

# 3M

## Hot Melt Adhesive

### 3762LM • 3762

Technical Data

July, 2016

**Product Description** 3M™ Hot Melt Adhesives are heat applied, 100% solids adhesives. They are fast setting thermoplastic adhesives with good “hot tack” and low to medium viscosity.

3M™ Hot Melt Adhesives bond to a wide variety of substrates such as corrugated, beadboard, repacking chipboard, recouperage, wood and many other lightweight materials.

**3M™ Hot Melt 3762LM** Low temperature application for handling ease. Economical hot melt with excellent “hot tack” and fast set.

**3M™ Hot Melt 3762** Low viscosity adhesive with “quick grab” properties.

#### Features

- 100% solids, no VOCs
- Easy to use
- Fast-setting adhesive obtains strength in seconds
- Low Melt (LM) adhesives are designed for low temperature application and heat sensitive substrates
- “Quick grab” for instant adhesion that cools to a tack free solid
- Ideal for packaging and woodworking applications.

#### Typical Physical Properties

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

	3M™ Hot Melt Adhesive	
	3762LM	3762
<b>Color (solid)</b>	Light Amber	Tan
<b>Density (g/cm<sup>3</sup>)</b>	1.01	0.95
<b>Flashpoint (°F)</b>	560	500

#### Directions for Use

**1. Surface Preparation:** Surfaces must be clean, dry and dust free. Wipe with a solvent such as isopropyl alcohol for plastic substrates to aid in removing oil and dirt.\*

\***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer’s precautions and directions for use.

**2. Application:** 3M™ Hot Melt Adhesives are designed for application with a 3M™ Hot Melt Applicators. Read and follow the precautions and directions for use in the user’s manual before operating the applicator. 3M™ Hot Melt Adhesives are applied at 350-385°F, except the Low Melt (LM) series which are designed to be applied at 250-275°F. LM series are adhesives designed for lower temperature application but still yield long-lasting bonds.

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## Directions for Use (continued)

**Open Time** is the maximum amount of time between dispensing adhesive and joining surfaces. Reported open time are based on 1/8" extruded beads and will vary based on bead size, dispense temperature and ambient temperature.

Extruded bead sizes can be customized using 3M™ applicator tips.

**3. Coverage:** 3M™ Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.

**4. Set Time:** After the bond is made, 3M™ Hot Melt Adhesives immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates.

## Typical Application Properties

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

	3M™ Hot Melt Adhesive	
	3762LM	3762
<b>Application Temperature<sup>1</sup></b>	250-270°F/ 121-132°C	350-385°F/ 177-196°C
<b>Viscosity (cps)<sup>2</sup></b>	4000 @ 250°F	1870 @ 375°F
<b>Open Time (seconds)<sup>3</sup></b>	25	35
<b>Delivery Time (seconds)<sup>4</sup></b>	45	30
<b>Available sizes/forms</b>	5/8"x8"Q 5/8"x2" TC 1"x3" PG 1/2"x12"AE 1/8" Bulk	5/8"x8"Q 5/8"x2" TC 1"x3" PG 1/2"x12"AE

(1) Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.

(2) Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

(3) For 1/8" semicircular bead, Douglas Fir to Douglas Fir.

(4) Extrusion time for one 1"x3" PG cartridge.

## Typical Performance Properties

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

	3M™ Hot Melt Adhesive	
	3762LM	3762
<b>Heat Resistance<sup>1</sup></b>	130°F/ 54°C	130°F/ 54°C
<b>Ball &amp; Ring Melt Point<sup>2</sup></b>	205°F/ 96°C	201°F/ 94°C
<b>Shear Strength<sup>3</sup></b>	480 psi	545 psi
<b>Peel Strength<sup>4</sup></b>	6 pwi	7 pwi
<b>UL94 Listing</b>	n/a	V2
<b>FDA Indirect Food Contact<sup>5</sup></b>	21 CFR 175.105	21 CFR 175.105

(1) Highest temperature that the adhesive will support a 2 psi dead load.

(2) ASTM E28-67.

(3) Douglas Fir to Douglas Fir.

(4) Canvas to Douglas Fir.

(5) Permitted for indirect food contact subject to the limitations in applicable CFR section(s).

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<b>Storage</b>	Store product below 120°F (49°C).
<b>Shelf Life</b>	When stored at the recommended conditions, this product has a shelf life of 2 years after 3M ships the product to a customer or distributor.
<b>Pre cautionary Information</b>	Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501
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**ISO 9001:2000**

**3M**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.

## Industrial Adhesives and Tapes Division

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