



# Technical Data Sheet

3M™ Super 77™ Spray Adhesive (Bulk)



[Product Details](#)



[Regulatory Info/SDS](#)

## Product Description

A high tack, high coverage and fast drying adhesive.

## Product Features

- A high tack, high coverage fast drying, transparent adhesive for permanently attaching foils, carpeting, many lightweight foams, paper, cardboard, felt and cloth to painted or unpainted metals, wood, hardboard and other base materials.
- It provides high initial "grab" with sufficient open time to allow for positioning of materials.
- Low soak-in gives better looking and higher coverage bonds.
- Soft, non-dimpling glue lines

## 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
Density	0.78

## Typical Physical Properties

Attribute Name	Value
Color	Translucent
Solids Content by Weight	36 %
Base	Synthetic Elastomer
Dry Time	15 — 60 s <sup>1</sup>
Spray Pattern	Mist
Flammable Solvent	Yes
Coverage	15.6 m <sup>2</sup> (168 ft <sup>2</sup> ) <sup>2</sup>
Bonding Range	15 sec — 15 min
SCAQMD 1168 Compliant	No
VOC	504 g/L
Hazardous Air Pollutants (HAPS)	1.2 % by weight
Viscosity	200 — 5000 cP

<sup>1</sup> Dry time will depend on ambient temperature, humidity and coverage applied.

<sup>2</sup> @ 27 g/m<sup>2</sup> (2.5 g/ft<sup>2</sup>)

## Typical Performance Characteristics

Attribute Name	Value
Shear Adhesion Failure Test - SAFT	65 °C (150 °F) <sup>1</sup>

<sup>1</sup> SAFT Shear Adhesion Failure Test with birch plywood, 25 mm (1 in) overlap, 100 g used, temperature start at 32 °C (90 °F) and ramped 5.5 °C (10 °F) every 10 min. until complete failure.

## 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, unopened packaging, out of direct sunlight. Lower temperatures cause increased viscosity of a temporary nature. For best performance, use this product within 18 months from date of manufacture.

## Available Sizes - Detailed

Container Size	3M Stock Number	UPC Number
24 Fl. Oz. (Net Wt. 16.75 oz)	62-4977-4930-9	00-021200-21210-9
Large Cylinder – 29.3 lbs.	62-4979-8030-0	00-051115-25776-6
5 gallon pail – 32.5 lbs.	62-4458-8530-4	00-021200-43793-9
52 gallon drum – 338 lbs.	62-4458-9530-3	00-021200-43813-4

## 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

## Automotive Disclaimer

### Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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