

# 3M

## Hi-Tack Pressure Sensitive Adhesive

### 3794

Technical Data

July, 2016

#### Product Description

3M™ Hot Melt Adhesives are 100% solids, thermoplastic resins that become fluid when heated and quickly wet the bonding surface. They cool and reach bond strength in seconds, keeping production flowing by eliminating clamps, fixturing and drying, and saving time energy and space.

3M™ Hi-Tack Pressure Sensitive Adhesive 3794 bonds to a wide variety of substrates such as wood, corrugated, fabrics and foams, plastics, metal and other lightweight materials.

#### 3M™ Hi-Tack Pressure Sensitive Adhesive 3794

Sprayable and extrudable. Aggressive tack bonds well to most surfaces. Tackiness remains after cooling, allowing bond formation long after dispensing. Offers good low temperature flexibility.

#### Features

- 100% Solids, no VOCs
- Easy to use
- Extra-long open time
- Adhesive obtains strength in seconds
- Can be sprayed, extruded or roll coated
- Hi tack PSA provides tack even after cooling

#### Typical Physical Properties

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

	3M™ Hot Melt Adhesive
	3794
Color (solid)	Light Tan
Density (g/cm <sup>3</sup> )	0.94
Flashpoint (°F) <sup>1</sup>	> 400

(1) Cleveland Open Cup ASTM D92-72

#### Directions for Use

**1. Surface Preparation:** Surfaces must be clean, dry and dust free. Wipe with a solvent such as isopropyl alcohol for plastic substrates to aid in removing oil and dirt.\*

**\*Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

**2. Application:** 3M™ Hot Melt Adhesive 3794 is designed for bulk applicators.

Note: Plastic wrap encasing the chub DOES NOT need to be removed. Entire chub can be deposited into melting equipment. Wrap has no effect on process or performance.

**3. Coverage:** 3M™ Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.

**4. Set time:** After the bond is made, 3M™ Hot Melt Adhesive 3794 immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates, however 3M™ Hot Melt Adhesive 3794 will remain tacky after cooling.

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### Typical Application Properties

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	3M™ Hot Melt Adhesive
	3794
Application Temperature <sup>1</sup>	325-385°F/ 162-196°C
Viscosity (CPS) <sup>2</sup>	15,000 @ 325°F
Open Time (seconds) <sup>3</sup>	> 60
Available sizes/forms	Chubs (1.1 lb)

(1) Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life

(2) Brookfield Thermocel Viscometer

(3) For 1/8" semicircular bead, Douglas Fir to Douglas Fir

### Typical Performance Properties

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

	3M™ Hot Melt Adhesive
	3794
Heat Resistance <sup>1</sup>	120°F/ 49°C
Ball & Ring Melt Point <sup>2</sup>	224°F/ 107°C
Peel Strength <sup>3</sup>	16 pwi
FDA Indirect Food Contact <sup>4</sup>	21 CFR 175.105

(1) Highest temperature that the adhesive will support a 2 psi dead load

(2) ASTM E28-67

(3) Canvas to Douglas Fir

(4) Permitted for indirect food contact subject to the limitations in applicable CFR section(s)

### Storage

Store product below 120°F (49°C).

### Shelf Life

When stored at the recommended conditions, this product has a shelf life of 2 years after 3M ships the product to a customer or distributor.

### 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

### 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

Unless stated otherwise in 3M's product literature, packaging inserts or product packaging for individual products, 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. Individual products may have additional or different warranties as stated on product literature, package inserts or product packages. 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 within the warranty period, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.

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### Limitation of Liability

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ISO 9001:2000

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This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



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