



Technical Data Sheet

3M™ Industrial Adhesive 4799

Product Description

3M™ Industrial Adhesive 4799 can be used to bond most EPDM rubber, sponge rubber, rubber sheeting, felt, canvas, linoleum and other lightweight materials to many metals, woods, concrete and plastics.

Product Features

- Quick drying adhesive with fast strength buildup.
- Provides low soak-in on most porous substrate.
- Dries to a flexible, water resistant bond.

Technical Information Note

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

Typical Physical Properties

Property	Values	Additional Information
Solids Content by Weight	28 to 35 %	
Color	Black	
Flash Point	-14 °F	View
Notes: Closed Cup		
Flash Point	-26 °C	View
Notes: Closed Cup		
Carrier Solvent	Petroleum Distillate, N-Hexane and Toluene	







Typical Uncured Physical Properties

Property	Values	Additional Information
Viscosity	7,500-18,000 cP	View

Notes: Brookfield Viscometer spindle #6 at 20 rpm

Base	SBR
Net Weight	6.6 to 7 lb/gal


Typical Performance Characteristics

Property	Values	Additional Information
180° Peel Adhesion	248 oz/in	View 
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	352 oz/in	View 
Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	400 oz/in	View 
Dwell/Cure Time: 120.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	408 oz/in	View 
Dwell/Cure Time: 168.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	440 oz/in	View 
Dwell/Cure Time: 2.0 Dwell Time Units: week Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	448 oz/in	View 
Dwell/Cure Time: 3.0 Dwell Time Units: week Temp C: 23C		

Temp F: 72F
Environmental Condition: 50%RH
Substrate: Canvas to Steel

180° Peel Adhesion

224 oz/in

View 

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: -34C
Temp F: -29F
Environmental Condition: 50%RH
Substrate: Canvas to Steel

180° Peel Adhesion

136 oz/in

View 

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 66C
Temp F: 150F
Environmental Condition: 50%RH
Substrate: Canvas to Steel

180° Peel Adhesion

80 oz/in

View 

Dwell/Cure Time: 3.0
Dwell Time Units: week
Temp C: 82C
Temp F: 180F
Environmental Condition: 50%RH
Substrate: Canvas to Steel

Storage and Shelf Life

Store product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.

When stored at the recommended conditions and kept in the original, unopened container, this product has a shelf life of 24 months from date of manufacture.

Bottom Matter

3M
Industrial Adhesives and Tapes Division
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550

Trademarks

3M is a trademark of 3M Company.

Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer’s automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M’s Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer’s use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

NOTWITHSTANDING ANY OTHER STATEMENT TO THE CONTRARY, 3M MAKES NO REPRESENTATIONS, WARRANTIES OR CONDITIONS WHATSOEVER, EXPRESS OR IMPLIED, REGARDING THE PRODUCT IF USED IN AN AUTOMOTIVE ELECTRIC POWERTRAIN BATTERY OR HIGH VOLTAGE APPLICATION, INCLUDING, BUT NOT

LIMITED TO, ANY WARRANTY ON PERFORMANCE, LONGEVITY, SUITABILITY, COMPATIBILITY, OR INTEROPERABILITY, OR ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE.

Handling/Application Information

Application Equipment

Note: Appropriate application equipment can enhance adhesive performance. The user is responsible for evaluating application equipment in light of the user's particular purpose and method of application.

1. Pumping: Use a 5:1 ratio double acting, ball check pump with a 3 inch diameter air motor. All packings and glands in contact with the adhesive should be PTFE coated.
2. Hoses: Material hoses should be nylon lined with a working pressure of 500 psi or greater.
3. Brushes: Brushes designed for use with oil based paint may be used.

Directions for Use

1. Surface Preparation: Surfaces to be bonded must be clean, dry and dust free.

Wiping with a solvent such as methyl ethyl ketone (MEK)* will aid in removing oil and dirt.

2. Application Temperature: For best results the temperature of the adhesive and the surfaces being bonded must be at least 65°F (18°C).
3. Application: Stir or agitate well before using.

Porous Surface(s): Brush a uniform, generous coat of adhesive on the least porous surface to be bonded. Assemble the materials immediately with sufficient pressure to ensure contact.

Non-Porous Surface(s): Apply a uniform coat of adhesive to each surface. Allow adhesive to dry until it is tacky, but does not transfer. Assemble materials with sufficient pressure to ensure contact.

4. Cleanup: Excess adhesive may be removed with a solvent such as methyl ethyl ketone (MEK).*

*Note: When using solvents, extinguish all sources of ignition in the area and follow the manufacturer's precautions and directions for use when handling such materials.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40069405/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=4799

ISO Statement

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

Precautionary Information

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.

Information

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Disclaimer: 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.