

3M Science.
Applied to Life.™



3M™ Spray Adhesives

Performance. Productivity. Efficiency.

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

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 go to work to find the best products to help maximize your product performance, increase your efficiency, streamline your assembly productivity and meet your sustainability goals.

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 setup
- 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

Sustainability: Find the products that achieve your goals.

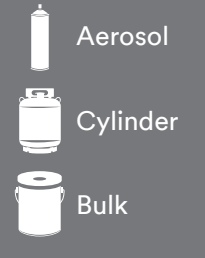
Maximizing sustainability doesn't have to mean giving up performance. For more than 40 years 3M engineers have been developing water-based, low VOC and GREENGUARD™ certified adhesives for some of the most demanding applications in the world. So if you're ready to "go greener," we're ready to take you there.



*Meets applicable 2017 California Air Resource Board VOC limits for mist and web spray adhesives.

Industrial grade. Trusted by professionals.

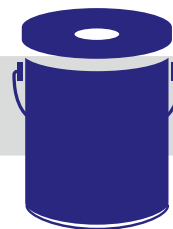
3M's portfolio of industrial-grade, solvent- and water-based spray adhesives is designed to make assembly fast, convenient and efficient. Start with 3M™ Super 77™ Multipurpose Spray Adhesive and adjust according to your specific bonding needs.



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, Fiberglass, Cork	20, 27, 77	70, 77, 78ET	77	49
Flexible Foam: Urethane, Latex	24, 74	74	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, 4491	30NF
FRP: Fiberglass 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, 4491	N/A
Plasticized Vinyl	80	NA	4491	4224NF

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

60CA

3M™ General Purpose Adhesive 60CA

- Low VOC, general-purpose industrial-grade adhesive with lace spray pattern
- High solids content
- Bonds fabric, foam, plastic, heavy paper to wood, plastics and metals

Clear	
Cylinder	
Large	00 48011 61687 2
Intermediate	00 48011 61688 9
Jumbo	00 48011 61689 6
Bulk	
5 Gallon Pail	00 51115 31589 1
Closed Head Steel Drum	00 51115 31590 9

70

3M™ HoldFast 70 Spray Adhesive

- Extremely versatile, fast-tacking, industrial-grade adhesive
- Unique wide-web spray pattern with heavy body and low soak-in formula
- Bonds polystyrene without degrading the surface

Clear	
Cylinder	
Large	00 48011 61690 2
Intermediate	00 48011 61691 9
Jumbo	00 48011 61692 6
Bulk	
5 Gallon Pail	00 51115 63935 7
Closed Head Steel Drum	00 51115 63934 0

77MP

3M™ Super 77™ Multipurpose Spray Adhesive

- High tack, high coverage and low soak-in formula
- Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
- Bonds in 15 seconds

Clear	
Aerosol	
13.44 oz.	00 76308 86234 3
16.0 oz.	00 21200 21210 9

77 Classic

3M™ Super 77™ Classic Spray Adhesive

- Original formula
- Fast aggressive tack and low soak-in of adhesive
- Bonds lightweight materials
- Bonds in 10–15 seconds

Clear	
Aerosol	
16.75 oz.	00 21200 96315 5
Cylinder	
Large	00 51115 25776 6
Bulk	
5 Gallon Pail	00 21200 43793 9
Open Head Steel Drum	00 21200 43813 4

77CA

3M™ Super 77™ CA Multipurpose Spray Adhesive Low VOC <25%

- Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
- Low soak-in and long open time
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear	
Aerosol	
00 51111 97956 3	

Foam & Fabric

24

3M™ Foam & Fabric 24 Spray Adhesive

- Fast-tack, industrial-grade adhesive
- Aggressive tack with foam-tearing strength
- Bonds foam to substrates such as fabric, wood and more

Orange	
Aerosol	
00 51111 07862 4	

74

3M™ Foam Fast 74 Spray Adhesive

- Fast-tacking adhesive with soft, non-dimpling bond lines
- Immediate foam-tearing strength
- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more

Clear		Orange	
Aerosol		Aerosol	
00 51111 50045 9		00 21200 82242 1	
Cylinder		Cylinder	
Large	00 21200 49919 7	Large	00 21200 49158 0
Intermediate	00 51115 25741 4	Intermediate	00 51111 18853 8
Jumbo	00 51115 25742 1	Jumbo	00 51111 18854 5

74CA

3M™ Foam Fast 74CA Spray Adhesive Low VOC <25%

- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more
- Soft, non-dimpling glue lines
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear		Orange	
Aerosol		Aerosol	
00 51111 97967 9		00 51111 97958 7	

100NF

3M™ Fastbond™ Foam Adhesive 100NF

- A water-dispersed, neoprene-based contact adhesive
- One part, rapid setting adhesive
- Ideal for bonding foam to many substrates such as wood, metal, fabrics and more

Lavender		Neutral	
Bulk		Bulk	
5 Gallon Pail	00 21200 41542 5	5 Gallon Pail	00 21200 39203 0
5 Gallon Box	00 21200 56509 0	5 Gallon Box	00 21200 56510 6
Open Head Steel Drum	00 48011 58433 1	Open Head Steel Drum	00 48011 58713 4
Poly Drum	00 21200 41543 2	Poly Drum	00 21200 39204 7
270 Gallon Poly Tote	00 21200 41544 9	270 Gallon Poly Tote	00 21200 39205 4
100 Gallon EZ Tote	00 21200 56512 0		

Specialty

72

3M™ Pressure Sensitive Spray Adhesive 72

- Pressure-sensitive adhesive gains strength as pressure is applied
- Permanent tack ideal for many one-surface bond applications
- Long open time allows bonds to be made hours or days after application
- Variable-width lace spray pattern allows for precise dispensing

Blue	
Aerosol	
00 21200 30025 7	

76

3M™ Hi-Tack 76 Spray Adhesive

- High tack spray adhesive creates quick, strong bonds
- Bonds hard-to-hold surfaces such as plastics to rubber, fabric, cardboard, wood, metal and more
- Variable-width lace spray pattern

Clear	
Aerosol	
00 21200 30026 4	

78

3M™ Polystyrene Insulation 78 Adhesive

- High solids adhesive formulated for expanded polystyrene and foam insulations
- Bonds without cavitating foams
- Fast grabbing, fast drying formula

Clear		Inverted	
Aerosol		Aerosol	
00 21200 41593 7		00 51111 07279 0	
Bulk			
5 Gallon Pail	00 48011 53438 1		

78ET

3M™ Polystyrene Insulation 78ET Adhesive

- Bonds polystyrene with no surface degradation
- Long tack time extends working time
- Uniform spray pattern ensures fast and easy application

Clear		Green	
Cylinder		Cylinder	
Large	00 48011 61693 3	Large	00 48011 61695 7
Intermediate	00 51115 25704 9	Intermediate	00 51115 25705 6
Jumbo	00 48011 61694 0	Jumbo	00 48011 61696 4

78HT

3M™ Hi-Temperature Polystyrene Insulation 78HT Adhesive

- Permanently bonds to polystyrene foam and other materials
- Will not degrade the foam
- Sprays with a lace pattern optimized for foam

Blue	
Cylinder	
Mini Cylinder	00 51115 31593 0
Large Cylinder	00 51115 31595 4
Intermediate Cylinder	00 51115 31594 7
Jumbo Cylinder	00 51115 31596 1
Bulk	
5 Gallon Pail	00 51111 07571 5
54 Gallon Drum	00 51111 07572 2