### Questions to Ask for Product Selection

1. What materials do you want to bond?
2. Do you require a structural or non-structural bond?
3. Are you willing to prepare the surfaces?
4. What types of stresses will the bond be subjected to?
5. What types of environmental conditions will be involved?
6. Do you need repositioning time?
7. What is the preferred bonding range?
8. What application method is appropriate for your production requirements?
9. What is the present bonding or joining method?

### Spray Adhesives

#### Multipurpose

**3M Super 77**
- **3M Super 77 Multipurpose Spray Adhesive**
  - High tack, high coverage and low soak-in formula
  - Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
  - Bonds in 15 seconds
  - Low soak-in and long open time

**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

**3M Foam Fast 74**
- **Spray Adhesive**
  - Fast-tacking adhesive with soft, non-dimpling bond lines
  - Immediate foam-tearing strength
  - Ideal for bonding flexible urethane or latex foam to many substrates

#### Heavy Duty

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

**3M Hi-Strength 90 CA Spray Adhesive – Low VOC <25%**
- **Spray Adhesive**
  - Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more
  - Soft, non-dimpling glue lines

**3M Foam Fast 74 CA Spray Adhesive – Low VOC <25%**
- **Spray Adhesive**
  - Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more

#### Foam & Fabric

**3M Foam Fast 74**
- **Spray Adhesive**
  - Fast-tacking adhesive with soft, non-dimpling bond lines
  - Immediate foam-tearing strength
  - Ideal for bonding flexible urethane or latex foam to many substrates

#### Specialty

**3M Polystyrene Insulation 78**
- **Spray Adhesive**
  - High solids adhesive formulated for expanded polystyrene and foam insulations
  - Bonds without cavitating foams
  - Fast grabbing, fast drying formula

**3M Rubber and Vinyl Insulation 78**
- **Spray Adhesive**
  - High solids adhesive provides strong bonds for rubber and vinyl
  - High temperature and plasticizer resistant
  - Fast-setting contact adhesive produces rapid results

#### Maintenance & Cleaning

**3M Adhesive Remover**
- Removes adhesive without damaging the surface underneath

**3M Silicone Lubricant**
- Reliable lubricant can be used in a wide variety of applications
  - Fast drying to maintain productivity
  - Long lasting and non-staining to keep work surfaces clean

**3M Industrial Cleaner**
- Removes grease, oil, and ink most adhesives without the need to soak

**3M 5-Way Penetrant**
- Helps free rusted and frozen bolts, nuts and more
  - Displaces moisture and “dries out” electronics
  - Light-duty lubricant works well with delicate precision instruments

### Low VOC Spray Adhesives

#### Multipurpose

**3M Super 77**
- **3M Super 77 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

#### Heavy Duty

**3M Hi-Strength 90 CA Spray Adhesive – Low VOC <25%**
- High strength and fast-tack adhesive performance
  - Bonds to concrete, wood, MDF, laminates and polyethylene

#### Foam & Fabric

**3M Foam Fast 74 CA Spray Adhesive – Low VOC <25%**
- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more
  - Soft, non-dimpling glue lines

#### Maintenance & Cleaning

**3M Adhesive Remover – Low VOC < 20%**
- Removes grease, oil, ink and most adhesives without the need to soak or damaging the surface underneath
  - Provides mold-release agents

**3M Silicone Spray – Low VOC 60%**
- Reliable lubricant can be used in a wide variety of applications
  - Fast drying to maintain productivity
  - Long lasting and non-staining

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*Meets CARB/OTC VOC requirements and helps contribute to LEED® credits. Review applicable VOC requirements to ensure local compliance.

**All products listed are GREENGUARD Gold Certified.**
**Mist Spray vs. Web Spray**

**Particle Spray**
- Dispersions — suspended particles that can settle (shake/purge)
- Translucent glue lines
- Non-telegraphing texture, smooth
- Fine, misty particle spray
- Particle sprays are odd number products (77, 27, 75...)

**Lace Spray**
- Solutions — no particles, no settling (shake/purge not needed)
- Variable spray pattern
- Less overspray
- Lace, web spray pattern
- Lace sprays are even number products (90, 74, 72...)

**Common Reasons for Bond Failure**
- Insufficient pressure on bond
- Wrong adhesive or too thick of coating
- Too thin of coating
- Stress too great for that type of adhesive
- Bonds assembled while adhesive was still wet
- Lack of surface preparation
- Plasticizers attached and broke down adhesive

**Value Story for 3M Aerosol Adhesives**
- Ultimate convenience in a sprayable adhesive, no equipment, no mess, no set up time, minimal training, extremely portable
- Small jobs (doesn’t mean small volume!), multiple stations, easy to use, precise placement of spray (lace) portability
- Compliments bulk or cylinder adhesives
- On job sites or away from spray booths

1. Use 3M™ Multipurpose Adhesive when bonding fiberglass insulation to metal.

2. Use 3M™ Heavy Duty Adhesive when bonding wood and laminate, lamination of large materials like wood, metal, plastic.

3. Use Specialty adhesive, 3M™ Polystyrene 78 Spray adhesive when bonding polystyrene.

4. Use Maintenance and Cleaning, 3M™ Adhesive Remover when removing adhesive residue.

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