



**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 goes to work to

find the best products to help maximise your product performance, increase your efficiency and streamline your assembly productivity.

## 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
- Optimised 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

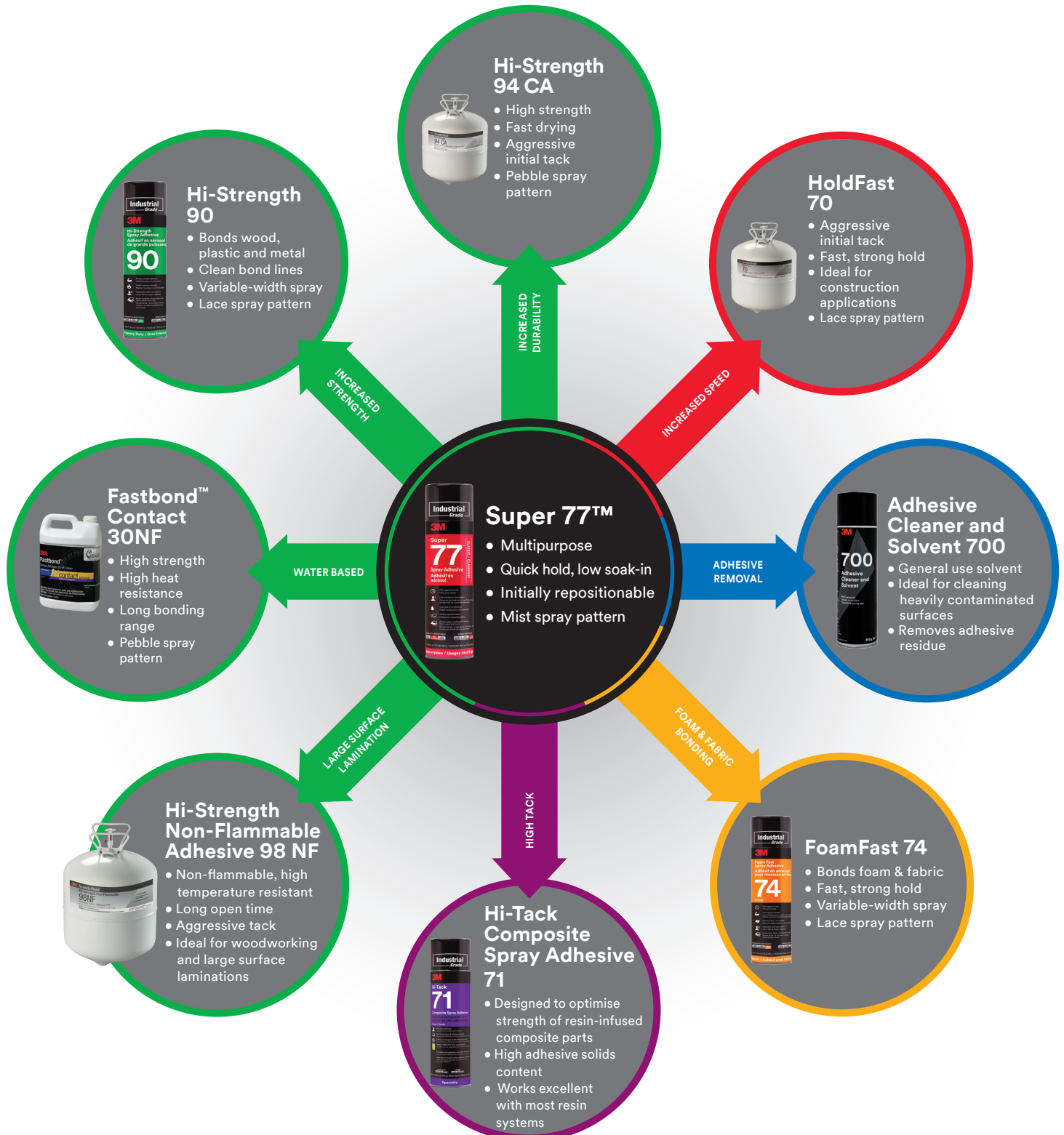
Maximising sustainability doesn't have to mean giving up performance. For more than 40 years 3M engineers have been developing water-based low VOC adhesives.





## 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.



● MULTIPURPOSE   
 ● HEAVY DUTY   
 ● FOAM & FABRIC   
 ● SPECIALTY   
 ● INDUSTRIAL CLEANER

To find out more about the available formats for each product, please contact your 3M representative.

## Adhesive Selector: Find the right adhesive by selecting the substrates you're bonding

Choose Substrate/Process	Spray Adhesive
Paper, Cardboard	77
Fabric, Felt, Fiberglass, Cork	70, 77, 78ET
Flexible Foam: Urethane, Latex	74, 74NF
Rigid Foam: Polystyrene, Beadboard	70, 78, 30NF
High Pressure Laminates, Melamine	90, 94CA, 30NF
Wood, MDF, Particle Board	90, 94CA, 30NF
Metal: Steel, Aluminum	90, 94CA, 30NF
Plastics: ABS, PVC, Phenolic, Acrylic	90, 94CA, 30NF
FRP: Fiberglass Reinforced Plastic	70, 90, 94CA, 30NF
Painted Surfaces	90, 94CA, 30NF
Rubbers: Nitrile, Neoprene, SBR	70, 80, 90, 94CA
Plasticised Vinyl	80
Dry Lay Up (Composite Manufacturing)	71

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	Non-Flammable	Bonding Range – One Surface	Solids* %	Bonding Range – Two Surfaces	Initial Tack	Postforming	Plasticiser Resistant	Spray Pattern	Colour
30NF	149°C	≤ 400	✓	NR	49	15 min-4 hr	Low	✓		Pebble	Green, Neutral
70	88°C	≤ 200		1-60 min	21/26	1-60 min	High			Heavy Body Lace	Clear
71	96°C			15 sec-20 min	19/20	15 sec-20 min	High			Mist / Particulate	Clear / Yellow Green
74	82°C	≤ 200		30 sec-15 min	22/36	30 sec-15 min	Medium			Variable Lace	Clear, Orange
74NF	99°C	≤ 300	✓	1-60 min	24	1-60 min	Medium			Variable Lace	Clear
75	43°C	≤ 50		15 sec-1 min	9	15 sec-1 hour	Low			Mist	Clear
76	110°C	≤ 200		1-10 min	13.5	1-60 min	High			Variable Lace	Clear
77	65°C	≤ 300		15 sec-15 min	25/27/36	15 sec-15 min	High			Mist	Clear
80	149°C	≤ 600		NR	80	3-30 min	Low		✓	Variable Lace	Yellow
90	121°C	≤ 600		NR	13/23	1-10 min	Low			Variable Lace	Clear
94CA	99°C	≤ 500		NR	23	1-30 min	Low	✓		Pebble	Clear, Red
94ET	93°C	≤ 300		NR	21/25	1-60 min	Medium	✓		Pebble	Clear, Red
98NF	115°C	≤ 300	✓	1-5 min	21/24	1-60 min	Medium	✓		Variable Lace	Clear, Red

\* Solid weight percent can vary by format.

# Specifications\*

## 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
- Low VOC

Available format: 4L plastic container

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

Available format: Aerosol

94CA

### 3M™ Hi-Strength Postforming 94CA Spray Adhesive

- Unique, non-telegraphing spray pattern delivers postformable strength
- High solids maximise coverage

Available format: Cylinder

94ET

### 3M™ Hi-Strength 94ET Spray Adhesive

- Unique, non-telegraphing spray pattern delivers postformable strength
- Long open time

Available format: Aerosol

98NF

### 3M™ Hi-Strength Non-Flammable 98NF Spray Adhesive

- Non-flammable in wet stage, fast-tack adhesive
- High strength and temperature resistance
- Versatile, high tack adhesive is ideal for foams or rigid substrates
- Non-flammable solvent and propellant

Available format: Cylinder

## 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

Available format: Aerosol

74NF

### 3M™ Non-Flammable Foam Fast 74NF Cylinder Spray Adhesive

- Non-flammable, fast-tack adhesive
- Soft, non-dimpling bond lines and foam-tearing strength
- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more

Available format: Cylinder

## Industrial Cleaner

### 3M 700 Adhesive Cleaner and Solvent

- Versatile general purpose solvent spray
- Ideal for cleaning heavily contaminated surface prior to Bonding
- Used for removal of adhesive residue or dismantling previously bonded articles

Available format: Aerosol

### 3M hIPA Clean 300

- Light duty cleaner
- Isopropyl alcohol (IPA) based cleaner spray
- Cleans surfaces prior to the application of tapes or adhesive

Available format: Aerosol

### 3M 100 Adhesive Cleaner

- This is the Bulk form of 3M 700 Adhesive Cleaner and Solvent

Available format: Can

### 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

Available format: Aerosol

### 3M™ 5-Way Penetrant

- Helps free rusted and frozen bolts, nuts and more
- Displaces moisture and "dries out" electronics
- Light-duty lubricant works well with delicate precision instruments
- Inhibits corrosion during storage

Available format: 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

Available format: Aerosol

### 3M™ Adhesive Remover Cylinder

- Removes grease, oil, ink and most adhesives without the need to soak
- Provides mold-release agents
- Mild, pleasant citrus odor
- Offers an easy way to clean and purge cylinder applicators and hoses
- Useful for cleaning and surface preparation prior to bonding, coating or further processing of parts

Available format: Cylinder

## Multipurpose

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

Available format: Cylinder

77

### 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
- Ideal for dry layup applications in fiberglass infusion process

Available format: Aerosol and cylinder

## Specialty

71

### Hi-Tack Composite Spray Adhesive 71

- Hi tack, resin compatible mist spray aerosol adhesive for resin infused composite applications
- Securely bonds many lightweight materials used in resin infused composites. Such as glass fiber, carbon fiber, nylon fibers, peel ply & transfer mesh
- Compatible with resins used in composite manufacture, including epoxy, vinyl ester & polyester resins

Available format: Aerosol

75

### 3M™ Repositionable 75 Spray Adhesive

- Adhesive holds strong yet removes easily for repeated use
- Low soak-in formula
- Bonds lightweight materials without damage and prevents wrinkling when bonded

Available format: 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

Available format: Aerosol

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

Available format: Aerosol

**Disclaimer:** 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. User is responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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**3M Australia Pty Ltd**  
**Industrial Adhesives and Tapes Division**  
Building A, 1 Rivett Rd  
North Ryde NSW 2113

Phone 136-136 (*Option 2*)  
Web [www.3M.com.au](http://www.3M.com.au)

**3M New Zealand Ltd**  
**Industrial Adhesives and Tapes Division**  
94 Apollo Drive  
Rosedale, Albany North Shore City, Albany

Phone 0800 362 886  
Web [www.3M.co.nz](http://www.3M.co.nz)