













Woodworking and Large Surface Lamination — Solvent and Water Based






Wood, Metal and Rubber Flooring

Woodworking, transportation, construction, and general industrial markets can effectively bond metals, wood, rubber, carpet and flooring (vinyl tiles) with this line of adhesives. Some applications include transportation flooring and carpet, store fixtures and furniture.

- High pressure laminate (HPL)
 - Countertops
 - Furniture
 - Display fixtures
- Edge banding
 - Specialty vehicle flooring
 - Wood furniture
 - Trade show displays

HEAVY DUTY — Solvent Based Adhesives			
Key Product	Product	Requirement	Size Availability
	94 CA	FAST TACKING, POSTFORMABLE	 
	90	High strength	 
	92	High temperature resistance	 
	94 ET	Longer open time, more aggressive tack	 
	98 NF	Non-flammable	 
	5	Very high temperature resistance	
	1099	Plasticizer resistance, harsh environments	

HEAVY-DUTY — Water Based Adhesives			
Key Product	Product	Requirement	Size Availability
	30NF	HIGH STRENGTH	
	2000NF	Faster initial strength	
	1000NF	One surface bonding, fast assembly, plasticizer resistance	



Marine and specialty vehicle applications, like installing carpet, rubber or synthetic flooring, are perfect for 3M sprayable adhesives. Our quick tack, low VOC and cylinder delivery are common benefits in this market.



Consider trade show exhibits and store fixtures that are often updated several times a year. 3M's adhesive line offers very low cost per square foot bonded for applications where our customers value total applied cost.



3M® Hi-Strength 90 Spray Adhesive has a long reputation of holding strong in critical applications like this edge banding strip. Also, 3M has multiple adhesives that are postformable. Postforming is where the laminate is heated and bent as much as 360° around a radius.

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

Save Yourself the Hassle of Inefficient Spraying

Most common applications:

- High pressure laminate
- Foam/paper core steel door
- Upholstery
- Metal lamination
- Insulation bonding

Where to find these applications:

- Cabinet shops
- Elevator interiors
- Countertop shops
- Exhibit manufacturing
- Fixture/display manufacturing
- Office furniture
- Theatre/production sets
- Acoustic panel/partition

Key Questions

Asking the right questions related to the application will help you arrive at an adhesive selection quickly and painlessly.

Use A.S.P.E.C.

- What is the **APPLICATION** you are currently using the adhesive for?
- What **SUBSTRATES** does the adhesive need to bond too?
- Are there special **PROCESS** details the adhesive needs to accommodate? Such as high temperatures or VOC regulations?

- What kinds of **END USE** stress or environment will the bond be subject to? (e.g., boat carpet and saltwater conditions or exterior applications).
- How do you determine the **VALUE** beyond simply the **COST** of a product? (e.g., Improved coverage, reduced flammability or speed of application).



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3M™ Cylinder Spray Adhesives do not atomize spray patterns with added airline. This means you get consistent even spray patterns, potentially saving rework and cleanup.

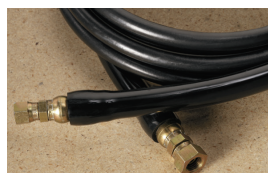


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Consistent spray patterns and portable cylinders mean you can realize big improvements in efficiency and save time and labor costs.

3M™ Cylinder Spray Adhesive Quick Reference Guide

Product	Application	Solids (%)	Solids – Bulk (%)	VOCs (g/L)	Open Time (min)	Spray Pattern	Spray Applicator	Recommended Tips
MULTI-PURPOSE								
60 CA	General Purpose	43	42	>80	2–60	Web	Applicator	9501, 6501
70	Construction, Marine, RV, Polystyrene	21	41	544	1–60	Web	Applicator	QSS tip
77	Multi-Purpose	27	36	534	1–30	Mist	Applicator	250050, 650050
HEAVY DUTY								
90	Laminating	13	23	571	1–15	Web	Applicator	9501, 6501, 250050
92	Laminating	23	34	654	1–20	Web	Applicator	9501, 6501, 250050
94 CA	Laminating	28	28	79	1–15	Pebble	Applicator H	4001, 6501
94 ET	Laminating	28	34	<80	1–60	Pebble	Applicator H	9501, 6501, 4001
98NF	Laminating	20	25	254	1–60	Web	Applicator	9501, 6501, 4001
FOAM & FABRIC								
74	Foam Bonding	22	36	563	1–15	Web	Applicator	9501, 6501
74NF	Foam Bonding	22	28	248	1–60	Web	Applicator	9501, 6501
SPECIALTY								
78 ET	Polystyrene	17	31	570	1–60	Web	Applicator	9501, 6501

3M™ Cylinder Spray Adhesive Equipment and Accessories



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9501



6501



4001



QSS



T-Fitting



Hose Swivel

Spray Tip	Angle	Spray Pattern Width
9501	95°	Wide
6501	65°	Medium
4001	40°	Narrow
QSS*	—	Very Wide
250050	25°	Very Narrow
650050	65°	Medium

*For 3M™ HoldFast 70 Spray Adhesive

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Solvent and Water Based Adhesives



Product	Available Format	Solids Weight Percent (Approx.)	Key Characteristics
MULTI-PURPOSE			
Multi-Purpose 27	Aerosol	21%	Fast tack. Lightweight applications. Mist spray pattern.
General Purpose 60 CA	5 gal, 54 gal	43%	High solids for increased coverage. High tack general purpose adhesive.
	Large, Int and Jumbo Cylinder	42%	
HoldFast 70	5 gal, 52 gal	26%	Extremely versatile and very fast tacking. Unique wide web spray pattern with heavy body and low soak-in. Bonds polystyrene without degrading surface.
	Large, Int and Jumbo Cylinder	21%	
Super 77™	Aerosol	25%	Low soak-in for long lasting bond. High coverage and aggressive tack. Bonds quickly in 15 seconds.
	5 gal, 52 gal	36%	
	Large Cylinder	27%	
Super 77™ CA Multi-Purpose (Low VOC)	Aerosol	19%	Aggressive tack. Quick bonding. Long bonding range.
Fastbond™ Insulation Adhesive 49	5 gal box, 5 gal, 52 gal, 100 gal, 255 gal	55%	Fast tacking, high performance, pressure sensitive adhesive for lightweight materials. Low VOC and GREENGUARD Certified. UL MAGW2 component recognition.
HEAVY DUTY			
Neoprene Contact 5	5 gal, 53 gal	19%	High performance contact adhesive. Sprayable. Fast drying.
Neoprene Contact 10	1 qt, 1 gal, 5 gal, 54 gal	23%	Brushable and rollable with higher coverage. Meets requirements of MMM-A-121, MMM-A-130B and A-A-1936A.
Heavy Duty 20	Aerosol	17%	Fast grab. Variable width spray pattern. Forms strong bonds to a variety of substrates.
Hi-Strength 90	5 gal, 52 gal	23%	High strength. High temperature resistance.
	Large, Int and Jumbo Cylinder	13%	
	Aerosol	13%	
Hi-Strength 90 CA (Low VOC)	Aerosol	23%	High strength.
Hi-Strength 92	5 gal, 54 gal	34%	High strength. High temperature resistance. Versatile, high-tack adhesive.
	Large, Int and Jumbo Cylinder	23%	
Hi-Strength 94 ET (Low VOC)	5 gal, 54 gal	25%	Bonds many laminates, woods, and particle board. Long open time, low VOC. SCAQMD Rule 1168 compliance; helps contribute to LEED® Credits.
	Large, Int and Jumbo Cylinder	25%	
	Aerosol	21%	
Hi-Strength Postforming 94 CA (Low VOC)	5 gal, 54 gal	34%	High solids for increased coverage. Unique non-telegraphing spray pattern with postformable strength. Low VOC, SCAQMD 1168 and LEED® Compliant.
	Large, Int and Jumbo Cylinder	28%	
Hi-Strength 98NF	5 gal, 54 gal	24%	Non-flammable, fast tack adhesive. High temperature resistance. Versatile, high-tack adhesive.
	Mini, Large, Int and Jumbo Cylinder	21%	
Fastbond™ Contact Adhesive 30NF	1 qt, 1 gal, 5 gal, 52 gal, 270 gal	49%	Non-flammable water-based contact adhesive. Extremely high strength, high temperature resistant. Meets MIL-A-24179A, Type I, GREENGUARD Certified, SCAQMD 1168, LEED® Compliant.
Fastbond™ Contact Adhesive 30H	52 gal, 270 gal	48%	Long bonding range with high immediate bond strength. Economical high coverage. Low mist version of 30NF.
Fastbond™ 2000NF	5 gal, 50 gal, 270 gal	49%	Water dispersed, activated adhesive. Immediate bonding and handling strength without forced drying. GREENGUARD Certified.
FOAM & FABRIC			
Foam & Fabric 24	Aerosol	17%	Aggressive tack. Foam-tearing strength. Variable width lace spray pattern.
Foam Fast 74	Aerosol	22%	Extremely fast tack. Soft non-dimpling glue line. Immediate foam tearing strength.
	52 gal	36%	
	Large, Int and Jumbo Cylinder	22%	
Foam Fast 74 CA (Low VOC)	Aerosol	23%	Extremely fast tack. Soft non-dimpling glue line. Immediate foam tearing strength.
Foam Fast 74NF	Mini, Large, Int and Jumbo Cylinder	24%	Non-flammable. Fast tack with foam tearing strength. Soft non-dimpling bond line.
Fastbond™ Foam Adhesive 100NF	1 gal, 5 gal, 52 gal, 100 gal, 255 gal	47%	One-part, fast setting — foam and fabric adhesive. GREENGUARD Certified. Can be activated for immediate bonding.

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