

Convenience, portability, productivity.



The 3M™ Sprayable Adhesives portfolio offers a complete continuum of products for bonding a variety of surfaces:

- Aerosol, cylinder and bulk dispensing options
- Water-based adhesives
- Solvent-based adhesives
- GREENGUARD™ Certified and LEED® Compliant Products
- Regulatory compliance solutions

How to choose the right sprayable adhesive.

When you hear “3M™ Sprayable Adhesives” you immediately think quality, innovation and selection. Whatever your performance requirements, 3M has a spray adhesive that will get the job done. But how do you choose the right one for your particular application?

First ask the right questions

- What are the substrates being joined?
- Are there special end-user requirements?
 - LEED® compliance
 - VOC requirements
 - OSHA issues
 - Non-flammability
 - Greenguard™ Certified
- Are there specific product attributes needed?
 - High heat resistance
 - Strength requirements
 - Plasticizer resistance
 - Postforming
- Are there specific manufacturing requirements?
 - Multiple stations
 - Equipment concerns
 - Bonding range times
 - Single surface bonding
- What is the size of the substrate being sprayed?
- What are the issues with your current product?

Then choose a delivery system

Once you’ve narrowed your adhesive choices, the next step is to decide which package works best for your application. 3M Sprayable Adhesives come in three basic delivery systems: aerosol cans, cylinders and bulk.

Aerosols



3M's Premium Aerosol Adhesives have been delivering performance and value for more than 40 years.

3M Aerosol Cans are the ultimate in convenience. They're portable, simple to use and require no additional equipment. Aerosols are especially suited for small, multi-station assembly lines.

3M™ Low VOC Aerosol Adhesives

With significantly lower VOCs than 3M's trusted industrial standards, these “future friendly” products deliver the performance you’ve come

to expect from 3M Aerosols. Plus, all meet CARB/OTC VOC requirements, are GREENGUARD Children & Schools™ Certified and can help contribute to LEED® credits. In fact, 3M Low VOC Aerosol Adhesives meet the most stringent air quality regulations in the U.S., including California.



3M™ Series 20 Aerosol Spray Adhesives deliver industrial-strength performance, economically.



3M™ Low VOC Aerosol Adhesives help reduce your environmental footprint while maintaining or improving adhesive performance.

Cylinders

3M Cylinders are self-contained and pressurized. Available in a variety of sizes, they're portable and require minimal equipment investment and maintenance. Their optimized spray patterns cut waste and maximize adhesive coverage.












Bulk

3M Bulk Adhesives are available in many of the same formulations as other 3M Sprayable Adhesives, only packaged in larger containers. With existing equipment, it's hard to beat the cost efficiency and productivity of 3M Bulk Adhesives.

Adhesive Selector: Substrates

	Substrates					
	Wood, MDF, Particle Board	High Pressure Laminates, Melamine	Flexible Foam: Urethane, Latex	Rigid Foam: Polystyrene, Beadboard	Paper, Cardboard	Fabric, Felt, Fiberglass, Cork
Aerosol	20, 90	20, 90	24, 74	78	27, 77	20, 27, 77
Cylinder	94CA, 94ET, 98NF	94CA, 94ET, 98NF	74, 74NF	70, 78ET	77	70, 77, 78ET
Solvent-based Bulk	94CA, 94ET, 98NF	94CA, 94ET, 98NF	74	78	77	77
Water-based Bulk	30NF, 2000NF, 1000NF	30NF, 2000NF, 1000NF	100NF, 2000NF, 1000NF	30NF, 2000NF, 1000NF	49, 1000NF	49, 2000NF, 1000NF















Adhesive Selector: Attributes

	Product									
	20	24	27	30NF	49	70	74	74NF	77	78
Packaging Available	Aerosol	Aerosol	Aerosol	Cylinder, Water-based Bulk	Water-based Bulk	Cylinder	Aerosol, Cylinder, Bulk	Cylinder	Aerosol, Cylinder, Bulk	Aerosol, Bulk
Heat Resistance (°F)	210	170	140	300	250	190	180	210	150	190
Shear Strength psi	up to 300	up to 300	up to 200	up to 400	50	up to 200	up to 200	up to 300	up to 300	up to 300
Non-flammable										
Bonding Range – One Surface	1-10 min	30 sec-15 min	15 sec-5 min	NR	30 days plus	1-60 min	30 sec-15 min	1-60 min	15 sec-15 min	1-5 min
Bonding Range – Two Surface	1-15 min	30 sec-30 min	15 sec-10 min	15 min-4 hr	30 days plus	1-60 min	30 sec-15 min	1-60 min	15 sec-15 min	1-15 min
Initial Tack	Medium	Medium	Medium	Low	High	High	Medium	Medium	High	Medium
Postforming				✓						
Class A Rating: ASTM E-84					✓	✓			✓	
Plasticizer Resistant					✓					
GREENGUARD™ Certified										
Low VOC Version Available										
LEED® Compliant	✓	✓	✓	✓	✓		Aerosol Only		Aerosol Only	Aerosol Only
California Compliant	✓	✓	✓	✓	✓		Aerosol Only		Aerosol Only	Aerosol Only
Spray Pattern	Variable Lace	Variable Lace	Mist	Pebble	Pebble	Heavy Body Lace	Variable Lace	Variable Lace	Mist	Variable Lace
Color	Clear	Orange	Clear	Green, Neutral	Clear	Clear	Clear, Orange	Clear, Red	Clear	Clear

Adhesive Selector: Substrates




	Substrates					
	Metal: Steel, Aluminum	Painted Surfaces	Plastics: ABS, PVC, Phenolic, Acrylic, etc	FRP: Fiberglass Reinforced Plastic	Rubbers: Nitrile, Neoprene, SBR	Plasticized Vinyl
Aerosol	20, 90	20, 90	20, 90	20, 90	20, 80, 90	80
Cylinder	90, 94CA, 94ET	90, 94CA, 94ET	90, 94CA, 94ET	70, 90, 94CA, 94ET	70, 90, 94CA, 94ET	
Solvent-based Bulk	90, 94CA, 94ET, 1357	90, 94CA, 94ET, 1357	90, 94CA, 94ET, 1357, 4491	90, 94CA, 94ET, 1357	90, 94CA, 94ET, 1357, 4491	4491
Water-based Bulk	30NF, 1000NF	30NF, 2000NF, 1000NF	30NF, 2000NF, 1000NF	30NF, 2000NF, 1000NF	30NF, 2000NF	4224NF, 1000NF

Adhesive Selector: Attributes

	Product											
	78ET	80	90	94CA	94ET	98NF	100NF	1000NF	1357	2000NF	4224NF	4491
Packaging Available	Cylinder	Aerosol	Aerosol, Cylinder, Bulk	Cylinder, Bulk	Aerosol, Cylinder, Bulk	Cylinder, Bulk	Water- based Bulk	Water- based Bulk	Solvent- based Bulk	Water- based Bulk	Water- based Bulk	Bulk
Heat Resistance (°F)	200	300	250	210	200	240	230	300	300	300	120	300+
Shear Strength psi	up to 200	up to 600	up to 600	up to 500	up to 300	up to 300	up to 300	up to 400	up to 600	up to 400	up to 200	500+
Non-flammable												
Bonding Range – One Surface	1-60 min	NR	NR	NR	NR	1-60 min	30 sec- 20 min	1-5 min	NR	NR	30 days plus	2-10 min
Bonding Range – Two Surface	1-60 min	3-30 min	1-10 min	1-30 min	1-60 min	1-60 min	30 sec- 20 min	1-10 min	5-30 min	30 sec- 2 hr	30 days plus	2-20 min
Initial Tack	Medium	Low	Low	Low	Medium	Medium	Medium	Medium	Medium	Low	High	Medium
Postforming				✓					✓			
Class A Rating: ASTM E-84	✓			✓	✓							
Plasticizer Resistant		✓						✓			✓	✓
GREENGUARD™ Certified												
Low VOC Version Available												
LEED® Compliant			Aerosol Only	✓	✓		✓	✓		✓	✓	Bulk only
California Compliant			Aerosol Only	✓	✓		✓	✓		✓	✓	Bulk only
Spray Pattern	Variable Lace	Variable Lace	Variable Lace	Pebble	Pebble	Variable Lace	Pebble	Pebble	Lace	Pebble	Pebble	Lace

3M™ Sprayable Adhesives

Availability Key

 Aerosols  Cylinders  Bulk

Product	Key Attributes	Product	Key Attributes
3M™ Heavy Duty 20 Spray Adhesive 	<ul style="list-style-type: none"> High strength, fast-grabbing, industrial-grade adhesive Variable-width spray pattern Forms powerful, permanent bonds to a variety of substrates 	3M™ Polystyrene Insulation 78ET Adhesive 	<ul style="list-style-type: none"> Bonds polystyrene with no surface degradation Long tack time extends working time Uniform spray pattern ensures fast and easy application
3M™ Foam & Fabric 24 Spray Adhesive 	<ul style="list-style-type: none"> Fast-tack, industrial-grade adhesive Aggressive tack with foam-tearing strength Bonds foam to a wide range of substrates 	3M™ Rubber and Vinyl 80 Spray Adhesive 	<ul style="list-style-type: none"> High performance, neoprene-based contact adhesive Bonds plasticized vinyls and rubbers High temperature resistance
3M™ Multi-Purpose 27 Spray Adhesive 	<ul style="list-style-type: none"> Versatile, economical, industrial-grade adhesive Bonds paper, fabrics, cardboard, soft foams and more Fast-tack, mist spray pattern 	3M™ Hi-Strength 90 Spray Adhesive    	<ul style="list-style-type: none"> Extremely high strength and fast-tack adhesive Bonds to concrete, wood, MDF, laminates and polyethylene High temperature and moisture resistance
3M™ Fastbond™ Contact Adhesive 30NF   	<ul style="list-style-type: none"> 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 	3M™ Hi-Strength Postforming 94CA Spray Adhesive   	<ul style="list-style-type: none"> Unique, non-telegraphing spray pattern delivers postformable strength High solids maximizes coverage Low VOC, SCAQMD Rule 1168 and LEED® compliant
3M™ Fastbond™ Insulation Adhesive 49  	<ul style="list-style-type: none"> Fast-tacking, high performance, pressure-sensitive adhesive Ideal for lightweight materials such as fiberglass, felt, shoddy and paper Low VOC and LEED® compliant 	3M™ Hi-Strength 94ET Spray Adhesive    	<ul style="list-style-type: none"> Bonds many laminates, woods and particle board Long open time, Low VOC Meets CARB/OTC VOC requirements, SCAQMD Rule 1168 compliance, helps contribute to LEED® credits
3M™ HoldFast 70 Spray Adhesive 	<ul style="list-style-type: none"> Extremely versatile, fast-tacking, industrial-grade adhesive Unique wide-web spray pattern with heavy body and low soak-in Bonds polystyrene without degrading the surface 	3M™ Hi-Strength Non-Flammable 98NF Spray Adhesive  	<ul style="list-style-type: none"> Non-flammable, fast-tack adhesive High strength and temperature resistance Versatile, high tack adhesive is ideal for foams or rigid substrates
3M™ Foam Fast 74 Spray Adhesive     	<ul style="list-style-type: none"> Extremely fast-tacking, industrial-grade adhesive Immediate foam-tearing strength Soft, non-dimpling bond line 	3M™ Fastbond™ Foam Adhesive 100NF  	<ul style="list-style-type: none"> A water-dispersed, neoprene-based contact adhesive One part, rapid setting Bonds porous and non-porous substrates
3M™ Non-Flammable Foam Fast 74NF Cylinder Spray Adhesive 	<ul style="list-style-type: none"> Non-flammable, fast-tack adhesive Foam-tearing strength Soft, non-dimpling bond line 	3M™ Fast Tack Water Based Adhesive 1000NF  	<ul style="list-style-type: none"> Quick bond in a one-part product 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
3M™ Super 77™ Multi-Purpose Spray Adhesive     	<ul style="list-style-type: none"> High tack, high coverage, low soak-in Permanently attaches foils, carpeting, paper, cardboard, felt, cloth and more Bonds in 15 seconds 	3M™ Neoprene High Performance Contact Adhesive 1357 	<ul style="list-style-type: none"> 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
3M™ Polystyrene Insulation 78 Adhesive  	<ul style="list-style-type: none"> High solids adhesive formulated for expanded polystyrene and foam insulations Bonds without cavitating foams Fast grabbing, fast drying 	3M™ Fastbond™ Contact Adhesive 2000NF  	<ul style="list-style-type: none"> A water-dispersed, high solids activated adhesive Immediate bonding and handling strength without forced drying
		3M™ Fastbond™ Pressure Sensitive Adhesive 4224NF  	<ul style="list-style-type: none"> Water-based carpet adhesive Permanent pressure-sensitive adhesive with an aggressive tack Low VOC content and LEED® compliant
		3M™ 4491 Adhesive 	<ul style="list-style-type: none"> Fast-drying adhesive with good resistance to plasticizer migration Bonds many vinyl extrusions and sheeting Excellent environmental resistance

 GREENGUARD™ Certified
 Low VOC version available.

11-Digits & UPCs



Water-based Spray Adhesives







Description	Large Cylinder	1 Gallon Pail	5 Gallon Pail	5 Gallon Box	Open Head Steel Drum	Poly Drum	Poly Tote	255 EZ Drain Tote	100 EZ Tote	30 Gallon Drum
*30NF Green	62-4936-8030-0 31575	62-4276-7530-1 21186	62-4276-8530-0 21187	—	62-4276-9530-9 21188	—	62-4276-9932-7 31344	—	—	—
*30NF Neutral	62-4934-8030-5 31574	62-4274-7530-6 21181	62-4274-8530-5 21182	—	62-4274-9530-4 21183	—	—	—	—	—
*49 Clear	—	—	62-4240-8530-6 45163	62-4240-8436-6 50044	62-4240-9538-8 56556	62-4240-9530-5 45164	62-4240-9932-3 45193	62-4240-9935-6 56521	62-4240-9939-8 56520	—
*100 Neutral	—	—	62-4284-8530-4 39203	62-4284-8436-4 56510	62-4284-9538-6 58713	62-4284-9530-3 39204	62-4284-9932-1 39205	—	—	—
*100 Lavender	—	—	62-4285-8530-1 41542	62-4285-8436-1 56509	62-4285-9538-3 58433	62-4285-9530-0 41543	62-4285-9932-8 41544	—	62-4285-9939-3 56512	—
*1000NF Neutral	—	62-4226-7530-6 64581	62-4226-8530-5 64674	62-4226-8436-5 64675	62-4226-9538-7 64677	62-4226-9530-4 64676	62-4226-9932-2 64678	—	—	—
*1000NF Purple	—	62-4234-7530-0 64679	62-4234-8530-9 64680	62-4234-8436-9 64681	62-4234-9538-1 64683	62-4234-9530-8 64682	62-4234-9932-6 64684	—	—	—
*2000 Neutral	—	—	62-4347-8430-2 89337	62-4347-8436-9 31337	62-4347-9430-1 89338	—	62-4347-9935-9 89341	—	—	—
*2000 Light Orange	—	—	62-4346-8430-4 87953	—	62-4346-9430-3 87955	—	62-4346-9932-8 87959	—	—	—
*2000 Blue	—	—	62-4286-8430-2 87965	—	62-4286-9430-1 87966	—	62-4286-9932-6 87969	—	—	—
*4224 Clear	—	—	62-4261-8530-2 85780	—	62-4261-9530-1 85781	—	—	—	—	—
*4224 Blue	—	—	62-4224-8530-0 21159	—	62-4224-9535-8 65080	—	—	—	—	—
*Activator #1 for 100 and 2000	—	—	62-4446-8530-9 89324	—	—	—	—	—	—	62-4446-9130-7 39289

Cylinder Equipment

Applicator	Reduced Output "H"	Regular Output	High Output	Extended Applicator	T-Fitting	Swivel	
	62-9880-9950-3 25039	62-9880-9930-5 61706	62-9880-9960-2 07329	62-9880-9940-4 25779	62-9880-8348-1 61987	62-9880-7948-9 61992	
Hoses	6'	12'	25'	50'			
	62-9880-0006-3 25036	62-9880-0012-1 61988	62-9880-0025-3 61989	62-9880-0050-1 25782			
Tips	QSS	4001	6501	9501	250050	650050	730154
	62-9880-8148-5 61993	62-9880-4001-0 61990	62-9880-6501-7 61991	62-9880-9501-4 61707	62-9880-8133-7 25780	62-9880-8173-3 25781	62-9880-7301-1 25832

*  GREENGUARD™ Certified

Solvent-based Spray Adhesives

Description	Aerosol	Mini	Large	Intermediate	Jumbo	1 Gallon Pail	5 Gallon Pail	Agitator Steel Drum	Closed Head Steel Drum	Open Head Steel Drum
20 Clear	62-4915-4920-0 07861	—	—	—	—	—	—	—	—	—
24 Orange	62-4923-4920-4 07862	—	—	—	—	—	—	—	—	—
27 Clear	62-4906-4920-9 07832	—	—	—	—	—	—	—	—	—
70 Clear	—	62-4983-8010-4 32201	62-4983-8030-2 61690	62-4983-8150-8 61691	62-4983-8300-9 61692	—	62-4847-8530-8 63935	—	62-4847-9530-7 63934	—
74 Clear	62-4950-4950-4 50045	—	62-4974-8030-1 49919	62-4974-8150-7 25741	62-4974-8300-8 25742	—	—	—	—	—
74 Orange	62-4935-4950-5 82242	—	62-4912-8030-1 49158	62-4912-8150-7 18853	62-4912-8300-8 18854	—	—	—	—	—
 *74 Low VOC Clear	62-4880-4930-5 97967	—	—	—	—	—	—	—	—	—
 *74 Low VOC Orange	62-4879-4930-7 97958	—	—	—	—	—	—	—	—	—
74 Orange Inverted	62-4935-4970-3 07277	—	62-4912-8030-1 49158	62-4912-8150-7 18853	62-4912-8300-8 18854	—	—	—	—	—
74NF Clear	—	62-4998-8010-2 25798	62-4998-8030-0 97160	62-4998-8150-6 97161	62-4998-8300-7 97162	—	—	—	—	—
74NF Red	—	—	—	62-4955-8150-6 92119	62-4955-8300-7 92120	—	—	—	—	—
77 Clear	62-4977-4930-9 21210	—	62-4979-8030-0 25776	—	—	—	62-4458-8530-4 43793	—	62-4458-9530-3 43813	—
 *77 Low VOC Clear	62-4876-4930-3 97956	—	—	—	—	—	—	—	—	—
78 Clear	62-4951-4950-2 41593	—	—	—	—	—	62-4468-8532-9 53438	—	—	—
78 Inverted	62-4951-4970-0 07279	—	—	—	—	—	—	—	—	—
78ET Clear	—	—	62-4984-8030-0 61693	62-4984-8150-6 25704	62-4984-8300-7 61694	—	—	—	—	—
78ET Green	—	—	62-4986-8030-5 61695	62-4986-8150-1 25705	62-4986-8300-2 61696	—	—	—	—	—
80 Yellow	62-4996-4955-6 82618	—	—	—	—	—	—	—	—	—
90 Inverted	62-4942-4970-9 07278	—	62-4994-8030-9 41554	62-4994-8150-5 25774	62-4994-8300-6 25775	—	—	—	—	—
90 Clear	62-4942-4950-1 30023	—	62-4994-8030-9 41554	62-4994-8150-5 25774	62-4994-8300-6 25775	—	62-4479-8532-6 43797	—	—	62-4479-9532-5 43814
 *90 Low VOC Clear	62-4878-4930-9 97957	—	—	—	—	—	—	—	—	—
*94CA Clear	—	62-4960-8010-2 25014	62-4960-8030-0 61703	62-4960-8150-6 61704	62-4960-8300-7 61705	—	62-4924-8530-5 25016	—	62-4924-9530-4 25017	62-4924-9531-2 18858
*94CA Red	—	62-4970-8010-1 25018	62-4970-8030-9 61663	62-4970-8150-5 61664	62-4970-8300-6 61665	—	62-4988-8530-0 61666	—	62-4988-9530-9 61667	62-4988-9531-7 07280
*94CA FF Clear	—	62-4920-8010-6 31576	62-4920-8030-4 31577	62-4920-8150-0 31578	62-4920-8300-1 31579	—	62-4922-8530-9 31581	—	62-4922-9530-8 31582	—
*94CA FF Red	—	—	62-4940-8030-2 31583	62-4940-8150-8 31584	62-4940-8300-9 31585	—	62-4944-8530-3 31586	—	62-4944-9530-2 31588	—
 *94ET Low VOC Clear	62-4870-4930-6 97977	—	62-4871-8030-9 97979	62-4871-8150-5 97980	62-4871-8300-6 97981	—	62-4872-8530-6 97983	—	62-4872-9530-5 97984	—
 *94ET Low VOC Red	62-4873-4930-0 97978	—	62-4874-8030-3 97986	62-4874-8150-9 97987	62-4874-8300-0 97988	—	62-4875-8530-9 97990	—	62-4875-9530-8 97991	—
98NF Clear	—	62-4995-8010-8 25773	62-4995-8030-6 61675	62-4995-8150-2 61676	62-4995-8300-3 61677	—	62-4907-8530-0 18851	—	62-4907-9530-9 18852	—
98NF Red	—	62-4993-8010-3 25772	62-4993-8030-1 61678	62-4993-8150-7 61679	62-4993-8300-8 61680	—	62-4904-8530-7 18847	—	62-4904-9530-6 18848	—
1357 Gray-Green	—	—	—	—	—	62-1357-7530-2 19894	62-1357-8540-0 19897	62-1357-9530-0 19898	—	62-1357-9531-8 19899
1357 Light Yellow	—	—	—	—	—	62-1368-7535-8 22586	62-1368-8536-5 64963	62-1368-9535-6 22589	—	—
4491 Light Tan	—	—	—	—	—	—	62-4491-8530-5 50046	62-4491-9530-4 50047	—	—

*  GREENGUARD™ Certified
 Low VOC version available.



3M's complete line of innovative sprayable adhesives is essential for a wide range of industrial applications, from aerospace to woodworking. For more information, contact your 3M representative, local distributor or call 1-800-362-3550.

www.3M.com/adhesives

WARRANTY, LIMITED REMEDY, AND 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 solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application. Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

3M

**Industrial Adhesives
and Tapes Division**

Building 225-3S-06
St. Paul, MN 55144-1000
1-800-362-3550
www.3M.com/adhesives

LEED® is a registered trademark of the United States Green Building Council (USGBC).
3M, Fastbond and Super 77 are trademarks of 3M.
Please recycle. Printed in USA.
© 3M 2014. All rights reserved.