

3M™ Hot Melt Adhesive Selector Guide

Step 1: Select your assembly type.



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Small Joint Assembly

Small joints are typically irregularly shaped, but only a few inches of overlap area.



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Large Surface Lamination

Two surfaces of similar size, either rigid or flexible, are bonded or laminated together where majority of the surface is covered by adhesive.



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Mounting and Trim Attachment

Small objects are mounted or added to a large surface.

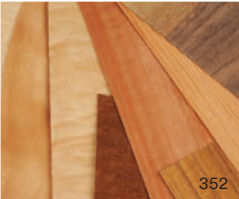


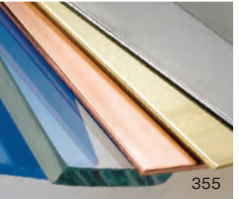
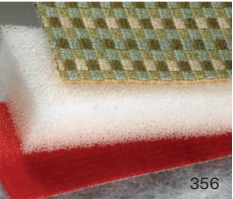




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Sealing, Potting and Encapsulating

Adhesive flows over and around a component or fills a chamber to protect and seal components therein.

Step 2: After selecting your assembly, choose the substrate and identify the adhesive that performs best for your application.

Substrate	 352	 353	 354	 355	 356
	Wood	Paper	Plastic	Metal / Glass	Fabric / Foam
Lead Adhesive	<p>3M™ Hot Melt Adhesive 3792</p> 	<p>3M™ Hot Melt Adhesive 3762LM</p> 	<p>3M™ Hot Melt Adhesive 3764</p> 	<p>3M™ Hot Melt Adhesive 3747</p> 	<p>3M™ Sprayable Hot Melt Adhesive 6111HT</p> 

Hot Melt Adhesive is dispensed at 350–385°F. Low Melt Adhesive is dispensed at 250–270°F.

NOTE: Low Melt (LM) adhesives liquefy at lower operating temperatures for bonding heat sensitive surfaces such as bead board and foams.

NOTE: High Temperature (HT) has high temperature resistance.

3M™ Hot Melt Adhesives



Product	Color	UL 94 Listing	Features/Application Ideas
Low Melt Technology: Applied 250–270°F (121–132°C)			
3762LM*	Light Amber	N/A	Excellent "hot tack", fast setting for corrugated, beadboard, recouperage, repacking chipboard and wood. Economical, general purpose. Use with low melt applicator only.
3776LM	Tan	N/A	Bonds variety of plastics, woods and light-gauge metals. Use with low melt applicator only.
3792LM*	Clear	V2	Clear, multi-purpose for wood, coated paper, polyolefins and other heat-sensitive materials. P.O.P. displays. Use with low melt applicator only.
3798LM*	Light Yellow	N/A	Removable "gummy glue" for many substrates. Removes easily without residual tack. Use with low melt applicator only.
Hot Melt Technology: Applied 350–385°F (177–196°C)			
3731*	Tan	N/A	High heat resistance. Bonds plastics including polyethylene, polypropylene.
3738*	Tan	V2	High delivery rate and long bonding range. General purpose for foundry sand cores, wood bonding, corrugated, selected plastics and chipboard.
3747	Tan	N/A	General purpose for wide variety of plastics, wood and lightweight metals.
3748*	Off-White	V2	Good thermal shock resistance. Non-corrosive to copper for many electronic applications. Bonds polyolefins.
3748 VO	Light Yellow	VO	Self-extinguishing version of 3748. Meets UL 1410 requirements.
3750	Tan	N/A	Low viscosity for high flow rate, increased production. Good hot tack, quick grab for packaging and woodworking.
3750	Clear	N/A	Low viscosity for high flow rate, increased production. Good hot tack, quick grab for packaging and woodworking.
3762	Tan	V2	Excellent "hot tack", fast setting for corrugated, beadboard, recouperage, repacking chipboard and wood. Economical, general purpose.
3764*	Clear	V2	Bonds variety of plastics including polycarbonate, polyethylene, and polypropylene. Flexible at low temperatures.
3779*	Amber	N/A	High heat resistance. High strength. Good fuel and oil resistance. Electronics.
3789*	Brown	V2	High performance for plastics. Impact resistant. Bonds vinyl and wood. Good fuel and oil resistance.
3792*	Clear	V2	Clear, multi-purpose for wood, corrugated, fabric, furniture, upholstery, novelties, and other lightweight materials.
3797	Off-White	V2	High ball and ring. Low viscosity. Good for electrical potting.
Bulk Only			
3794 Hi Tack PSA	Light Tan	N/A	Sprayable high tack PSA for bonding plastic, paper, metals, die-cut labels.
6111	Tan	N/A	Sprayable 100% solventless adhesive for most foams, fabrics, plastics, particle board and thin metal.
6111HT	Tan, Blue	N/A	Similar to 6111 but has higher heat resistance. Available in tan and blue.
6116	Off-White	N/A	Similar to 6111 but lower than normal viscosity and mainly used on fabrics.

*Also available in bulk.

1 – Brookfield Thermosel Viscometer in Centipoise

2 – ASTM E-28-6-7

3 – Highest temperature that the adhesive will support a 2 psi dead load

4 – Canvas to Douglas Fir

5 – Douglas Fir to Douglas Fir

6 – 1/8" semicircular bead, Douglas Fir to Douglas Fir