



# Technical Data Sheet

## Preliminary 3M™ Hi-Tack Composite Spray Adhesive 71 Pink



Regulatory  
Info/SDS

### Product Description

3M™ Hi-Tack Composite Spray Adhesive 71 is a high-tack spray adhesive designed for use in a wide variety of resin infused composite applications.

### Product Features

- Designed for bonding lightweight materials used in resin infused composites.
- Meets CARB / OTC VOC Requirements.
- May help contribute to LEED® credits.

### Technical Information Note

3M will continue to test samples from additional manufacturing lots and issue a new Technical Data Sheet if the results change. The technical information and data should be considered representative or typical only and should not be used for specification purposes. The following data is taken from tests conducted on a limited number of production runs.

### Typical Uncured Physical Properties

Attribute Name	Value
Density	0.8 g/mL (6.67 lb/gal)

### Typical Physical Properties

Attribute Name	Value
Color	Pink
Base	SBR
Spray Pattern	Mist
Dry Time	Up to 60 s <sup>1</sup>
Flammable Solvent	Yes
Flammable Propellant	Yes
Bonding Range	1-10 min
Solids Content by Weight	20 %
Net Weight	511 g (18.04 oz)

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

### Application Guidelines

**Preparation:** For best results, all surfaces to be bonded must be clean, dry, and free from dirt, dust, oil, loose paint, wax or grease, etc.

**Working Temperature:** The adhesive and surfaces to be bonded should be at 65 °F (18 °C) or above.

**Two Surface Bonding:** For more permanent or demanding applications spray both surfaces. Allow minimum 60 seconds drying.

Overhead or more difficult materials may need an application to both materials. More adhesive may be needed depending on number of layers, configuration and nature of materials.

## **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.

## **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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3M Center, St. Paul, MN 55144-1000  
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