesive.** Textured surfaces will require more adhesive than smooth surfaces.
- **Ensure you allow sufficient drying time,** and bond within the recommended bonding range. When ready to bond, the adhesive will be aggressively tacky to the touch.
- **Pressure should be applied** to the finished bond, using a roller or a squeegee.
- **Use adequate ventilation** when working with spray adhesives
- Over spray may be removed with **3M Citrus Base Cleaner** (test a small area of the surface first). Alternative removal methods include solvent/soft cloth, or a piece of tape.

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Available can sizes	FoamFast 74	Repositionable 75	Hi-Tack 76	Super 77	Insulation 78	Hi-Strength 90
	480 g	276 g	550 g	50 g 304 g 475 g	489 g*	460 g

*Not stocked in New Zealand

- Application ideas**
- Bonding decorative film, foils and fabrics
 - Holding emblems and badges during stitching
 - Holding T-shirts during screen printing
 - Bonding carpets in cars
 - Attaching pool table fabrics
 - General upholstery bonding
 - Upholstery foam bonding
 - Bonding kick plates to office desks
 - Attaching sign lettering
 - Bonding polystyrene foam insulation panels

Coverage 3M aerosol adhesives are formulated to deliver a high rate of coverage per can. When comparing 3M aerosol adhesives with other products it is important to compare the coverage and not just the net weight.

	FoamFast 74	Repositionable 75	Hi-Tack 76	Super 77	Insulation 78	Hi-Strength 90
Container size	480 g	276 g	550 g	475 g	489 g	460 g
Coverage (one side)	24 m ²	9 m ²	9 m ²	20 m ²	10 m ²	9 m ²
% Solids	22	9	11.4	25	25	11.5

Testing Always test the suitability of the adhesive selected for your application before use. More detailed product information is available from your 3M Representative.

Shelf life 15 months when stored at 16-27°C.

Health and Safety Information Use adequate ventilation when working with 3M aerosol adhesives. Material Safety Data Sheets may be accessed by going to <http://www.3m.com/msds> and entering the product number or 3M stock number. Alternatively, contact 3M Customer Services.

Further information Further information is available at [www](http://www.3m.com) or by contacting 3M Customer Services on Free Phone 0800 200 713 or Free Fax 0800 508 980

Note **The user is responsible for determining whether the 3M product, surface preparation, and method of assembly are suitable for their particular purpose. Failure to determine the suitability of all factors involved in the application may result in bond failure.**



3M New Zealand Ltd
 Industrial Tape & Adhesives

PO Box 33-246 Takapuna 1332
 Phone: 0800 200 713
 Fax: 0800 508 980
 Email: nzsolutions@mmm.com
www.3m.com/nz/