



Technical Data Sheet

3M™ NG IF HS



[Regulatory Info/SDS](#)

Product Description

An infusion adhesive specifically designed to hold reinforcing fibers in place during infusion process of the resin without affecting the surface finish or structural integrity. It is designed to hold mat, pads and similar types of dry materials to themselves or onto mold surface during the resin infusion. It will not interfere with curing process of vinyl esters, polyesters or styrene reins. The adhesive is designed to ultimately become part of the polymer matrix. It is designed to be used to give a provisional hold for fiberglass materials in place prior to the application of fiberglass resin and/or gel coat to build up composites. It can also be used as general purpose adhesive for a wide range of application.

Product Features

- Used for infusion/vacuum forming composites
- Safely fuses laminating materials to structure core surfaces
- Provides superior holding during forming process
- Low Shrinkage in curing
- Fine mist with tracer color
- Fast tack

Technical Information Note

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

Typical Uncured Physical Properties

Attribute Name	Value
Base	Synthetic Elastomer
Density	5.9 lb/gal

Typical Physical Properties

Attribute Name	Value
Color	Green
Solids Content by Weight	29 %
Spray Pattern	Mist to lacy
Dry Time	3 to 5 min ¹
Flammable Solvent	Yes
Bonding Range	20-40 min
Flammable Propellant	Yes
VOC	535 g/L

¹ Dry time will depend on ambient temperature, humidity and coverage applied.

Typical Performance Characteristics

Attribute Name	Value
Shear Adhesion Failure Test - SAFT	82 °C (180 °F) ¹

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 min. until complete failure.

Cylinder Accessories

	3M Cylinder Spray Adhesive Applicators and Accessories	3M ID Numbers	UPC Numbers
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
Tips	Cylinder Spray Adhesive 9501 Spray Tip	62-9880-9501-4	00-048011-61707-7
	Cylinder Spray Adhesive 6501 Spray Tip	62-9880-6501-7	00-048011-61991-0

Handling/Application Information

Directions for Use

NG IF HS contact spray adhesive is 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.

Storage and Shelf Life

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. When stored at the recommended conditions in original, unopened container, this product has a shelf life of 18 months from date of manufacture.

Available Sizes - Detailed

	NG IF HS - Green	
Container Size	3M Stock Number	UPC Number
Aerosol	17-0000-0553-2	0-00-51131-28100-4
Large Cylinder – 30 lbs.	17-0000-0556-5	0-00-51131-28103-5
Intermediate Cylinder – 140 lbs.	17-0000-0552-4	0-00-51131-28099-1

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.

Information

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Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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