



# Technical Data Sheet

## 3M™ Hot Melt Adhesive 3789

### Product Description

3M™ Hot Melt Adhesives are heat applied, 100% solids adhesives. 3M™ Hot Melt 3789 is a thermoplastic adhesive to bond to wide variety of substrates such as wood, plastic, vinyl, metal and glass.

- High performance for plastic with good fuel, oil and plasticizer resistance. Long open time.

### Product Features

- 100% solids, no VOCs
- Easy to use
- Long open times allow for easy use on large assemblies and large surfaces
- Adhesive sets and obtains strength in seconds
- Creates high performance bonds
- Ideal for woodworking and general industrial applications.

### 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				Brown
Density				0.95 g/cm <sup>3</sup>
Open Time			OSB	50 s <sup>1</sup>
Flash Point	ASTM D92-72			>200 °C <sup>2</sup>
Delivery Time				70 s <sup>3</sup>
Viscosity		191 °C		5,200 cP <sup>4</sup>

<sup>1</sup> Open time is the max time between the application of the adhesive and joining the parts. Data based on 3.2 mm (1/8 in) semicircular bead on non-metallic substrates at 24 °C (75 °F). Higher environmental temperatures and/or larger beads will lengthen open times.

<sup>2</sup> Cleveland Open Cup

<sup>3</sup> Extrusion time for one 25 x 76 mm (1 x 3 in) PG cartridge.

<sup>4</sup> Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

### Typical Performance Characteristics

Attribute Name	Test Method	Temperature	Substrate	Value
180° Peel Adhesion		23 °C	Flexible canvas bonded to Douglas Fir	28 N/cm
Overlap Shear Strength		23 °C	Douglas Fir	40 kg/cm <sup>2</sup>
Ball & Ring Melt Point	ASTM E28-67			132 °C

Attribute Name	Value
Application Temperature	177 — 196 °C <sup>1</sup>
Temperature Resistance	104 °C <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, metal and glass substrates to remove 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 Adhesives are designed for application with a 3M™ Hot Melt Applicators. Read and follow the precautions and directions for use in the user's manual before operating the applicator. 3M™ Hot Melt Adhesives are applied at 350-385°F. Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead. Extruded bead sizes can be customized using 3M™ applicator tips.

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 up time: After the bond is made, 3M™ Hot Melt Adhesives immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates.

## **Industry Specifications**

UL 94 - V2

## **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**

5/8 in x8 in Q  
1 in x3 in PG  
1/8 in Bulk

## **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**

Precautionary Information: Refer to product label and Material Safety Data Sheet for health and safety information before using the product. For information, please contact your local 3M Office. You can click or scan QR code to see contact detail or visit [www.3M.com](http://www.3M.com) Important Information: All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law. Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.

## **ISO Statement**

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

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