



Technical Data Sheet

3M™ PB923 High Temp Adhesive



[Product Details](#)



[Regulatory Info/SDS](#)

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.

Product Features

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

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	6.09 lb/gal
Base	Synthetic Elastomer

Typical Physical Properties

Attribute Name	Value
Color	Clear or Red
Solids Content by Weight	34 %
Spray Pattern	Web
Dry Time	3 — 5 min ¹
Flammable Propellant	Yes
Bonding Range	20-40 min
Flammable Solvent	Yes
VOC	<530 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	104 °C (220 °F) ¹

¹ 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.

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

Handling/Application Information

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.

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. Higher temperatures reduce normal storage life. For best performance, use this product within 21 months from date of manufacture.

Available Sizes - Detailed

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

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