

3M

Scotch-Weld™

Hi-Strength Cylinder Spray Adhesive

94 CA that is certified to the GREENGUARD®
Children & Schools^(SM) product emission standard.

Technical Bulletin

January, 2008

Introduction

3M™ Scotch-Weld™ Hi-Strength Cylinder Spray Adhesive 94 CA is an industrial grade, high performance bulk spray adhesives formulated for high strength and high heat resistant bonds. The adhesive is available in convenient, portable, no maintenance aerosol cylinders as well as bulk packaging.

For more detailed information please see the complete data page (78-6900-9944-1).

Key Features

- High solids, high coverage adhesive.
- Fast drying formulas to help speed assembly.
- High heat and moisture resistance to help protect bonds.
- Postforming adhesive.
- Permanent bonds on substrates like wood, high pressure laminate, veneer, metal, plastics, soft foams, poly foams, carpets and more.
- HAPS free and MACT compliant products.
- California compliant per SCAQMD Rule 1168.
- **Certified to the GREENGUARD® Product Emission Standard For Children and Schools^(SM) for low emitting interior building materials:**
 - Addresses or Contributes to LEED™ EQ Credit 4.1: Low Emitting Materials: Adhesive and Sealants
 - Addresses or Contributes to LEED™ EQ Credit 4.3: Low Emitting Materials: Flooring Materials
 - Addresses or Contributes to LEED™ EQ Credit 4.4: Low Emitting Materials: Composite Wood and Agrifiber Products
 - Addresses or Contributes to LEED™ EQ Credit 4.5: Low Emitting Materials: Furniture and Furnishings
 - Addresses or Contributes to LEED™ EQ Credit 4.6: Low Emitting Materials: Ceiling and Wall Systems



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Typical Physical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Product	3M™ Scotch-Weld™ Hi-Strength Cylinder Adhesive	
	94 CA Cylinder	94 CA Bulk
Base:	Synthetic Elastomer	Synthetic Elastomer
Solids Content of Adhesive – (by wt.):	28%	34%
Color(s):	Clear, Red	Clear, Red
Volatile Organic Compounds (VOC):	79 g/L	0 g/L
Hazardous Air Pollutants (HAPS) % wt. (calculated):	0%	0%
SCAQMD Rule 1168 Compliant Contact Adhesive:	Yes	Yes
MACT Compliant:	Yes	Yes
GREENGUARD® Certified:	Yes	Yes

Available Sizes and Expected Coverage

Product	Size Availability	Adhesive Net. Wt. (lbs.)	Sq. Ft. Coverage @ 2.5 gms./sq. ft. (dry wt.): per Wet lb.	Sq. Ft. Coverage @ 2.5 gms./sq. ft. (dry wt.): per container
Cylinder	Mini - Disposable	7.6	51	386
	Large - Disposable	26.2	51	1,332
	Intermediate - Returnable	128	51	6,509
	Jumbo - Returnable	266	51	13,526
Bulk	5 Gallon Pail	39.5	62	2,439
	55 Gallon Drum	427	62	26,365

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Storage Store product at 60°-80°F (16°-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.

Shelf Life When stored at the recommended conditions in the original, unopened container, this product has a shelf life of 15 months from date of shipment.

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 or (651) 737-6501.

Product Use 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 of application.

Warranty and Limited Remedy Unless stated otherwise in 3M's product literature, packaging inserts or product packaging for individual products, 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. Individual products may have additional or different warranties as stated on product literature, package inserts or product packages. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If the 3M product is defective within the warranty period, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.

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Industrial Adhesives and Tapes Division

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10% post-consumer

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