

3M™ Scotch-Weld™  
Cylinder Spray Adhesives

Take the next step  
in bulk productivity...



**Simplify and Save**



with the convenience and  
portability of pressurized cylinders



# Convenience and freedom of an aerosol with the productivity of a bulk system

## Convenient 3M cylinder systems

- Increased productivity with fast application and no time-consuming equipment set-up and clean-up
- Freedom from expensive capital equipment and maintenance of spray equipment and compressors
- Precise application to reduce waste

## Choice of formulations to meet a variety of regulatory requirements including:

- Non-flammable adhesive/non-flammable propellant
- No ozone-depleting chemicals
- No HAPs      • Low VOCs      • MACT compliant
- SCAQMD Compliant Contact Adhesives (South Coast Air Quality Management District with some of the toughest standards in the United States)
- California compliant

## Nine adhesives with choice of properties to help optimize production efficiency and end user reliability:

- High solids for high coverage that puts more usable adhesive to work for your money
- Fast tacking for immediate handling
- High strength, high temperature-resistant bonds for demanding applications and continued durability during end product warehousing and shipping



MARKETS

SUBSTRATES

*Compact self-contained pressurized cylinder for on the job convenience.*

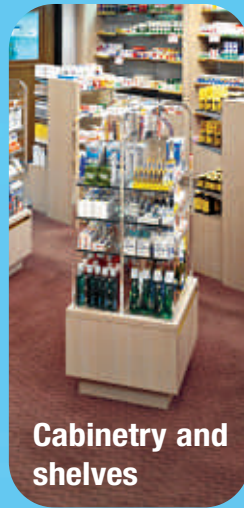
## Effective delivery with adjustable-tip spray gun




*Left to right: Wide web pattern for fast coverage and minimized overspray. Narrow web pattern for targeted application. Pebble pattern for minimized telegraphing.*




# Adhesive selection for many markets... performance for many substrates



	3M™ Scotch-Weld™ Cylinder Spray Adhesive	Differentiating Features	Application Ideas for Markets and Substrates
General Purpose	General Purpose 60 CA*	<ul style="list-style-type: none"> <li>• Very high coverage</li> <li>• Temporary and permanent bonds</li> <li>• SCAQMD Rule 1168 Compliant</li> <li>• Contact Adhesive</li> <li>• MACT Compliant</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Furniture:</b> bonds soft foam, scrims, and fabric to wood or metal</li> <li>• <b>Bedding:</b> bond foam, felt, or fabric</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds, insulation to walls</li> <li>• <b>Marine:</b> attach carpeting and insulation</li> </ul>
	Super 77™	<ul style="list-style-type: none"> <li>• High solids, high coverage</li> <li>• Fast, aggressive tack</li> <li>• Uniform mist spray pattern; very low soak in</li> <li>• Good heat and moisture resistance</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Furniture:</b> bond foam and fabric</li> <li>• <b>Bedding:</b> bond foam, fabric, embroidery and textiles</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds, insulation to walls</li> </ul>
Specialty	HoldFast 70	<ul style="list-style-type: none"> <li>• Very fast tacking</li> <li>• Temporary and permanent bonds</li> <li>• Heavy body web spray with low soak in on porous or irregular surfaces</li> <li>• Bonds polystyrene without degrading the surface</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds; insulation to walls</li> <li>• <b>Marine:</b> attach carpeting and insulation</li> <li>• <b>Construction:</b> bond EPS insulation to wood and concrete; attach fabric and foam to walls for noise abatement; bond rubber matting to metal concrete forms for pre-cast; bond insulation to metal pipes and boilers</li> <li>• <b>Urethane foam</b> to wood, metal, and plastic</li> </ul>
	Polystyrene Foam Insulation 78 ET*	<ul style="list-style-type: none"> <li>• Extended tack range for temporary or permanent bonds</li> <li>• Bonds polystyrene without degrading the surface</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Store displays:</b> bond fabric, felt, plastic to soft foam, FRP, ABS, wood, or metal</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds; insulation to walls</li> <li>• <b>Construction:</b> bond EPS insulation to wood and concrete</li> <li>• <b>Appliances:</b> attach EPS insulation to metal in refrigerators</li> <li>• <b>HVAC:</b> attach insulation to pipes and ductwork</li> </ul>
High Performance, High Strength, High Temperature	Hi-Strength Postforming 94 CA* 	<ul style="list-style-type: none"> <li>• Postformable high strength</li> <li>• Low telegraphing spray pattern</li> <li>• SCAQMD Rule 1168 Compliant Contact Adhesive</li> <li>• Reduced open time</li> <li>• MACT Compliant; HAPs free</li> <li>• Greenguard™ Indoor Air Quality Certified Safe for Use in Schools</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Fixtures:</b> bond HPL to wood and steel</li> </ul>
	Hi-Strength Laminating 92	<ul style="list-style-type: none"> <li>• High strength</li> <li>• High temperature and creep resistance</li> <li>• MACT compliant; HAPs free</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Motor homes:</b> bond HPL to wood and steel</li> <li>• <b>Marine:</b> bond HPL to wood and steel; attach carpeting and insulation</li> <li>• <b>Construction:</b> attach plastic cornerbead and expansion joints to drywall; laminate drywall to drywall</li> </ul>





3M™ Scotch-Weld™ Cylinder Spray Adhesive	Differentiating Features	Application Ideas for Markets and Substrates
FoamFast Non-flammable 74 NF*	<ul style="list-style-type: none"> <li>• Fast tacking, quickly reaches foam-tearing strength</li> <li>• Soft, non-dimpling glue line</li> <li>• Non-flammable solvent and propellant</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Furniture:</b> bond soft foam to itself, fabric wood, and metal</li> <li>• <b>Bedding:</b> bond foam, felt, or fabric</li> <li>• <b>Motor homes:</b> bond foam or fabric for interior applications</li> </ul>
Hi-Strength Non-flammable 98 NF*	<ul style="list-style-type: none"> <li>• High solids, high coverage</li> <li>• Fast drying</li> <li>• Permanent bonds</li> <li>• Non-flammable solvent and propellant</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL to wood for countertops, cabinets, shelves, furniture, and displays</li> <li>• <b>Motor homes:</b> bond carpet to wood, metal, or FRP</li> </ul>
Fastbond™ 30 NF 	<ul style="list-style-type: none"> <li>• Greenguard™ Indoor Air Quality Certified Safe for Use in Schools</li> <li>• Water-based adhesive</li> <li>• Very high solids, very high coverage</li> <li>• Excellent heat resistance</li> <li>• Postformable</li> <li>• Non-flammable solvent and propellant</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL, particle board, plywood and plastic laminate</li> <li>• <b>Appliances:</b> attach EPS insulation to metal in refrigerators</li> <li>• <b>Marine:</b> secure rubber flooring and headliners</li> </ul>

Non Flammable

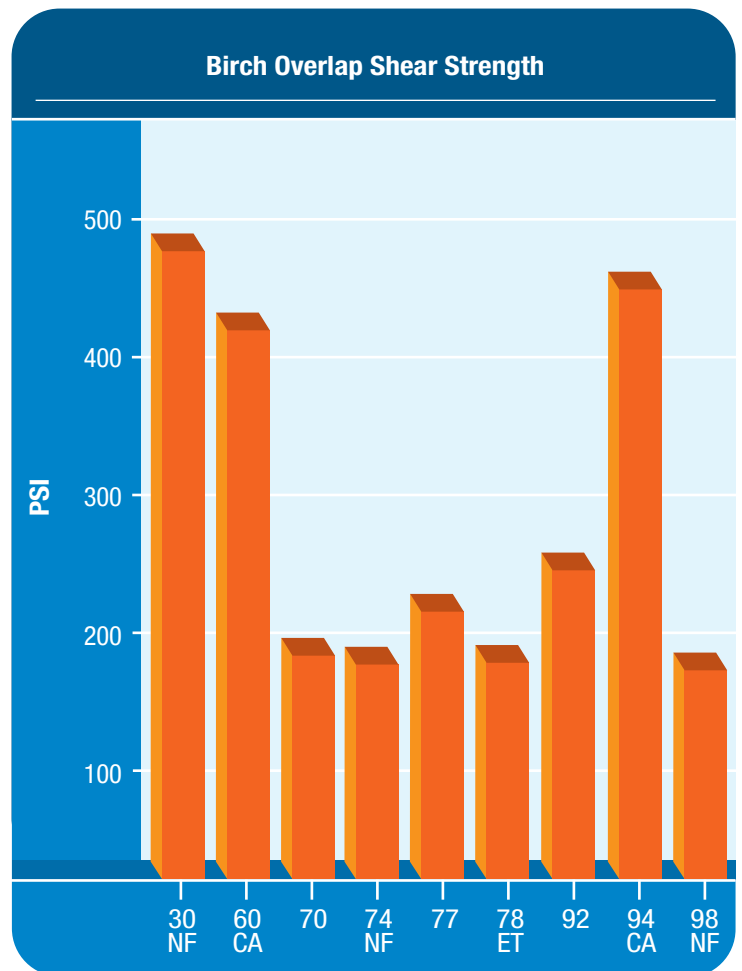
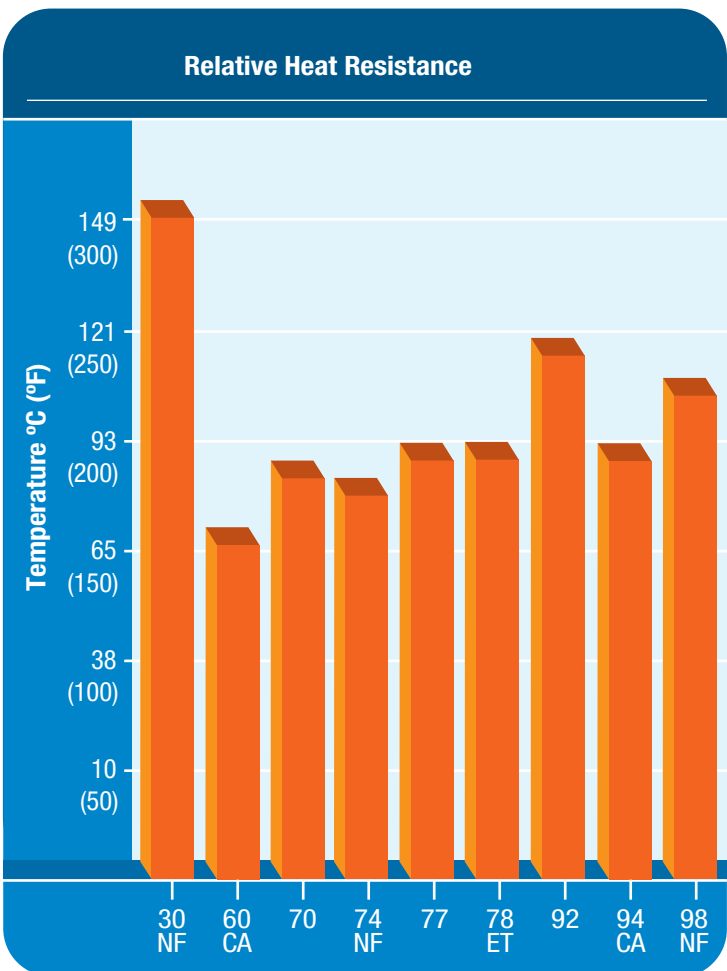
\* CA: California compliant  
 ET: Extended Tack  
 NF: Non Flammable

# Product Information and Packaging

Product	Flammable Adhesive/Propellant	Solids % w/propellant	Solids % w/o propellant	California Compliant	VOCs (g/liter)	Dry Time (minutes)	Open Time (minutes)
Fastbond™ 30 NF	◆ Yes/Yes	21	41	No	544	1-4	1-60
General Purpose 60 CA*	◆ Yes/Yes	43	42	Yes	>80	2-5	2-60
HoldFast 70	◆ Yes/Yes	21	41	No	544	1-4	1-60
FoamFast Non-Flammable 74 NF*	◆ No/No	22	28	No	248	1-2	1-60
Super 77™	◆ Yes/Yes	27	36	No	534	0.25-0.5	1-30
Polystyrene Foam Insulation 78 ET*	◆ Yes/Yes	17	31	No	570	1-5	1-60
Hi-Strength Laminating 92	◆ Yes/Yes	23	34	No	654	1-4	1-20
Hi-Strength Postforming 94 CA*	◆ Yes/Yes	28	28	Yes	79	1-5	1-15
Hi-Strength Non-Flammable 98 NF*	◆ No/No	20	25	No	254	1-2	1-60

\*Ingredients when dried after application are listed as indirect food additives under FDA regulation 21 CFR 175.105

**Note:** This technical information and data should be considered representative or typical only and should not be used for specification purposes.

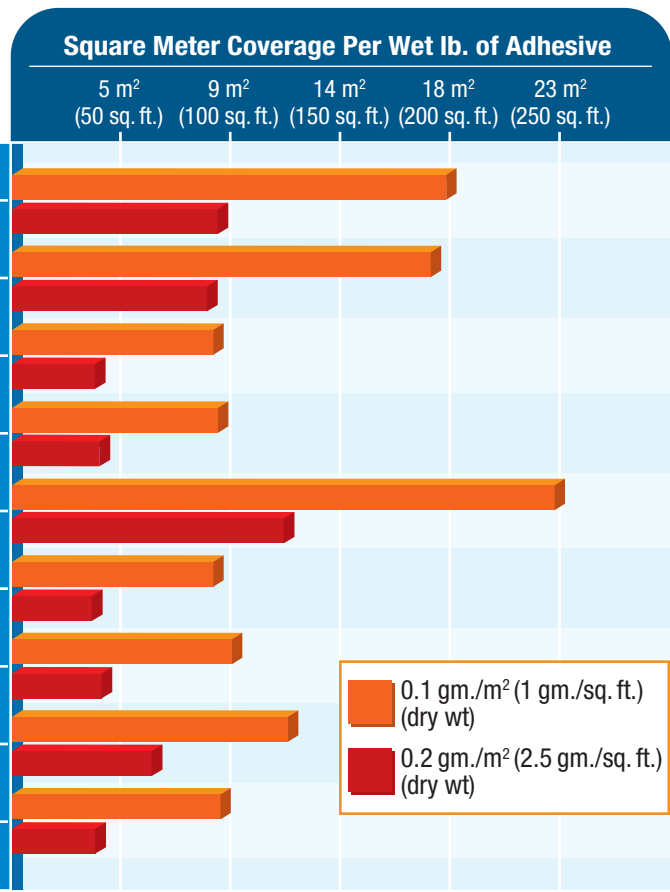


**Note:** This technical information and data should be considered representative or typical only and should not be used for specification purposes.

	Temperature Rating	Spray Pattern	MACT Compliant	Colour
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	No	Clear or Orange
	High	Mist	Yes	Clear or Red
	High	Web	No	Green
	Very High	Web	Yes	Clear or Red
	High	Pebble	Yes	Clear or Red
	High	Web	No	Clear or Red



Size Availability



Note: This technical information and data should be considered representative or typical only and should not be used for specification purposes.

Selection Guide for High Performance, High Temperature Laminating Adhesives.	Starting Product	Added Features	Product
	<b>Hi-Strength Laminating 92</b> High temperature and creep resistance	Postformable, CA compliant, reduced open time, low telegraphing	94 CA
		Water-based non-flammable adhesive/ non-flammable propellant	30 NF

Product	Cylinder Sizes				Bulk	
	Mini	Large	Intermediate	Jumbo	19 L (5-gal)	208 L (55-gal)
30 NF		●				
60 CA		●	●	●		
70		●	●	●		
74 NF		●				
77		●				
78 ET		●		●		
92		●	●	●		
94 CA	●	●	●	●	●	●
98 NF	●	●	●	●		

# Equipment simplification with 3M™ Scotch-Weld™ Cylinder Spray Adhesives



Compare the equipment and tools needed for a typical compressor and drum operation (above) with the savings and simplicity of the 3M™ Scotch-Weld™ Cylinder Spray Adhesives system (at right).



## 3M™ Scotch-Weld™ Cylinder Spray

### Adhesive Equipment & Accessories

Cylinder Adhesive Applicator (includes 9501 Tip)

Cylinder Adhesive Applicator H (includes 4001 Tip)

Cylinder Adhesive 9501 Spray Tip

Cylinder Adhesive 4001 Spray Tip

Cylinder Adhesive 6501 Spray Tip

Cylinder Adhesive QSS Spray Tip

Cylinder Adhesive 250050 Spray Tip

Cylinder Adhesive 650050 Spray Tip

Cylinder Adhesive Hose Swivel

Cylinder Adhesive T-Fitting

Cylinder Adhesive 1.8 m (6-Foot) Hose

Cylinder Adhesive 3.7 m (12-Foot) Hose

Cylinder Adhesive 7.6 m (25-Foot) Hose

Cylinder Adhesive 15 m (50-Foot) Hose

**PRODUCT USE:** All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

**WARRANTY AND LIMITED REMEDY:** 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. **3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE.** User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If the 3M product is defective, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to repair or replace the product or refund the purchase price. **LIMITATION OF LIABILITY:** Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.



Industrial and Transportation Business  
Industrial Adhesives and Tapes Division

3M Canada  
London, Ontario N6A 4T1  
1 800 364-3577  
www.3M.com/adhesives

Please recycle. Printed in Canada.  
© 2009, 3M. All rights reserved.  
3M, Scotch-Weld, Super 77 and Fastbond are  
trademarks of 3M. Used under license in Canada.  
0807-2778 E-AC BA-09-12967