



# Adhesives and Tapes

## Adhesives Selection Guide

Metal to:	Structural Adhesives: Each adhesive has high cohesive strength to bond high strength materials and potentially replace mechanical fasteners		Solvent and Water Based Spray Adhesives	
	3M™ Scotch-Weld™ Epoxy, Acrylic Adhesives	3M™ Scotch-Weld™ Instant Adhesives	3M™ Solvent and Water Based Adhesives	3M™ Aerosol Adhesives
<b>Metal</b>	Acrylics, Epoxies	CA40H	1357, 1099 (All), 1300	80, 90
<b>EPDM Rubber</b>	—	CA40H	4799	—
<b>Rubber (except EPDM)</b>	Flexible 2-part Epoxies	CA40H	1300, 847	80, 90*
<b>Glass and Ceramics</b>	Flexible 2-part Epoxies	—	1357	80, 90
<b>Leather</b>	Flexible 2-part Epoxies	—	847	80
<b>Plastics (Polyolefins)</b>	DP8005	—	—	90
<b>Plastics (ABS, PVC, Acrylic, etc.)</b>	DP8005	CA40H	1357	77, 80, 90
<b>Plastics (High Performance Nylon)</b>	DP460	CA40H	1099 (All)	77, 80, 90
<b>Plastics (Flexible Vinyl)</b>	Flexible 2-part Epoxies	CA40H	1099 (All)	80
<b>Paper and Cardboard</b>	2-part Epoxies	—	10	77
<b>Fabric, Felt, Cork and Fibrous Glass</b>	2-part Epoxies	—	—	74, 77, 80, 90
<b>Flexible Foam (Latex, Urethane)</b>	—	—	—	74, 90
<b>Rigid Foam (Beadboard, Styrene)</b>	Flexible 2-part Epoxies	—	—	—
<b>Rigid Foam (Urethane)</b>	Flexible 2-part Epoxies	CA40H	1357, 5, 10	74, 80




Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes. Final product selection should be made only after consideration of a variety of factors and evaluations of sample bonds.

\*Produces a temporary bond on these materials. (1) Adhesives must be force dried and bonded while warm. (2) For best results, preheat the substrate to a minimum of 120°F (49°C). (3) Evaluate usage surface activator.



## 3M™ Neoprene Contact Adhesives

This line offers a wide range of choices for contact adhesives applications. Select from bonding ranges, strengths, solids contents and solvent formulations to meet requirements for bonding laminate, foam and more.

Product	Description/UPC	Solids Weight (Approx)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PSI)	Color	Size	Qty/Case
								75°F (24°C)	180°F (82°C)	75°F (24°C)			
3M™ Neoprene Contact Adhesive 5													
	<ul style="list-style-type: none"><li>• Rapid strength buildup</li><li>• Heat and creep resistant bond</li><li>• Bonds many high pressure plastic laminates to metal and other surfaces</li></ul>												
	021200-21232-1	19%	-14°F (-26°C)	Thin Liquid	Green	Spray	30 min max	482'	65'	19²	Green	5 Gal Pail	1
	021200-20333-6				Light Yellow						Light Yellow	5 Gal Pail	1
3M™ Neoprene Contact Adhesive 10													
	<ul style="list-style-type: none"><li>• Similar performance to Contact Adhesive 5</li><li>• Brushable with higher coverage</li><li>• Bonds aluminum, steel, rubber and other porous and non-porous materials to each other or to themselves</li></ul>												
	021200-20272-8	22%	-14°F (-26°C)	Thin Liquid	Light Yellow	Brush, Roller	30 min max	482'	65'	19²	Light Yellow	1 Quart	12
	021200-20274-2											1 Gal	4
	021200-20276-6											5 Gal Pail	1
3M™ Neoprene High Performance Contact Adhesive 1357													
	<ul style="list-style-type: none"><li>• Rapid buildup to a very high strength bond for metal</li><li>• Resists heat and continuous load stress</li><li>• Adheres well to metal, rubber, wood and glass</li></ul>												
	021200-19887-8	25%	-14°F (-26°C)	Thin Liquid	Gray-green, Light Yellow	Brush, Spray	30 min max	536'	199'	42²	Gray Green	5 oz tube	36
	021200-19890-8											1 Pint	12
	021200-19892-2											1 Quart	12
	021200-19894-6											1 Gal	4
	021200-19897-7											5 Gal Pail	1
	021200-22586-4										Light Yellow	1 Gal	4
	021200-64963-9											5 Gal Pail	1

1 Birch plywood to birch plywood @ 0.1 inches/minute separation rate

2 Canvas to cold rolled steel @ 2.0 inches/minute separation rate

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