



PB923 High Temp Adhesive

Technical Data

April 2018

Product Description A versatile, high performance industrial contact adhesive. It is designed for bonding decorative laminates to particle board, but also can be used on a variety of other substrates including veneers, fabrics, upholstery, foam, headliners, glass and mirrors, cork, tile, fiberglass and plastics.

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.

PB923 High Temp Adhesive	
Base	Synthetic Elastomer
Solids Content (by wt.)	34%
Density (lbs/gal)	6.09
Viscosity (cps)	N/A
Colors	Clear or red
Volatile Organic Compounds (VOC)	<530 g/l
Hazardous Air Pollutants (HAPS) % wt (calculated)	<30%
CARB Compliant	N/A
SCAQMD 1168 Compliant	No.
GREENGUARD Indoor Air Quality Certified®	N/A
LEED® Eligible	N/A
Spray Pattern	Web
Dry Time	3 - 5 minutes
Bonding Range	20 - 40 minutes
Shear Adhesion Failure Test – SAFT ⁽¹⁾	220°F (104°C)
Flammable Solvent	Yes
Flammable Propellant	Yes

(1)SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90°F and ramped 10°F every 10 mn. until complete failure.

Key Features

- Non-chlorinated adhesive
- Water resistant
- Fast tack, strong bonds
- Temperature resistant to 220°F

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Directions for Use

PB923 High Temp Adhesive is a contact spray adhesive designed to be applied to the two surfaces about to be joined. Spray an even coat of adhesive to cover 80% to 100% of the surfaces. Do not wet the surface. Allow to dry 2 to 4 minutes and become tacky. For porous surfaces and crucial areas such as edge bonding, it is recommended to apply a second coat after the first has dried and become tacky. Place the coated surfaces together and apply a uniform pressure for strongest bond. Full adhesive strength will be reached in 24 hours. Please note that adhesive and substrates should be 60°F or higher for best results. Also insure that surfaces are dry and free from dirt.

Available Sizes

Container Size	Clear		Red	
	3M ID	UPC Number	3M ID	UPC Number
Large Cylinder – 30 lbs.	17-0000-0699-3	0-00-51131-28167-7	17-0000-0700-9	0-00-51131-28168-4
Intermediate Cylinder – 140 lbs.	17-0000-0693-6	0-00-51131-28163-9	17-0000-0694-4	0-00-51131-28164-6

Cylinder Accessories

Accessories	Description	3M ID Number	UPC Number
Applicator	Cylinder Adhesive Applicator w/ 9501 tip	62-9880-9930-5	00-048011-61706-0
Hoses	Cylinder Adhesive 6' Hose	62-9880-0006-3	00-051115-25036-1
	Cylinder Adhesive 12' Hose	62-9880-0012-1	00-048011-61988-0
	Cylinder Adhesive 25' Hose	62-9880-0025-3	00-048011-61989-7
Tip	Cylinder Spray Adhesive 9501 Spray Tip	62-9880-9501-4	00-048011-61707-7

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Storage Conditions	Store product at 60°- 80° F (16°- 27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.
Shelf Life	When stored at the recommended conditions in original, unopened container, this product has a shelf life of 15 months from date of shipment.
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