



# 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 <sup>1</sup>
Flammable Propellant	Yes
Bonding Range	20-40 min
Flammable Solvent	Yes
VOC	<530 g/L

<sup>1</sup> 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) <sup>1</sup>

<sup>1</sup> 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

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

## **Information**

**Disclaimer:** 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit [www.3M.com](http://www.3M.com).

## **Technical Information**

The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

## **Product Selection and Use**

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

## **Warranty, Limited Remedy, and Disclaimer**

Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

## **Limitation of Liability**

Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

3M™ Industrial Adhesives and Tapes Division  
3M Center, St. Paul, MN 55144-1000  
3M.com/iatd

3M is a trademark of 3M Company.  
The GREENGUARD INDOOR AIR QUALITY CERTIFIED Mark is a registered certification mark owned by Air Quality Sciences, Inc. and used under license through the Greenguard Environmental Institute.  
LEED is a registered trademark of the United States Green Building Council (USGBC).  
©3M 2024 (6/24)