

3M Science.
Applied to Life.™



3M™ Spray Adhesives

Performance. Productivity. Efficiency.

Streamline your assembly operation with convenient, efficient 3M™ Spray Adhesives.

Solutions that start with you

Choosing the right 3M™ Spray Adhesives starts with you: your processes, your objectives, your bonding challenges. Then the 3M team of adhesive experts go to work to find the best products to help maximise your product performance, increase your efficiency, streamline your assembly productivity and meet your sustainability goals.

Performance: Find the right adhesive

Choosing the right adhesive for your assembly begins with asking the right questions:

- What kinds of materials are you bonding?
- How large are the materials?
- What specific adhesive attributes are you looking for?
- Do you need time to reposition after adhesion?
- What issues are you having, if any, with your current products?
- What are the environmental, health and safety factors?

Productivity: Find the right delivery system

How you apply adhesive to your assembly components is often as important as the adhesive itself. 3M will work with you to find the delivery system that optimises efficiency and works best for your assembly processes. 3M spray adhesives are available in three delivery systems: aerosol, cylinder and bulk.

Aerosol



- Ultimate convenience for smaller jobs or multiple stations
- No equipment, no mess, no setup
- Easy to use; complements bulk or cylinder systems
- Ideal for field work

Cylinder



- Self-contained, pressurised, portable
- Minimal equipment investment
- Low maintenance
- Optimized spray patterns cut waste and maximise coverage
- Ideal for larger surface areas and >20 pieces/day

Bulk



- Easily integrated into existing equipment
- Highly cost efficient — generally the lowest cost per square foot
- Requires trained and experienced operators to maximise value
- Ideal for large surface areas and large industrial manufacturers

Sustainability: Find the products that achieve your goals

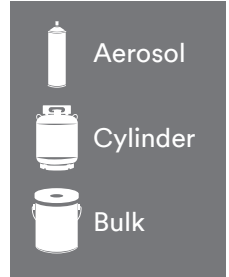
Maximising sustainability doesn't have to mean giving up performance. For more than 40 years 3M engineers have been developing water-based, low VOC and GREENGUARD™ certified adhesives for some of the most demanding applications in the world. So if you're ready to "go greener," we're ready to take you there.



*Meets applicable 2017 California Air Resource Board VOC limits for mist and web spray adhesives.

Industrial grade. Trusted by professionals.

3M's portfolio of industrial-grade, solvent- and water-based spray adhesives is designed to make assembly fast, convenient and efficient. Start with 3M™ Super 77™ Multipurpose Spray Adhesive and adjust according to your specific bonding needs.



Adhesive Selector: Find the Right Adhesive by Selecting the Substrates You're Bonding

Choose Adhesive Delivery System


Choose Substrate



Substrate	Aerosol	Cylinder	Solvent-Based Bulk	Water-Based Bulk
Paper, Cardboard	77	77	77	49
Drainboard, Waterproof Membrane	90	70,1049	N/A	N/A
Fabric, Felt, Fiberglass Insulation, Cork	77	70, 1049, 77	77	49
Flexible Foam: Urethane, Latex	74	74, 1100NF	74	100NF, 1100NF
Rigid Foam: Polystyrene, EPX, XPS*	78	70, 1049	70, 78HT	30NF
High Pressure Laminates, Melamine	90	94CA	94CA	30NF
Wood, MDF, Particle Board	90	94CA	94CA	30NF
Metal: Steel, Aluminium	90	90, 94CA	90, 94CA	30NF
Plastics: ABS, PVC, Phenolic, Acrylic	90	90, 94CA	90, 94CA, 4491	30NF
FRP: Fiberglass Reinforced Plastic	90	70, 1049, 90, 94CA	90, 94CA	30NF
Painted Surfaces	90	90, 94CA	90, 94CA	30NF
Rubbers: Nitrile, Neoprene, SBR	80, 90	70, 1049, 90, 94CA	90, 94CA, 4491	N/A
Plasticised Vinyl	80	1049	4491	1049
Geotextiles	N/A	70, 1049	N/A	N/A

* Extruded Polystyrene
Substrates are ranked from lightweight, heavy duty to specialty substrates.

Adhesive Selector: Find the right adhesive by selecting the attributes you need

Product	Heat Resistance	Shear Strength psi	Solids* %	Non-Flammable	Postforming	Class A Rating: ASTM E-84	Plasticiser Resistant		Low VOC	Helps Contribute to LEED® Credits	California Compliant	Spray Pattern	Color
30NF			49	✓	✓			✓	✓	✓	✓	Pebble	Green, Neutral
49	250°F	50	55	✓		✓		✓	✓		✓	Pebble	Clear
60CA			43			✓			✓		✓	Variable Lace or Pebble	Clear
70			21			✓						Heavy Body Lace	Clear
71	222°F	≤ 300	19								Aerosol Only	Mist	Clear
72	175°F	≤ 200	16							✓		Variable Lace	Blue
74	175°F	≤ 200	22/36							Aerosol Only		Variable Lace	Clear, Orange
74CA	195°F	≤ 200	23					✓	✓	Aerosol Only	Aerosol Only	Variable Lace	Clear, Orange
76	225°F	≤ 200	14							Aerosol Only		Variable Lace	Clear
77	150°F	≤ 200	25/27/36			✓				Aerosol Only		Mist	Clear
77 Classic	150°F	≤ 200	25							Aerosol Only		Mist	Clear
77CA	190°F	≤ 200	19					✓	✓	Aerosol Only	Aerosol Only	Mist	Clear
78	165°F	≤ 200	21							Aerosol Only	Aerosol Only	Variable Lace	Clear
78ET			17			✓						Variable Lace	Clear, Green
78HT			15/27			✓						Variable Lace	Clear, Green
80	280°F	≤ 300	15				✓					Variable Lace	Yellow
90	210°F	≤ 300	13/23							Aerosol Only		Variable Lace	Clear
90CA	195°F	≤ 200	24					✓	✓	Aerosol Only	Aerosol Only	Variable Lace	Clear
92			23/34		✓							Variable Lace	Clear, Red
94CA			28/34		✓	✓		Cylinder Only	✓		✓	Pebble	Clear, Red
94ET	190°F	≤ 200	21/25		✓			✓	✓	✓	✓	Pebble	Clear, Red
100NF			46	✓				✓	✓	✓	✓	Pebble	Lavender, Neutral
1000NF	400°F	≤ 400	50	✓		✓		✓	✓	✓	✓	Pebble	Purple, Neutral
1049	TBD	TBD	55	✓			✓		✓		✓	Mist	Clear
1100NF	TBD	TBD	55	✓					✓		✓	Mist	Clear
1357			25			✓						Lace	Gray-Green, Light Yellow
2000NF			49	✓				✓	✓	✓	✓	Pebble	Blue, Light Orange, Neutral
4491			24				✓					Lace	Light Tan

*Solid weight percent can vary by format.

Heavy Duty

30NF



3M™ Fastbond™ Contact Adhesive 30NF

- Water-dispersed, high strength contact adhesive
- Long bonding range with high immediate bond strength
- Bonds most foamed plastics, plastic laminate, wood, plywood, wood veneer, canvas and more

Green	Neutral
Bulk	Bulk
1 Gallon Pail	1 Gallon Pail
5 Gallon Pail	5 Gallon Pail
Open Head Steel Drum	Open Head Steel Drum
270 Gallon Poly Tote	

90

3M™ Hi-Strength 90 Spray Adhesive

- High strength and fast-tack adhesive performance
- Bonds to concrete, wood, MDF, laminates and polyethylene
- High temperature and moisture resistance

Clear	Inverted
Aerosol	Aerosol
12.23 oz.	
17.6 oz.	
Cylinder	
Large	
Intermediate	
Jumbo	
Bulk	
5 Gallon Pail	
Open Head Steel Drum	

90CA



3M™ Hi-Strength 90CA Spray Adhesive Low VOC <25%

- High strength and fast-tack adhesive performance
- Bonds to concrete, wood, MDF, laminates and polyethylene
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear
Aerosol

92

3M™ Hi-Strength Laminating 92 Adhesive

- High performance laminating adhesive for large surfaces
- High solids and high coverage
- Lace spray pattern and fast-tack adhesive performance

Clear	Red
Cylinder	Cylinder
Large	Large
Intermediate	Intermediate
Jumbo	
Bulk	
5 Gallon Pail	
Closed Head Steel Drum	

94CA



3M™ Hi-Strength Postforming 94CA Spray Adhesive

- Unique, non-telegraphing spray pattern delivers postformable strength
- High solids maximise coverage
- Low VOC, SCAQMD Rule 1168 compliance

Clear	Red
Cylinder	Cylinder
Large	Large
Intermediate	Intermediate
Bulk	Bulk
5 Gallon Pail	5 Gallon Pail
Closed Head Steel Drum	Closed Head Steel Drum
Open Head Steel Drum	Open Head Steel Drum

94ET



3M™ Hi-Strength 94ET Spray Adhesive Low VOC <20%

- Unique, non-telegraphing spray pattern delivers postformable strength
- Long open time
- Meets CARB/OTC VOC requirements, SCAQMD Rule 1168 compliance, helps contribute to LEED® Credits, and low VOC

Clear	Red
Aerosol	Aerosol
Cylinder	Cylinder
Large	Large
Intermediate	Intermediate
Bulk	Bulk
5 Gallon Pail	5 Gallon Pail
Closed Head Steel Drum	Closed Head Steel Drum

1357

3M™ Neoprene High Performance Contact Adhesive 1357

- High performance contact adhesive with long bonding range and excellent initial strength
- Resists heat and continuous load stress
- Meets MIL-A-21366A, MMM-A-121

Grey-Green	Light Yellow
Bulk	Bulk
1 Gallon Pail	1 Gallon Pail
5 Gallon Pail	5 Gallon Pail
Agitator Steel Drum	Agitator Steel Drum
Open Head Steel Drum	

2000NF



3M™ Fastbond™ Contact Adhesive 2000NF

- A water-dispersed, high solids activated adhesive
- Immediate bonding and handling strength without forced drying

Blue	Light Orange
Bulk	Bulk
5 Gallon Pail	5 Gallon Pail
Open Head Steel Drum	Open Head Steel Drum
270 Gallon Poly Tote	270 Gallon Poly Tote
Neutral	
Bulk	
5 Gallon Pail	
5 Gallon Box	
Open Head Steel Drum	
270 Gallon Poly Tote	

Multipurpose

49



3M™ Fastbond™ Insulation Adhesive 49

- Fast-tacking, high performance, water-based, pressure-sensitive adhesive
- Ideal for lightweight materials such as fibreglass, felt, shoddy and paper
- Low VOC content

Clear
Bulk
5 Gallon Pail
5 Gallon Box
Open Head Steel Drum
Poly Drum
Poly Tote
255 Gallon EZ Drain Tote
100 Gallon EZ Tote

60CA

3M™ General Purpose Adhesive 60CA

- Low VOC, general-purpose industrial-grade adhesive with lace spray pattern
- High solids content
- Bonds fabric, foam, plastic, heavy paper to wood, plastics and metals

Clear
Cylinder
Large
Intermediate
Bulk
5 Gallon Pail
Closed Head Steel Drum

70

3M™ HoldFast 70 Spray Adhesive

- Extremely versatile, fast-tacking, industrial-grade adhesive
- Unique wide-web spray pattern with heavy body and low soak-in formula
- Bonds polystyrene without degrading the surface

Clear	
Cylinder	Bulk
Mini	5 Gallon Pail
Large	Closed Head Steel Drum
Intermediate	
Jumbo	

77MP

3M™ Super 77™ Multipurpose Spray Adhesive

- High tack, high coverage and low soak-in formula
- Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
- Bonds in 15 seconds

Clear	
Aerosol	
13.44 oz.	
16.0 oz.	

77
Classic**3M™ Super 77™ Classic Spray Adhesive**

- Original formula
- Fast aggressive tack and low soak-in of adhesive
- Bonds lightweight materials
- Bonds in 10–15 seconds

Clear	
Aerosol	
16.75 oz.	
Cylinder	
Large	
Bulk	
5 Gallon Pail	
Open Head Steel Drum	

77CA

**3M™ Super 77™ CA Multipurpose Spray Adhesive Low VOC <25%**

- Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
- Low soak-in and long open time
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear	
Aerosol	

1049

3M™ Fastbond Pressure Sensitive Spray Adhesive 1049

- Bonds a variety of lightweight substrates
- Once surface bonding
- Water-based adhesive is non-flammable
- Plasticiser resistant
- Meets CARB and OTC VOC requirements

Clear	
Cylinder	Bulk
Large	1 Gallon Pail
	5 Gallon Pail
	52 Gallon Drum
	270 Gallon Tote

Foam & Fabric

74

3M™ Foam Fast 74 Spray Adhesive

- Fast-tacking adhesive with soft, non-dimpling bond lines
- Immediate foam-tearing strength
- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more

Clear		Orange	
Aerosol		Aerosol	
Cylinder		Cylinder	
Large		Large	
Intermediate		Intermediate	
Jumbo		Jumbo	

74CA

**3M™ Foam Fast 74CA Spray Adhesive Low VOC <25%**

- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more
- Soft, non-dimpling glue lines
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear		Orange	
Aerosol		Aerosol	

100NF

**3M™ Fastbond™ Foam Adhesive 100NF**

- A water-dispersed, neoprene-based contact adhesive
- One part, rapid setting adhesive
- Ideal for bonding foam to many substrates such as wood, metal, fabrics and more

Lavender		Neutral	
Bulk		Bulk	
5 Gallon Pail		5 Gallon Pail	
Open Head Steel Drum		Open Head Steel Drum	
Poly Drum		Poly Drum	
270 Gallon Poly Tote		270 Gallon Poly Tote	
100 Gallon EZ Tote			

1100NF

**3M™ Fastbond™ Foam Adhesive 1100NF**

- Bonds a variety of foam and fabric substrates
- Water-based, acrylic adhesive is non-flammable
- Mist spray, contact adhesive
- Meets CARB and OTC VOC Requirements

Clear		Neutral	
Cylinder		Bulk	
Large		50 Gallon Open Head Steel Drum	
Bulk		255 Gallon Tote	
1 Gallon Pail			
5 Gallon Pail			

Specialty

71

**3M™ Hi-Tack Composite Spray Adhesive 71**

- Specifically designed to optimize the ultimate strength of resin-infused composite parts
- Consistent fine mist spray with high adhesive solids content for exceptional coverage
- Meets CARB and OTC VOC requirements

Clear		Green	
Aerosol		Aerosol	
Cylinder		Cylinder	

72

3M™ Pressure Sensitive Spray Adhesive 72

- Pressure-sensitive adhesive gains strength as pressure is applied
- Permanent tack ideal for many one-surface bond applications
- Long open time allows bonds to be made hours or days after application
- Variable-width lace spray pattern allows for precise dispensing

Blue	
Aerosol	

76

3M™ Hi-Tack 76 Spray Adhesive

- High tack spray adhesive creates quick, strong bonds
- Bonds hard-to-hold surfaces such as plastics to rubber, fabric, cardboard, wood, metal and more
- Variable-width lace spray pattern

Clear	
Aerosol	

78

3M™ Polystyrene Insulation 78 Adhesive

- High solids adhesive formulated for expanded polystyrene and foam insulations
- Bonds without cavitating foams
- Fast grabbing, fast drying formula

Clear	
Aerosol	
Bulk	
5 Gallon Pail	

78ET

3M™ Polystyrene Insulation 78ET Adhesive

- Bonds polystyrene with no surface degradation
- Long tack time extends working time
- Uniform spray pattern ensures fast and easy application

Clear		Green	
Cylinder		Cylinder	
Large		Large	
Intermediate		Intermediate	
Jumbo		Jumbo	

78HT

3M™ Hi-Temperature Polystyrene Insulation 78HT Adhesive

- Permanently bonds to polystyrene foam and other materials
- Will not degrade the foam
- Sprays with a lace pattern optimized for foam

Blue	
Cylinder	
Large	
Intermediate	
Jumbo	

80

3M™ Rubber and Vinyl 80 Spray Adhesive

- High strength adhesive provides strong bonds for rubber and vinyl
- High temperature and plasticiser resistant
- Fast-setting contact adhesive produces rapid results

Yellow
Aerosol

1000NF



3M™ Fast Tack Water Based Adhesive 1000NF

- Quick bond in a one-part adhesive
- High coverage with potential for one surface application
- Bonds a wide variety of substrates with high temperature resistance
- Meets California and OTC state VOC requirements and helps contribute to LEED® credits

Neutral	Purple
Bulk	Bulk
1 Gallon Pail	1 Gallon Pail
5 Gallon Pail	5 Gallon Pail
Open Head Steel Drum	Open Head Steel Drum
Closed Head Poly Drum	Closed Head Poly Drum
255 Gallon Poly Tote	255 Gallon Poly Tote

4491

3M™ 4491 Adhesive

- Fast-drying adhesive with good resistance to plasticiser migration
- Bonds many vinyl extrusions and sheeting
- Excellent environmental resistance

Light Tan
Bulk
5 Gallon Pail
345 Gallon Tote

3M™ Fastbond™ Spray Activator 1

- Water-dispersed formula is low VOC
- High coverage with mist spray application
- Spray activator compatible with 100NF and 2000NF

Bulk
5 Gallon Pail
30 Gallon Tight Head Drum

Industrial Cleaner

Citrus Base Cleaner

- Removes grease, oil, ink and most adhesives without the need to soak
- Provides mold-release agents
- Removes adhesive without damaging the surface underneath

Aerosol

3M™ Silicone Lubricant

- Reliable lubricant can be used in a wide variety of applications
- Fast drying to maintain productivity
- Long lasting and non-staining to keep work surfaces clean

Aerosol

3M™ Silicone Spray Low VOC 60%



Aerosol

3M™ Adhesive Remover

- Removes grease, oil, ink and most adhesives without the need to soak
- Provides mold-release agents
- Removes adhesive without damaging the surface underneath

Aerosol

3M™ Adhesive Remover Low VOC < 20%



Aerosol

Cylinder Equipment

Applicator	Hoses
Reduced Output "H"	6 ft.
Regular Output	12 ft.
High Output	25 ft.
Extended Applicator	50 ft.
Fitting	Tips
T-Fitting	QSS
Swivel	4001
	6501
	9501
	250050
	650050

Water Based Cylinder Equipment

3M™ Performance Water-Based Cylinder Spray Nozzles

5/Box

3M™ Performance Water-Based Cylinder Spray Applicator Kit

4/Case

3M™ Performance Water-Based Cylinder Spray Adhesive Pex Hose

1/Case



*Meets applicable 2017 California Air Resource Board VOC limits for mist and web spray adhesives.



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