

3M Hi-Strength 90 Spray Adhesive

Technical Data

March 2012

Product Description

An industrial grade spray adhesive that is typically used for bonding HPL to wood.

Key Features

- A high strength, fast, contact-type adhesive
- Excellent adhesive for decorative laminates, particleboard, and many other materials, even polyethylene, polypropylene, and SBR rubber
- Has excellent heat resistance

Typical 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™ Hi-Strength 90 Spray Adhesive	3M™ Scotch-Weld™ Hi-Strength 90 Cylinder Spray Adhesive	3M™ Hi-Strength 90 Spray Adhesive (Bulk)
Base:	Synthetic Elastomer	Synthetic Elastomer	Synthetic Elastomer
Solids Content - (by wt.):	13%	13%	23%
Density (lbs/gal):	6.0	5.7	6.4
Viscosity (cps):	N/A	N/A	100-500
Color(s):	Translucent	Translucent	Translucent
Volatile Organic Compounds (VOC):	< 55%	571 g/L	356 g/L
Hazardous Air Pollutants (HAPS) % wt (calculated):	<0.4%	No	No
CARB Compliant:	Yes	N/A	N/A
SCAQMD 1168 Compliant:	N/A	No	No
GREENGUARD Indoor Air Quality Certified®:	No	No	No
LEED® Eligible:	Yes	No	No
Coverage @ 2.5 gms /ft ² per lb (sqft):	23.6	23.6	42
Spray Pattern:	Variable Lace	Lace	Lace
Dry Time:	1 minute	1 minute	1 minute
Bonding Range:	1-10 minutes	1-10 minutes	1-10 minutes
Shear Adhesion Failure Test - SAFT ⁽¹⁾ :	250F	250F	250F
Flammable Solvent:	Yes	Yes	Yes
Flammable Propellant:	Yes	Yes	N/A

⁽¹⁾SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90F and ramped 10F every 10 mn. until complete failure.

Available Sizes

Container Size	3M Stock Number	UPC Number
24 Fl. Oz. (Net Wt. 17.6 oz) - Aerosol	62-4942-4950-1	00-021200-30023-3
24 Fl. Oz. (Net Wt. 16.9 oz) – Inverted Aerosol	62-4942-4970-9	00-051111-07278-3
Large Cylinder – 28.8 lbs.	62-4994-8030-9	00-021200-41554-8
Intermediate Cylinder – 141.6 lbs.	62-4994-8150-5	00-051115-25774-2
Jumbo Cylinder – 283.2 lbs.	62-4994-8300-6	00-051115-25775-9
5 gallon pail – 32.5 lbs.	62-4479-8532-6	00-021200-43797-7
54 gallon drum – 338 lbs.	62-4479-9532-5	00-021200-43814-1

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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 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.
Technical Information	The technical information, recommendations and other statements contained in this document are based upon testes or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.
Product Use	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. Given the variety of factors that can affect the use and performance of a 3M product, 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.
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