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 goes 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.
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

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

<table>
<thead>
<tr>
<th>Substrate</th>
<th>Aerosol</th>
<th>Cylinder</th>
<th>Solvent-Based Bulk</th>
<th>Water-Based Bulk</th>
</tr>
</thead>
<tbody>
<tr>
<td>Paper, Cardboard</td>
<td>27, 77</td>
<td>77</td>
<td>77</td>
<td>49</td>
</tr>
<tr>
<td>Fabric, Felt, Fiberglass, Cork</td>
<td>20, 27, 77</td>
<td>70, 77, 78ET</td>
<td>77</td>
<td>49</td>
</tr>
<tr>
<td>Flexible Foam: Urethane, Latex</td>
<td>24, 74</td>
<td>74, 74NF</td>
<td>74</td>
<td>100NF</td>
</tr>
<tr>
<td>Rigid Foam: Polystyrene, Beadboard</td>
<td>78</td>
<td>70, 78ET</td>
<td>78</td>
<td>30NF</td>
</tr>
<tr>
<td>High Pressure Laminates, Melamine</td>
<td>20, 90, 94ET</td>
<td>94CA, 94ET</td>
<td>94CA, 94ET</td>
<td>30NF</td>
</tr>
<tr>
<td>Wood, MDF, Particle Board</td>
<td>20, 90, 94ET</td>
<td>94CA, 94ET</td>
<td>94CA, 94ET</td>
<td>30NF</td>
</tr>
<tr>
<td>Metal: Steel, Aluminum</td>
<td>20, 90</td>
<td>90, 94CA, 94ET</td>
<td>90, 94CA, 94ET</td>
<td>30NF</td>
</tr>
<tr>
<td>Plastics: ABS, PVC, Phenolic, Acrylic</td>
<td>20, 90</td>
<td>90, 94CA, 94ET</td>
<td>90, 94CA, 94ET, 4491</td>
<td>30NF</td>
</tr>
<tr>
<td>FRP: Fiberglass Reinforced Plastic</td>
<td>20, 90</td>
<td>70, 90, 94CA, 94ET</td>
<td>90, 94CA, 94ET</td>
<td>30NF</td>
</tr>
<tr>
<td>Painted Surfaces</td>
<td>20, 90</td>
<td>90, 94CA, 94ET</td>
<td>90, 94CA, 94ET</td>
<td>30NF</td>
</tr>
<tr>
<td>Rubbers: Nitrile, Neoprene, SBR</td>
<td>20, 80, 90</td>
<td>70, 90, 94CA, 94ET</td>
<td>90, 94CA, 94ET, 4491</td>
<td>N/A</td>
</tr>
<tr>
<td>Plasticized Vinyl</td>
<td>80</td>
<td>NA</td>
<td>4491</td>
<td>4224NF</td>
</tr>
<tr>
<td>Product</td>
<td>Heat Resistance</td>
<td>Shear Strength, psi</td>
<td>Non-Flammable</td>
<td>Bonding Range – One Surface</td>
</tr>
<tr>
<td>---------</td>
<td>-----------------</td>
<td>---------------------</td>
<td>---------------</td>
<td>-----------------------------</td>
</tr>
<tr>
<td>20</td>
<td>210°F ≤ 300</td>
<td>1-10 min</td>
<td>17</td>
<td>1-15 min</td>
</tr>
<tr>
<td>24</td>
<td>170°F ≤ 300</td>
<td>30 sec-15 min</td>
<td>17</td>
<td>30 sec-30 min</td>
</tr>
<tr>
<td>27</td>
<td>140°F ≤ 200</td>
<td>15 sec-5 min</td>
<td>21</td>
<td>15 sec-10 min</td>
</tr>
<tr>
<td>30NF</td>
<td>300°F ≤ 400</td>
<td>NR</td>
<td>49</td>
<td>15 min-4 hr</td>
</tr>
<tr>
<td>49</td>
<td>250°F 50</td>
<td>30+ days</td>
<td>55</td>
<td>30+ days</td>
</tr>
<tr>
<td>60CA</td>
<td>170°F ≤ 200</td>
<td>1-60 min</td>
<td>42/43</td>
<td>1-60 min</td>
</tr>
<tr>
<td>70</td>
<td>190°F ≤ 200</td>
<td>1-60 min</td>
<td>21/26</td>
<td>1-60 min</td>
</tr>
<tr>
<td>72</td>
<td>170°F ≤ 200</td>
<td>NR</td>
<td>15</td>
<td>1-8 hours</td>
</tr>
<tr>
<td>74</td>
<td>180°F ≤ 200</td>
<td>30 sec-15 min</td>
<td>22/36</td>
<td>30 sec-15 min</td>
</tr>
<tr>
<td>74CA</td>
<td>180°F ≤ 200</td>
<td>30 sec-15 min</td>
<td>23</td>
<td>30 sec-15 min</td>
</tr>
<tr>
<td>74NF</td>
<td>210°F ≤ 300</td>
<td>1-60 min</td>
<td>24</td>
<td>1-60 min</td>
</tr>
<tr>
<td>75</td>
<td>110°F ≤ 50</td>
<td>15 sec-1 min</td>
<td>9</td>
<td>15 sec-1 hour</td>
</tr>
<tr>
<td>76</td>
<td>230°F ≤ 200</td>
<td>1-10 min</td>
<td>13.5</td>
<td>1-60 min</td>
</tr>
<tr>
<td>77</td>
<td>150°F ≤ 300</td>
<td>15 sec-15 min</td>
<td>25/27/36</td>
<td>15 sec-15 min</td>
</tr>
<tr>
<td>77CA</td>
<td>150°F ≤ 300</td>
<td>15 sec-15 min</td>
<td>19</td>
<td>15 sec-15 min</td>
</tr>
<tr>
<td>78</td>
<td>190°F ≤ 300</td>
<td>1-5 min</td>
<td>19</td>
<td>1-15 min</td>
</tr>
<tr>
<td>78ET</td>
<td>200°F ≤ 200</td>
<td>1-5 min</td>
<td>17</td>
<td>1-60 min</td>
</tr>
<tr>
<td>78HHT</td>
<td>250°F ≤ 200</td>
<td>1-5 min</td>
<td>17</td>
<td>1-60 min</td>
</tr>
<tr>
<td>80</td>
<td>300°F ≤ 600</td>
<td>NR</td>
<td>80</td>
<td>3-30 min</td>
</tr>
<tr>
<td>90</td>
<td>250°F ≤ 600</td>
<td>NR</td>
<td>13/23</td>
<td>1-10 min</td>
</tr>
<tr>
<td>90CA</td>
<td>250°F ≤ 600</td>
<td>NR</td>
<td>23</td>
<td>1-10 min</td>
</tr>
<tr>
<td>92</td>
<td>250°F N/A</td>
<td>NR</td>
<td>23/34</td>
<td>1-20 min</td>
</tr>
<tr>
<td>94CA</td>
<td>210°F ≤ 500</td>
<td>NR</td>
<td>23</td>
<td>1-30 min</td>
</tr>
<tr>
<td>94ET</td>
<td>200°F ≤ 300</td>
<td>NR</td>
<td>21/25</td>
<td>1-60 min</td>
</tr>
<tr>
<td>98NF</td>
<td>240°F ≤ 300</td>
<td>1-5 min</td>
<td>21/24</td>
<td>1-60 min</td>
</tr>
<tr>
<td>100NF</td>
<td>230°F ≤ 300</td>
<td>30 sec-20 min</td>
<td>47</td>
<td>30 sec-20 min</td>
</tr>
<tr>
<td>1000NF</td>
<td>300°F ≤ 400</td>
<td>1-5 min</td>
<td>49</td>
<td>1-10 min</td>
</tr>
<tr>
<td>1357</td>
<td>300°F ≤ 600</td>
<td>NR</td>
<td>25</td>
<td>5-30 min</td>
</tr>
<tr>
<td>2000NF</td>
<td>300°F ≤ 400</td>
<td>NR</td>
<td>49</td>
<td>30 sec-2 hr</td>
</tr>
<tr>
<td>4224NF</td>
<td>120°F ≤ 200</td>
<td>30+ days</td>
<td>41</td>
<td>30+ days</td>
</tr>
<tr>
<td>4491</td>
<td>300°F ≥ 500+</td>
<td>2-10 min</td>
<td>24</td>
<td>2-20 min</td>
</tr>
</tbody>
</table>

* Solid weight percent can vary by format.
** Meets applicable 2017 California Air Resource Board VOC limits for mist and web spray adhesives.
## Specifications and Ordering Information

### 3M® Heavy Duty 20 Spray Adhesive
- **Economical, fast-grabbing, industrial-grade adhesive**
- **Variable-width spray pattern**
- **Forms powerful, permanent bonds to concrete, wood, MDF, laminates and polyethylene**

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerosol</td>
<td>1 Gallon Pail</td>
<td>12.23 oz</td>
<td>00 21200 21985 7</td>
</tr>
<tr>
<td></td>
<td>5 Gallon Pail</td>
<td>270 Gallon Pail</td>
<td>00 21200 31841 4</td>
</tr>
<tr>
<td></td>
<td>Open Head Steel Drum</td>
<td>5 Gallon Pail</td>
<td>00 21200 30023 3</td>
</tr>
</tbody>
</table>

### 3M® Fastbond™ Contact Adhesive 30NF
- **Water-dispersed, high strength contact adhesive**
- **Long bonding range with high immediate bond strength**
- **Bonds most foamed plastics, plastic laminate, wood, plywood, wood veneer, canvas and more**

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerosol</td>
<td>1 Gallon Pail</td>
<td>11.76 oz</td>
<td>00 21200 21981 2</td>
</tr>
<tr>
<td></td>
<td>5 Gallon Pail</td>
<td>5 Gallon Pail</td>
<td>00 21200 21982 9</td>
</tr>
<tr>
<td></td>
<td>Open Head Steel Drum</td>
<td>5 Gallon Pail</td>
<td>00 21200 21983 6</td>
</tr>
</tbody>
</table>

### 3M® Hi-Strength 90 Spray Adhesive
- **High strength and fast-tack adhesive performance**
- **Bonds to concrete, wood, MDF, laminates and polyethylene**
- **High temperature and moisture resistance**

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerosol</td>
<td>Clear</td>
<td>12.23 oz</td>
<td>00 67008 86235 0</td>
</tr>
<tr>
<td></td>
<td>Inverted</td>
<td>1176 oz</td>
<td>00 21200 30023 3</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cylinder</td>
<td>Large</td>
<td>00 21200 41554 8</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Intermediate</td>
<td>00 21200 25774 2</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Jumbo</td>
<td>00 21200 25775 9</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bulk</td>
<td>5 Gallon Pail</td>
<td>00 21200 31581 7</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Open Head Steel Drum</td>
<td>00 21200 31582 4</td>
<td></td>
</tr>
</tbody>
</table>

### 3M® Hi-Strength 94CA Spray Adhesive
- **Unique, non-telegraphing spray pattern delivers postformable strength**
- **High solids maximize coverage**
- **Low VOC, SCAGMQ Rule 1188 compliance**

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerosol</td>
<td>Clear</td>
<td>12.23 oz</td>
<td>00 67015 31577 0</td>
</tr>
<tr>
<td></td>
<td>Inverted</td>
<td>1176 oz</td>
<td>00 21200 31578 7</td>
</tr>
</tbody>
</table>

### 3M® Hi-Strength 94ET Spray Adhesive
- **Unique, non-telegraphing spray pattern delivers postformable strength**
- **Long open time**
- **Meets CARB/OTC VOC requirements, SCAGMQ Rule 1188 compliance, helps contribute to LEED® credits, and low VOC**

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerosol</td>
<td>Clear</td>
<td>12.23 oz</td>
<td>00 67015 97978 8</td>
</tr>
</tbody>
</table>

## 3M® Neoprene High Performance Contact Adhesive 1357
- **High performance contact adhesive with long bonding range and excellent initial strength**
- **Resists heat and continuous load stress**
- **Meets MIL-A-23166A, MMM-A-121 credits**

### 3M® Fastbond™ Contact Adhesive 2000NF
- **A water-dispersed, high solids activated adhesive**
- **Immediate bonding and handling strength without forced drying**

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerosol</td>
<td>Blue</td>
<td>12.23 oz</td>
<td>00 21200 21989 4</td>
</tr>
<tr>
<td></td>
<td>Light Orange</td>
<td>1176 oz</td>
<td>00 21200 22595 5</td>
</tr>
</tbody>
</table>

### 3M® Multi-Purpose 27 Spray Adhesive
- **Versatile, economical, industrial-grade adhesive**
- **Bonds paper, fabrics, cardboard, soft foams and more**
- **Mist spray pattern and fast-tack adhesive performance**

<table>
<thead>
<tr>
<th>Form</th>
<th>Unit</th>
<th>Weight</th>
<th>Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerosol</td>
<td>Clear</td>
<td>12.23 oz</td>
<td>00 67015 97967 0</td>
</tr>
</tbody>
</table>

---

**Note:** The above table provides a structured summary of the adhesive specifications and ordering information provided in the document. Each entry includes the form type, unit, weight, and container details.
3M® Fastbond™ Insulation Adhesive 49
- Fast-tack, high performance, water-based, pressure-sensitive adhesive
- Ideal for lightweight materials such as fiberglass, felt, shoddy and paper
- Low VOC content

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

3M® Foam Fast 74 Spray Adhesive
- Fast-tack, industrial-grade adhesive
- Aggressive tack with foam-tearing strength
- Bonds foam to substrates such as fabric, wood and more

3M® Non-Flammable Fast 74NF Cylinder Spray Adhesive
- Non-flammable, fast-tack adhesive
- Soft, non-dimpling bond lines and foam-tearing strength
- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more

3M® Polyurethane Insulation 78 Adhesive
- High solids adhesive formulated for expanded polyurethane and foam insulations
- Bonds without cavitating foams
- Fast grabbing, fast drying formula

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

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

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

3M® HoldFast 70 Spray Adhesive
- Extremely versatile, fast-tack, industrial-grade adhesive
- Unique wide-web spray pattern with heavy body and low soak-in formula
- Bonds polystyrene without degrading the surface

3M® Foam & Fabric 24
- Fast-tack, industrial-grade adhesive
- Aggressive tack with foam-tearing strength
- Bonds foam to substrates such as fabric, wood and more

3M® Pressure Sensitive Spray Adhesive 74
- High solids adhesive formulated for expanded polyurethane and foam insulations
- Bonds hard-to-hold surfaces such as plastics to rubber, fabric, cardboard, wood, metal and more
- Variable-width lace spray pattern

3M® Repositionable 75 Spray Adhesive
- Adhesive holds strong yet removes easily for repeated use
- Low soak-in formula
- Bonds lightweight materials without damage and prevents wrinkling when bonded

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

72CA
- Clear
- Red
- Bulk
- 5 Gallon Pail
- 5 Gallon Box
- Open Head Steel Drum
- Poly Drum
- Poly Tote
- 255 Gallon EZ Drain Tote
- 100 Gallon EZ Tote
- 100 Gallon 56520 5

74
- Clear
- Orange
- Aerosol
- 00 5111 07862 4
- Cylinder
- Large 00 48011 61691 9
- Intermediate 00 48011 61692 6
- Jumbo 00 48011 61690 6
- Bulk
- 5 Gallon Pail 00 5111 53590 9
- Closed Head Steel Drum 00 5111 35590 9

74CA
- Clear
- Orange
- Aerosol
- 00 5111 50345 9
- Cylinder
- Large 00 48011 61500 2
- Intermediate 00 48011 61501 9
- Jumbo 00 48011 61502 6
- Bulk
- 5 Gallon Pail 00 5111 63835 7
- Closed Head Steel Drum 00 5111 63934 0

77
- Clear
- Orange
- Aerosol
- 00 5111 97967 9
- 00 5111 97968 7
- Cylinder
- Large 00 21200 49899 7
- Intermediate 00 5111 25741 4
- Jumbo 00 5111 16854 5
- Bulk
- 5 Gallon Pail 00 21200 43793 9
- Open Head Steel Drum 00 21200 43813 4
Specifications and Ordering Information

3M® Polyisylone Insulation 78ET Adhesive
- Bonds polyisylone with no surface degradation
- Long tack time extends working time
- Uniform spray pattern ensures fast and easy application

3M® Hi-Temperature Polyisylone Insulation 78HT Adhesive
- Permanently bonds to polyisylone foam and other materials
- Will not degrade the foam
- Sprays with a lace pattern optimized for foam

3M® Rubber and Vinyl 80 Spray Adhesive
- High strength adhesive provides strong bonds for rubber and vinyl
- High temperature and plasticizer resistant
- Fast-setting contact adhesive produces rapid results

3M® Fast Tack Water Based Adhesive 1000NF
- Quick bond in a one-part adhesive
- High coverage with potential for one surface application
- Bonds a wide variety of substrates with high temperature resistance
- Meets California and OTC state VOC requirements and helps contribute to LEED® credits

3M® Fastbond™ Spray Activator 1
- Water-dispersed formula is low VOC
- High coverage with mist spray application
- Spray activator compatible with 100NF and 2000NF

3M® Fastbond™ Case Sealing Adhesive
- Permanently seals closure flaps to protect corrugated shipping containers
- Fast-tack adhesive with low soak-in
- Offers heat- and moisture-resistance for long-lasting durability

3M® Shipping-Mate® Case Sealing Adhesive
- Ideal for palletizing, labeling and other packaging applications
- Bonds lightweight materials such as felt, cork, cardboard, paper, wood, plastic wrap and other common substrates used in shipping and packaging

3M® Adhesive Remover
- Removes grease, oil, ink and most adhesives without the need to soak
- Provides mold-release agents
- Removes adhesive without damaging the surface underneath

Industrial Cleaner
- Removes grease, oil, ink and most adhesives without the need to soak
- Provides mold-release agents
- Removes adhesive without damaging the surface underneath

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

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