



Hi-Tack Composite Spray 71

Technical Bulletin

February 2018

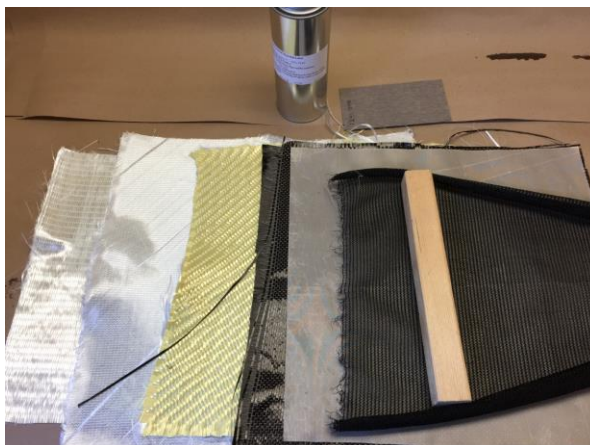
3M IATD intends to form an easily understood product portfolio of spray adhesives used in the dry lay-up (scrim to mold lamination) step used in the resin infusion molding process. A well-known current product, 3M™ Super 77™ Multipurpose Spray Adhesive, has been used for decades in this application and will continue to be in the future. To service the growing the infusion molding industry, additional products and features can aid a customer to choose a product that will be a benefit to the manufacturing process or the final performance. The purpose of this bulletin is to introduce 3M IATD's additional offering to that product portfolio.

3M™ Hi Tack Composite Spray Adhesive 71 is ideal for use in a wide variety of composite production applications. It is ideally suited to the dry lay-up & resin infusion process to securely hold fiber reinforcements and fabrics in place during the lay-up process. The optimized formula has been designed to have little to no intrusion in the infusion process to reduce the risk of delamination. The formula will work with most resin systems including: polyester, vinyl ester, & epoxy. The quick-to-tack formula has been finely tuned to allow faster lay up of fiber sheets with low soak-in, leading to faster bonding of layered composite assemblies. It has a high adhesive solids content for exceptional coverage that makes it very efficient so you can use less to do more. The adhesive will bond fiber, fabric, wood and much more. Available in a green color adhesive that provides visual control of how much adhesive is being applied so you can spray the ideal coat weight for your job. This provides operators less chance of applying too much adhesive and therefore creates less rework and waste in your production. This adhesive has been designed to maximize your composite production and assemblies.

3M™ Hi Tack Composite Spray Adhesive 71 Features:

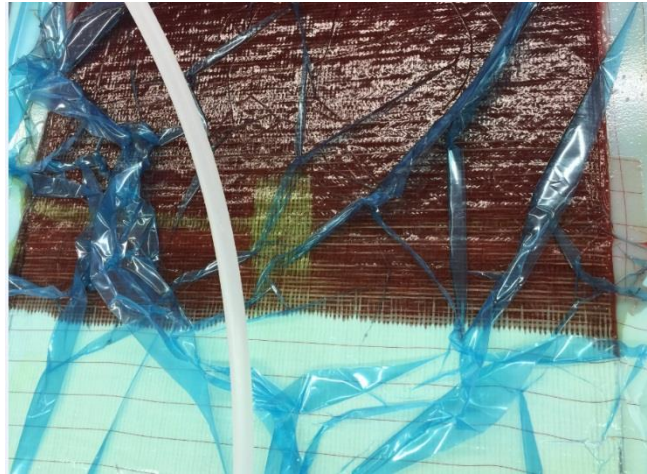
- Ideal for all materials used in the composite dry lay-up & resin infusion molding process.

Right: Typical infusion composite materials – Glass fiber, Kevlar, Carbon Fiber, Peel Ply, Transfer Mesh.

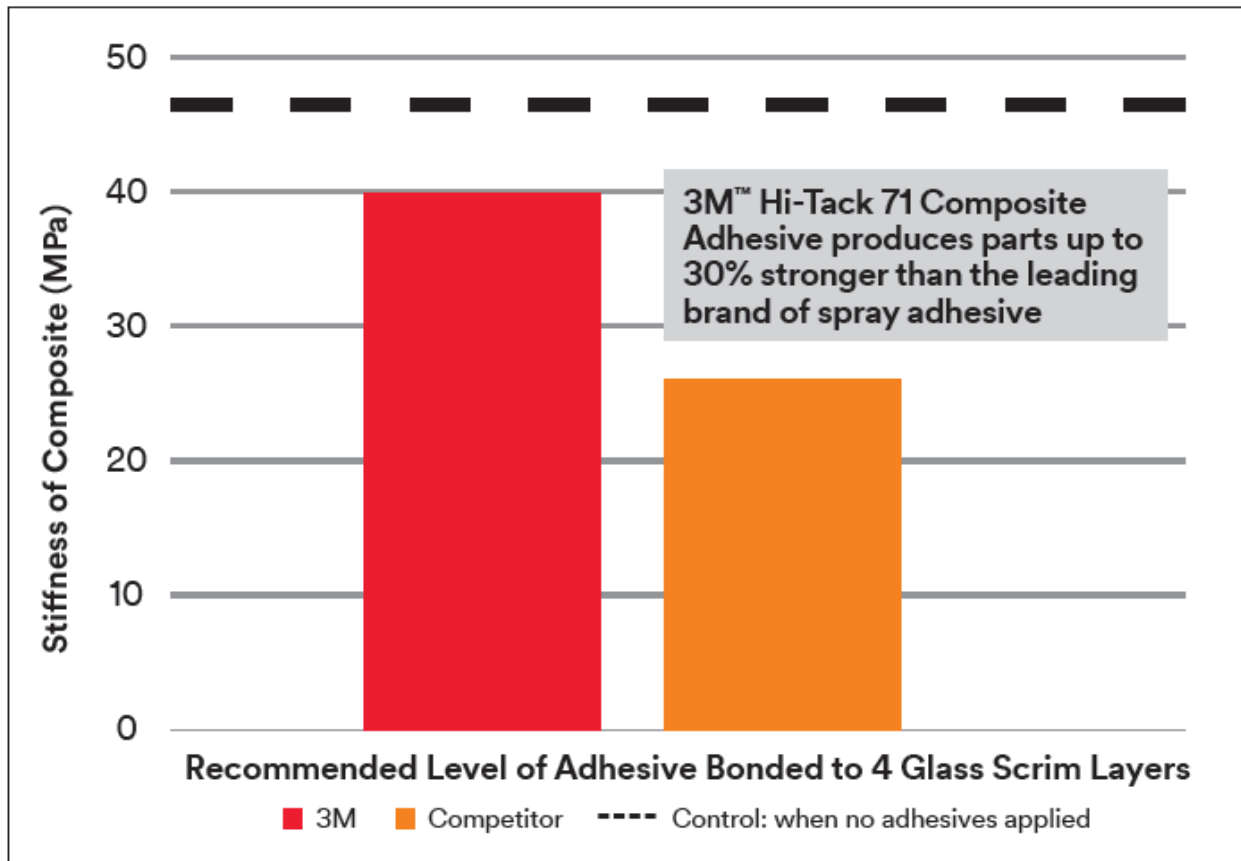


- Little to no intrusion during the resin infusion process

Right: Resin migration not slowed due to excess adhesive. In this resin infusion of a test panel with 5 layers of glass fiber, layered horizontally. 3M™ Hi Tack Composite Spray Adhesive 71 was intentionally sprayed heavily in the center and two lateral strips (green patch and lines) to show effect on resin flow thru the glass fiber.



- 3M™ Hi Tack Composite Spray Adhesive 71 compatible with the infused resin



- 3M™ Hi Tack Composite Spray Adhesive 71 saves time - get the job done faster & do more jobs. Spraying at the suggested levels of 5g to 1.5sqm ensure low soak-in, which ensure efficient coverage on the applied surface.
- Versatile adhesive beyond infusion molding. Bonds: Fiber, Fabric, Wood, Laminate, Metal & more. Strong tack for a wide variety of composite production applications.

- Available in Clear or Green for visual control of application & adhesive coat weight

Right: 3M™ Hi Tack Composite Spray Adhesive 71 Clear and Green holding 4 layers of glass fiber vertically. Approximately 10 grams/sq meter. Immediate bond.



- Soon available in Cylinder & Aerosol systems

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