

The background of the advertisement is a close-up photograph showing a hot melt adhesive dispenser, which has an orange, ribbed body and a metal nozzle, applying a clear, viscous adhesive bead to the edge of a fringed textile. The textile has a complex, multi-colored woven pattern. The dispenser is positioned in the upper right corner, and the adhesive is being applied to the fringed edge of the material. The overall image conveys a sense of precision and industrial application.

3M Science.
Applied to Life.™

3M™ Hot Melt Adhesive Systems

**Efficiency.
Flexibility.
Versatility.**

Improve productivity and
aesthetics while lowering costs
and minimizing waste with the
3M™ Hot Melt Adhesive Systems

Features and Benefits

3M™ Hot Melt Adhesives offer many benefits for success with a variety of assembly and/or closure applications.

Flexibility

Open time or bonding range is the maximum time between applying adhesive and joining the surfaces. With 3M™ Hot Melt Adhesives you have wide latitude in bonding range selection to meet your process needs.



Speed and Ease

Move assemblies immediately and eliminate clamps, fixturing and drying time and energy. Each adhesive is engineered for efficient application with an easy-to-use 3M portable applicator. Minimal operator training.



Improves Appearance

Unlike mechanical fasteners and sealing tapes, hot melt adhesive is virtually invisible between the mating surfaces. Since hot melts are dispensed as liquids, it is easy to apply exactly where adhesive is needed.



Bond Variety of Surfaces

You can combine a wide variety of materials ranging from wood to corrugated cardboard, heat-sensitive foam and even plastics and metals. For heat sensitive materials, low melt adhesives are dispensed at lower temperatures.



Durable

3M™ Hot Melt Adhesives are applied as a molten liquid, so they quickly fill gaps and wet the entire bonding surfaces. As a result, they often exceed 1000 kPa shear strength, quickly giving your application fast, convenient strength. Select from many options to fit your specific application — including peel resistant or highly heat resistant options.

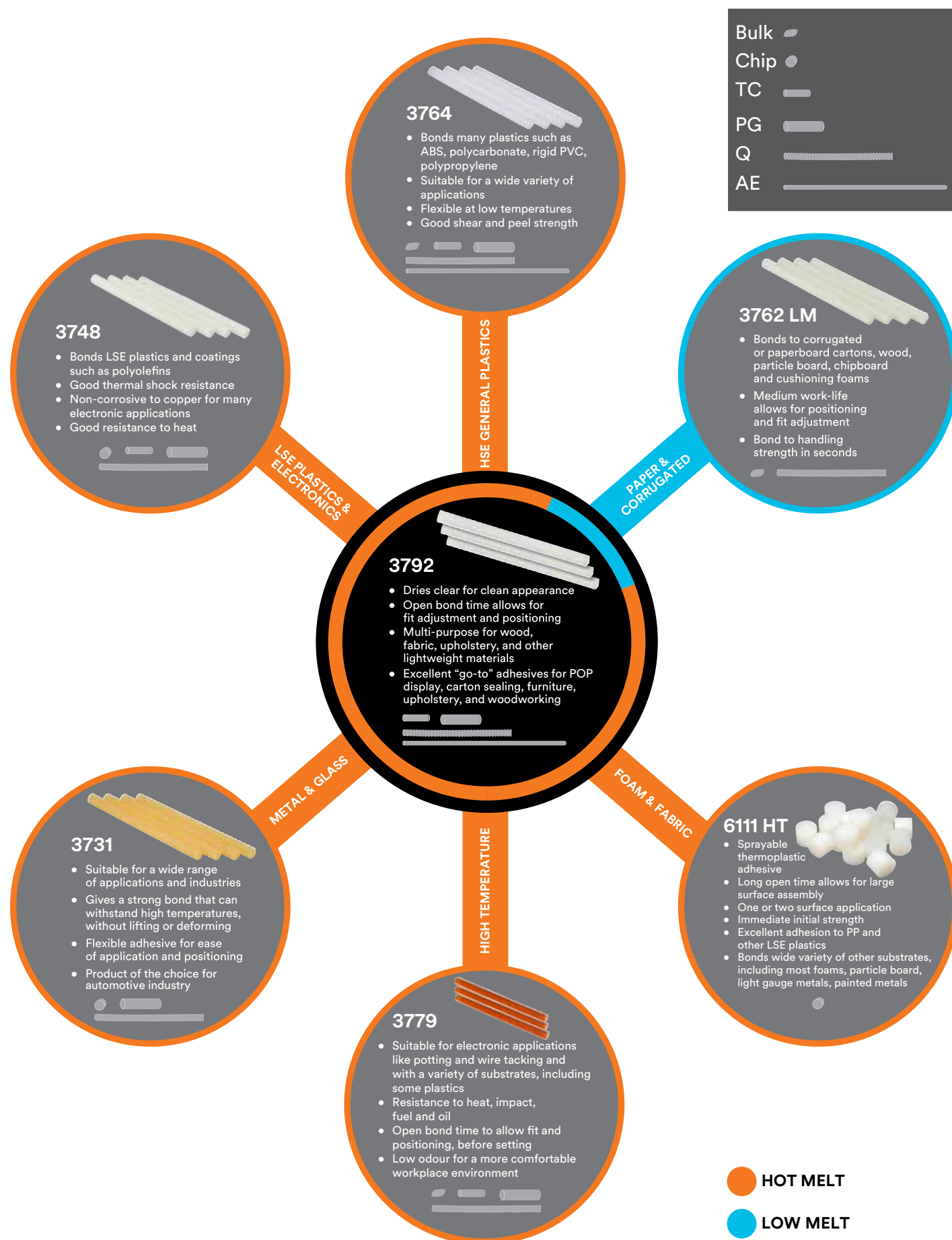


Sustainability

Hot melts are 100% solids thermoplastic resins, with virtually no VOCs. Because they don't contain solvents, hot melt products are basically odorless, create minimal pollution and are environmentally friendly. Unlike other adhesives, they don't require any special ventilation, nor provide any issues regarding flammability.



Go to Products



Lead Markets and Applications

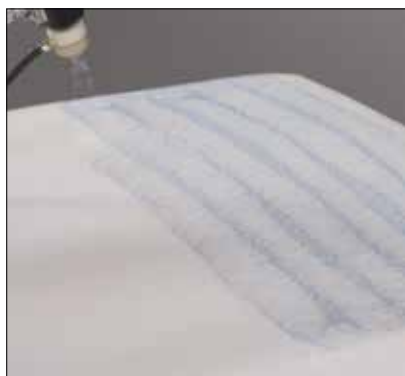


Furniture and Woodworking

Common Assembly: Small Joint Assembly, Large Surface Lamination, Mounting and Trim Attachment

- Great product performance for various small joint, mounting and trim attachment, and large surface lamination assemblies in furniture, upholstery, cabinetry and more.
- Bonds well to wood, particleboard, MDF, laminate, foam, and fabric. Nearly instant bonding strength speeds up production — eliminating the need for clamping and mechanical fasteners.
- Low melt adhesives are available for lower operating temperatures and bonding heat sensitive surfaces.

Lead Adhesives	3792	Multi-purpose for wood, fabric and many other substrates with a long open time
	3792LM	Multi-purpose low melt for heat sensitive surfaces



Transportation and Electrical

Common Assembly: Large Surface Lamination, Sealing, Potting and Encapsulating

- Fast, durable product performance for various small joint, mounting and trim attachment, large surface lamination and potting assemblies for automotive interior and electrical component manufacturing.
- Bonds well to foams, fabrics, non-wovens and difficult surfaces, such as LSE plastics.
- Some products are available as sprayable hot melt. All products can be tested to meet your specification requirements.

Lead Adhesives	3748	Bonds to plastic with high peel performance; Good thermal shock resistance and non-corrosive to copper; 3748VO is self extinguishing
	6111HT	Sprayable hot melt with long open time; High temperature resistant



Metalworking

Common Assembly: Mounting and Trim Attachment

- Ideal for difficult to bond to surfaces with fuel, oil and plasticizer exposure.
- Long 45 – 50 seconds open time allows for positioning.
- Provides good heat resistance.
- To get the ideal quality adhesion please heat the metal surface to 60-80 °C before applying hot melts.

Lead Adhesives	3731	Creates a strong, tough bond for a variety of substrates, including many plastics, wood and lightweight metals. Designed to be flexible, easing the process of application.
	3789	A go-to for high performance metal bonding, glass, plastics, vinyl, wood and other surfaces. Features impact resistance for durability and strength.
	6111HT	Ideal for metal to insulation material applications.



Packaging and Corrugated Carton Sealing

Common Assembly: Small Joint Assembly

- Quickly bonds and seals any size of corrugated carton invisibly. Durably bonds coated, printed and waxed surface that may be difficult to seal with tape.
- Low melt adhesives are available for lower operating temperatures and bonding heat sensitive surfaces.

Lead Adhesives	3762	Fast-setting with "hot tack"
	3762LM	General purpose, fast setting with "hot tack"



Product Assembly

Common Assembly: Small Joint Assembly, Large Surface Lamination, Mounting and Trim Attachment

- Fast, durable product performance for small joint, mounting and trim attachment, large surface lamination and more.
- Many solutions are available to quickly assemble and attach materials for your design.
- Low melt adhesives are available for lower operating temperatures and bonding heat sensitive surfaces.

Lead Adhesives	3764	Bonds to all plastics, including low surface energy (LSE), flexible at low temp
	3792LM	Multi-purpose low melt for heat sensitive surfaces



Point-of-Purchase, Displays and Trade Exhibits

Common Assembly: Small Joint Assembly, Large Surface Lamination, Mounting and Trim Attachment

- Fast, durable product performance for small joint, mounting and trim attachment, large surface lamination and more.
- Bonds well to wood, foam, fabric, and plastics.
- Low melt adhesives are available for worker-friendly temperatures and bonding heat-sensitive surfaces.

Lead Adhesives	3762LM	General purpose, fast setting with "hot tack"
	3792LM	Multi-purpose low melt for heat sensitive surfaces

3M™ Hot Melt Adhesives Systems

Product	Key characteristics	Q	TC	PG	AE	Bulk	Heat resistance
LOW MELT TECHNOLOGY: APPLIED 121 - 132°C							
3762 LM	Excellent “hot tack”, fast setting for corrugated, beadboard, recoupage, repacking chipboard and wood. Economical, general purpose. Use with low melt applicator only.	x			x	x	54°C
3792 LM	Clear, multi-purpose for wood, coated paper, polyolefins and other heat-sensitive materials. P.O.P. displays. Use with low melt applicator only.	x			x	x	60°C
3798 LM	Removable “gummy glue” for many substrates. Removes easily without residual tack. Use with low melt applicator only.		x				49°C
HOT MELT TECHNOLOGY: APPLIED 177- 196°C							
3731	High heat resistance. Bonds plastics including polyethylene, polypropylene.	x		x		x	129°C
3738	High delivery rate and long bonding range. General purpose for foundry sand cores, wood bonding, corrugated, selected plastics and chipboard	x	x	x	x		54°C
3747	General purpose for wide variety of plastics, wood and lightweight metals.	x		x			63°C
3748	Good thermal shock resistance. Non-corrosive to copper for many electronic applications. Bonds polyolefins.	x	x	x		x	79°C
3748 VO	Good thermal shock resistance. Non-corrosive to copper for many electronic applications. Bonds polyolefins. Self-extinguishing version of 3748.	x					79°C
3762	Excellent “hot tack”, fast setting for corrugated, beadboard, recoupage, repacking chipboard and wood. Economical, general purpose.	x	x	x	x		54°C
3764	Bonds variety of plastics including polycarbonate, polyethylene, and polypropylene. Flexible at low temperatures.	x	x	x	x	x	60°C
3779	High heat resistance. High strength. Good fuel and oil resistance. Usable with electronics.	x	x	x		x	149°C
3789	High performance for plastics. Impact resistant. Bonds vinyl and wood. Good fuel and oil resistance.	x		x		x	104°C
3792	Clear, multi-purpose for wood, corrugated, fabric, furniture, upholstery, novelties, and other lightweight materials.	x	x	x	x		60°C
6111 HT	Sprayable 100% solventless adhesive for most foams, fabrics, plastics, particle board and thin metal. Has high heat resistance.					x	79°C

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

3M™ Hot Melt Adhesives Systems

Shear Str (kPa) @ 22°C	Peel Str (N/mm) @ 22°C"	Ball & Ring Melt Point	Viscosity CPS	Open Time (sec)	Base Polymer	Color
3,309	1,05	96°C	4.000 @ 121°C	25	Ethylene-Vinyl Acetate Polymer	Light Amber
2,413	2,28	81°C	10.500 @ 121°C	40	Ethylene-Vinyl Acetate Polymer	Clear
N/A	N/A	88°C	9.500 @ 121°C	30	Naphthenic Oil	Light yellow
3,378	3,85	157°C	12.000 @ 191°C	30	Propylene copolymer	Tan
2,585	2,28	86°C	2.875 @ 191°C	50	Ethylene-Vinyl Acetate Polymer	Tan
2,965	3,50	104°C	4.100 @ 191°C	45	Ethylene-Vinyl Acetate Polymer	Tan
1,724	3,15	144°C	5.000 @ 191°C	45	Polypropylene	Off-white
1,896	2,63	152°C	5.000 @ 191°C	30	Ethylene-Vinyl Acetate Polymer	Light yellow
3,758	1,23	94°C	1.870 @ 191°C	35	Ethylene-Vinyl Acetate Polymer	Tan
2,689	2,45	88°C	6.000 @ 191°C	40	Ethylene-Vinyl Acetate Polymer	Clear
4,826	3,15	163°C	7.000 @ 191°C	25	Polyamide	Amber
3,930	2,80	132°C	5.200 @ 191°C	50	Polyamide	Brown
1,724	2,28	81°C	5.000 @ 191°C	50	Ethylene-Vinyl Acetate Polymer	Clear
N/A	4,55	140°C	2.500 - 4.500 @ 191°C"	1 surface: 180 2 surface: 480	Polyolefin copolymer thermoplastic	Tan, Blue

3M™ Hot-Melt Applicators

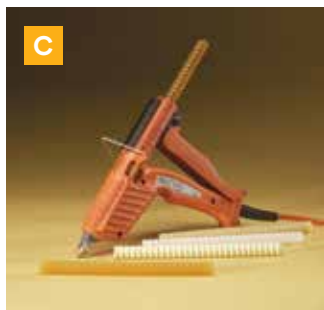
3M Hot Melt Applicators are trusted solutions that are engineered to help you improve productivity, lower cost and minimize waste in industrial applications. From high volume to detail work, 3M Hot Melt Applicators are uniquely designed to ensure optimum performance through melt-on-demand or progressive feed technology for your production needs.



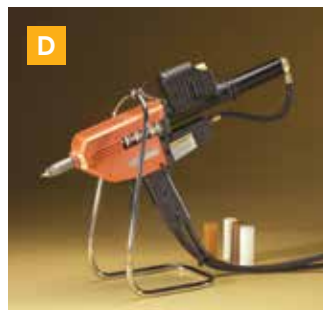
3M™ Hot Melt Applicator LT with Quadrack Converter. Medium volume using low melt adhesive.



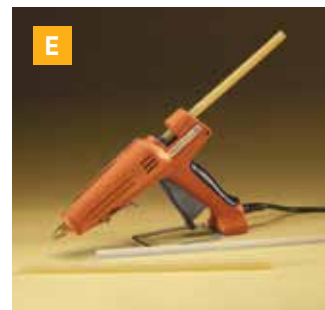
3M™ Hot Melt Applicator TC. Low-medium volume.



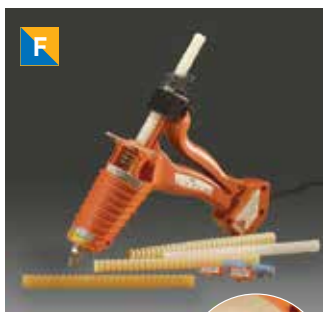
3M™ Hot Melt Applicator TC with Quadrack Converter. Medium volume.



3M™ Pneumatic Hot Melt Applicator PG II with Speedloader. High volume.



3M™ Hot Melt Applicator AE II. Low volume.



3M™ Hot Melt Applicator EC. Medium volume; variable temperature control.

Product	Weight ¹ (kg/g)	Output ² (kg/hr)	Temp. ³ (°C)	Power (120V)	Adhesive Dia. x L (cm)	Features	Warranty (Months)
Low Melt Applicators							
A LT with Quadrack Converter	390 g	1,18	129	150W	Q Stick	For use with low melt adhesives.	12
Hot Melt Applicators							
B TC	280 g	1,59	196	150W	TC Stick	Easy to use with standard melt adhesives.	12
C TC with Quadrack Converter	390 g	1,59	196	150W	Q Stick	Easy to use with standard melt adhesives.	12
D Pneumatic PG II with Speedloader	1,95 kg	3,40	196	500W	PG Stick	Pneumatic high output for standard melt adhesives.	12
E AE II	567 g	1,81	204	100W	AE Stick	All electric operation for standard melt adhesives.	6
Variable Applicators							
F EC	680 g	2,49	127–232	350W	Q Stick	Temperature modules to operate with standard and low melt adhesives.	12

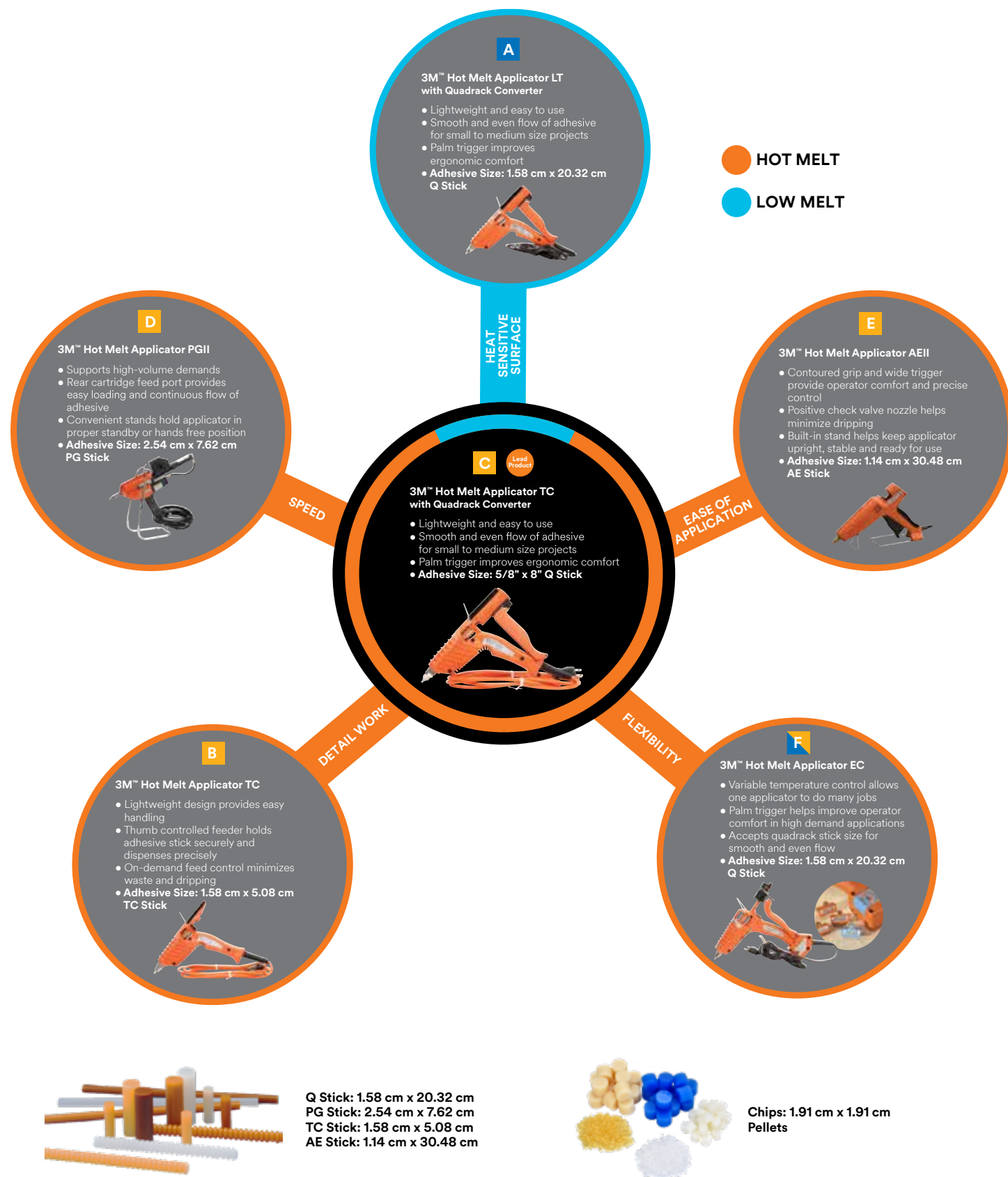
1 – Weight shown is for applicator only; does not include adhesive capacity.

2 – Adhesive output will vary with conditions and the adhesive used. Values are approximate and are based on maximum steady-state flow.

3 – Temperatures shown are nominal control values. Actual temperature will range slightly above and below this value.

Selecting the Right System

3M™ Hot Melt Adhesives are designed and precisely manufactured for use in a 3M Hot Melt Applicator. When paired together, they work as a system, providing optimal performance for your design needs. Use the guide to select the right applicator and the adhesive size for your application.



Accessories to Improve Productivity

3M™ Hot Melt Applicator Accessories and Parts are designed to offer versatility, when dispensing 3M Hot Melt Adhesives. Uniquely designed for 3M Hot Melt Applicators, these accessories and parts maximize the use of 3M Hot Melt Adhesives by improving productivity, optimizing precision, and reducing waste in your assembly process.



Product	Description
7000046677	Heavy Duty Benchstand 9945 for PG EC, TC and LT Applicators
7000046637	Bench Mount Assembly for PG II and PG II LT Applicators
7000046636	Valve Assembly Kit 9223 for PG II and PG II LT Applicators
7000046638	Valve Assembly Kit 9234 for PG TC, EC and LT Applicators
7000000953	Quadrack™ Converter 9275
7000121596	Foot Pedal Assembly 9277
7000016508	Palm Trigger 9761 for TC Applicator
7000046647	Mini Extension Tip 9725, 1.8 mm
7000121603	T Tip Assembly 9726
7000046649	Hi-Viscosity Flow Valve and Tip 9729
7000028621	Tapered Aluminum Extension Tip 9785, 1.8 mm
7000046674	Fluted Tip 9921, 2.3 mm
7000046675	Fluted Tip 9922, 1.6 mm
7000046676	Fluted Tip 9940, 3.2 mm
7000046678	Brass Extension 9946, 1.8 mm



A general purpose tip (.090) is supplied with each 3M™ Hot Melt Applicator. To increase productivity, optional tips can provide multiple beads, flat ribbons, guided beads for carton sealing and extended reach.



Heavy-Duty Benchstands provide storage for applicators when they are not in use.



Quadrack Converter*

Palm Trigger*



Foot Pedal



Bench Nozzle Assembly



Benchmount

Foot pedal, magazine feeder and benchmount accessories can provide high capacity, hands-free operation, reduction in operator fatigue, and overall convenience & productivity for 3M™ Hot Melt PG II and PG II LT Applicators.

*Increase loading capacity and ease of operation with Quadrack Converter and Palm Trigger.

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

Note: Repair parts are available. Reference owner manuals for information.

Low Melt Technology

3762
LM

3M™ Hot Melt Adhesive 3762 LM

- 100% solids, fast-setting hot melt adhesive designed for packaging and shipping applications
- It is ideal for bonding corrugated fiberboard cartons, wood, particle board, chipboard and foam

Light Amber	
7100025246	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100023281	Pellets, 10 kg

3792
LM

3M™ Hot Melt Adhesive 3792 LM

- Clear, multipurpose adhesive
- 50 second open time allows for adjustment and positioning
- Ideal for furniture, upholstery, woodworking POP displays, and carton sealing

Clear	
7000000880	Q stick, 1.58 cm x 20.32 cm, 5 kg
7000000881	Pellets, 10 kg

3798
LM

3M™ Hot Melt Adhesive 3798 LM

- Tack free, solvent free removable gummy glue
- 30 second open time allows for fast production
- Stable release properties sticks and peels easily without surface damage or residue
- Ideal for use on coated surfaces like paper, plastic and glossy laminates

Light Yellow	
7000046523	TC stick, 1.58 cm x 5.08 cm, 5 kg

Hot Melt Technology

3731

3M™ Hot Melt Adhesive 3731

- Bonds well to polyolefin based plastics
- High-temperature resistance to 129°C
- Fast-setting for quick, effective results
- Provides good peel strength, creating tough and resilient bonds

Tan	
7100009195	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100020337	PG stick, 2.54 cm x 7.62 cm, 10 kg
7100031985	Chips, 1.91 cm, 10 kg

3738

3M™ Hot Melt Adhesive 3738

- General purpose 100% solids adhesive
- 50 second open time allows for positioning
- High delivery rate and long bonding range

Tan	
7100008738	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100020456	PG stick, 2.54 cm x 7.62 cm, 10 kg
7100009196	TC stick, 1.58 cm x 5.08 cm, 5 kg
7100023046	AE stick, 1.14 cm x 30.48 cm, 10 kg

3747

3M™ Hot Melt Adhesive 3747

- Moderate heat resistance provides long-lasting bonds that can withstand elevated temperatures
- Adheres to a wide variety of substrates to provide solutions for many applications
- Flexible for ease of application and positioning

Tan	
7000000877	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100020458	PG stick, 2.54 cm x 7.62 cm, 10 kg

3748

3M™ Hot Melt Adhesive 3748

- High temperature performance and thermal shock resistance
- Formulated for bonding low surface energy plastics and coatings to dissimilar materials
- High peel delivers long-term strength and durability

Off-White	
7000000878	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100005566	PG stick, 2.54 cm x 7.62 cm, 10 kg
7000000879	TC stick, 1.58 cm x 5.08 cm, 5 kg
7100044127	Chips, 1.91 cm, 10 kg
Black	
7100026254	Q stick, 1.58 cm x 20.32 cm, 5 kg

3748
VO

3M™ Hot Melt Adhesive 3748 VO

- Tough, flexible bond provides good thermal shock resistance
- Adheres to difficult-to-bond plastics such as polyolefins
- Self-extinguishing properties for electrical applications

Light Yellow	
7000000887	Q stick, 1.58 cm x 20.32 cm, 5 kg

3762

3M™ Hot Melt Adhesive 3762

- Aggressive hot tack rapidly achieves handling strength
- Short open time allows for fast assembly lines
- Securely bonds difficult to seal substrates such as lightly waxed surfaces
- Low viscosity prevents stringing even at fast production speeds

Tan	
7100023053	Q stick, 1.58 cm x 20.32 cm, 5 kg
7000046513	PG stick, 2.54 cm x 7.62 cm, 10 kg
7100020333	TC stick, 1.58 cm x 5.08 cm, 5 kg
7100023019	AE stick, 1.14 cm x 30.48 cm, 10 kg

3764

3M™ Hot Melt Adhesive 3764

- Bonds variety of plastics
- Formulated to be flexible at low temperatures to ease modification and positioning during application
- Impact-resistant design delivers long-term durability
- Provides dependability through good shear and peel strength

Clear	
7100008178	Q stick, 1.58 cm x 20.32 cm, 5 kg
7000000884	PG stick, 2.54 cm x 7.62 cm, 10 kg
7000000886	TC stick, 1.58 cm x 5.08 cm, 5 kg
7000000885	AE stick, 1.14 cm x 30.48 cm, 10 kg
7000136621	Pellets, 10 kg

3779

3M™ Hot Melt Adhesive 3779

- Excellent for electronics and potting applications
- Provides extreme temperature stability 149°C for a durable bond
- Fuel, oil and impact resistant
- Fast setting allows for quick assembly

Amber	
7000000888	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100009192	PG stick, 2.54 cm x 7.62 cm, 10 kg
7000000890	TC stick, 1.58 cm x 5.08 cm, 5 kg
7100022869	Pellets, 10 kg

3789

3M™ Hot Melt Adhesive 3789

- Ideal for difficult to bond to surfaces, including those with fuel, oil and plasticizer exposure
- Provides good heat and impact resistance
- A go-to for high performance metal bonding
- Long 50 seconds open time allows for positioning of large surface assemblies

Brown	
7100008737	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100020457	PG stick, 2.54 cm x 7.62 cm, 10 kg
7010123533	Pellets, 10 kg

3792

3M™ Hot Melt Adhesive 3792

- Clear, multipurpose adhesive
- 50 second open time allows for adjustment and positioning
- Ideal for furniture, upholstery, woodworking POP displays, and carton sealing

Clear	
7000000891	Q stick, 1.58 cm x 20.32 cm, 5 kg
7100020334	PG stick, 2.54 cm x 7.62 cm, 10 kg
7100020336	TC stick, 1.58 cm x 5.08 cm, 5 kg
7100020335	AE stick, 1.14 cm x 30.48 cm, 10 kg

6111
HT

3M™ Sprayable Hot Melt Adhesive 6111 HT

- Sprayable, 100% solids adhesive without volatiles
- Extended open time allows for large surface assembly
- Features high temperature resistance
- Compatible with heat sensitive surfaces
- Bonds wide variety of substrates, including most foams, polypropylene, other LSE plastics, particle board, light gauge metals

Tan	
7100023018	Chips, 1.91 cm, 10 kg
Blue	
7100069028	Chips, 1.91 cm, 10 kg

Applicators

3M™ Hot Melt Adhesive Applicators

- Lightweight designs for easy, balanced handling
- Meet the needs of low and high volume dispensing
- Designed for comfort and ergonomics in mind

Applicators - EU Plug	
7000028619	Applicator with Quadrack™ Converter and Palm Trigger, 220V
7000028617	Applicator LT with Quadrack™ Converter and Palm Trigger, 220V
7000046646	Applicator TC, 220V
7000046679	Applicator PG II with Speedloader Cartridge Feed
7000046651	Applicator AE II, 240V
7000046643	Applicator EC, 220V
Applicators - UK Plug	
7000028618	Applicator with Quadrack™ Converter and Palm Trigger, 240V
7000046640	Applicator LT with Quadrack™ Converter and Palm Trigger, 240V
7000046645	Applicator TC, 240V
7000087694	Applicator PG II LT with Speedloader Cartridge Feed
7000046644	Applicator EC, 240V

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