



# Technical Data Sheet

## 3M™ Hi-Tack Pressure Sensitive Adhesive 3794

[Regulatory Info/SDS](#)

### Product Description

3M™ Hot Melt Adhesives are 100% solids, thermoplastic resins that become fluid when heated and quickly wet the bonding surface. They cool and reach bond strength in seconds, keeping production flowing by eliminating clamps, fixturing and drying, and saving time energy and space.

3M™ Hi-Tack Pressure Sensitive Adhesive 3794 bonds to a wide variety of substrates such as wood, corrugated, fabrics and foams, plastics, metal and other lightweight materials.

- Sprayable and extrudable. Aggressive tack bonds well to most surfaces. Tackiness remains after cooling, allowing bond formation long after dispensing. Offers good low temperature flexibility.

### Product Features

- 100% Solids, no VOCs
- Easy to use
- Extra-long open time
- Adhesive obtains strength in seconds
- Can be sprayed, extruded or roll coated
- Hi tack PSA provides tack even after cooling

### 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 Physical Properties

Attribute Name	Test Method	Temperature	Substrate	Value
Color				Light Tan
Density				0.94 g/cm <sup>3</sup> (0.034 lb/in <sup>3</sup> )
Open Time			Douglas Fir to Douglas Fir	>60 s <sup>1</sup>
Flash Point	ASTM D92-72			204 °C (>400 °F) <sup>2</sup>
Viscosity		163 °C (325 °F)		15,000 cP <sup>3</sup>

<sup>1</sup> 3 mm (1/8 in) semicircular bead

<sup>2</sup> Cleveland Open Cup

<sup>3</sup> Brookfield Thermocel Viscometer

### Typical Performance Characteristics

Attribute Name	Test Method	Temperature	Substrate	Value
180° Peel Adhesion		23 °C (73 °F)	Flexible canvas bonded to Douglas Fir	256 oz/in
Ball & Ring Melt Point	ASTM E28-67			107 °C (224 °F)

Attribute Name	Value
Application Temperature	162 — 196 °C (325 — 385 °F) <sup>1</sup>
Temperature Resistance	49 °C (120 °F) <sup>2</sup>

<sup>1</sup> Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.

<sup>2</sup> Highest temperature that the adhesive will support a 14 kPa (2 psi) dead load

## **Handling/Application Information**

### **Directions for Use**

1. Surface Preparation: Surfaces must be clean, dry and dust free. Wipe with a solvent such as isopropyl alcohol for plastic substrates to aid in removing oil and dirt.\*

\***Note:**When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

2. Application: 3M™ Hot Melt Adhesive 3794 is designed for bulk applicators.

**Note:**Plastic wrap encasing the chub DOES NOT need to be removed. Entire chub can be deposited into melting equipment. Wrap has no effect on process or performance.

3. Coverage: 3M™ Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.

4. Set time: After the bond is made, 3M™ Hot Melt Adhesive 3794 immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates, however 3M™ Hot Melt Adhesive 3794 will remain tacky after cooling.

### **Storage and Shelf Life**

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. For best performance, use this product within 24 months from date of manufacture.

### **Available Sizes - Detailed**

Chubs (1.1 lb)

### **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

### **Information**

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### **ISO Statement**

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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