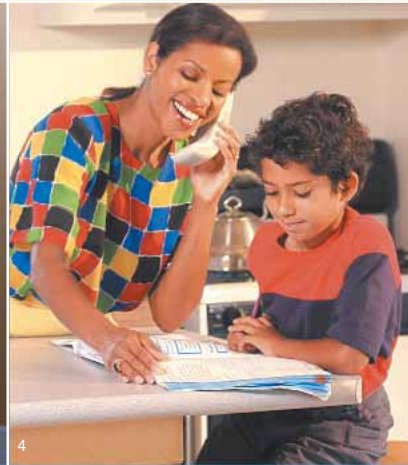


# 3M™ Scotch-Weld™ Cylinder Spray Adhesives

Take the next step  
in bulk productivity...



# Simplify and Save



with the convenience and  
portability of pressurized cylinders



# Convenience and freedom of an aerosol with the productivity of a bulk system

## Convenient 3M cylinder systems

- Increased productivity with fast application and no time-consuming equipment set-up and clean-up
- Freedom from expensive capital equipment and maintenance of spray equipment and compressors
- Targets adhesive where you want with little waste

## Choice of formulations to meet a variety of regulatory requirements

- Non-flammable adhesive/non-flammable propellant
- No ozone-depleting chemicals
- No HAPs • Low VOCs • MACT compliant
- SCAQMD Compliant Contact Adhesives (South Coast Air Quality Management District with some of the toughest standards in the United States)
- Nine adhesives with choice of properties to help optimize production efficiency and end use reliability:
  - High solids for high coverage that puts more usable adhesive to work for your money
  - Fast tacking for immediate handling
  - High strength, high temperature-resistant bonds for demanding applications and continued durability during end product warehousing and shipping



MARKETS

SUBSTRATES

*Compact self-contained pressurized cylinder for go-to-the-job convenience.*

## Effective delivery with adjustable-tip spray gun



7



8



9

*Left to right: Wide web pattern for fast coverage and minimized overspray. Narrow web pattern for targeted application. Pebble pattern for minimized telegraphing.*



# Adhesive selection for many markets... performance for many substrates



*With one gun and the appropriate tip, you can apply spray widths of 1-12". Neatly target defined areas or quickly cover large surfaces.*



*Controlled spray eliminates the waste of puddling, "fire hosing," and uneven stringing pattern (shown above).*

	3M™ Scotch-Weld™ Cylinder Spray Adhesive	Differentiating Features	Application ideas for Markets and Substrates
General Purpose	General Purpose 60 CA*	<ul style="list-style-type: none"> <li>• Very high coverage</li> <li>• Temporary and permanent bonds</li> <li>• SCAQMD Rule 1168 Compliant Contact Adhesive</li> <li>• MACT Compliant</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Furniture:</b> bond soft foam, scrims, and fabric to wood or metal</li> <li>• <b>Bedding:</b> bond foam, felt, or fabric</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds; insulation to walls</li> <li>• <b>Marine:</b> attach carpeting and insulation</li> </ul>
	HoldFast 70	<ul style="list-style-type: none"> <li>• Very fast tacking</li> <li>• Temporary and permanent bonds</li> <li>• Heavy body web spray with low soak in on porous or irregular surfaces</li> <li>• Bonds polystyrene without degrading the surface</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds; insulation to walls;</li> <li>• <b>Marine:</b> attach carpeting and insulation</li> <li>• <b>Construction:</b> bond EPS insulation to wood and concrete; attach fabric and foam to walls for noise abatement; bond rubber matting to metal concrete forms for pre-cast; bond insulation to metal pipes and boilers</li> <li>• <b>Urethane foam</b> to wood, metal, and plastic</li> </ul>
Specialty	FoamFast 74	<ul style="list-style-type: none"> <li>• Fast tacking, quickly reaches foam-tearing strength</li> <li>• Soft, non-dimpling glue line</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Furniture:</b> bond soft foam to itself, fabric, wood, and metal</li> <li>• <b>Bedding:</b> bond foam, felt, or fabric</li> <li>• <b>Foam fabrication:</b> knife edge turning boxing, and edge turning</li> </ul>
	Polystyrene Foam Insulation 78	<ul style="list-style-type: none"> <li>• Fast drying to strength greater than the foam itself</li> <li>• Bonds polystyrene without degrading the surface</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Store displays:</b> bond fabric, felt, plastic to soft foam, FRP, ABS, wood, or metal</li> <li>• <b>Packaging:</b> bond foam corner inserts</li> <li>• <b>Construction:</b> bond EPS insulation to wood and concrete</li> </ul>
	Polystyrene Foam Insulation 78 ET*	<ul style="list-style-type: none"> <li>• Extended tack range for temporary and permanent bonds</li> <li>• Bonds polystyrene without degrading the surface</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Store displays:</b> bond fabric, felt, plastic to soft foam, FRP, ABS, wood, or metal</li> <li>• <b>Motor homes:</b> bond plastic to wood in tub surrounds; insulation to walls</li> <li>• <b>Construction:</b> bond EPS insulation to wood and concrete</li> <li>• <b>Appliances:</b> attach EPS insulation to metal in refrigerators</li> <li>• <b>HVAC:</b> attach insulation to pipes and ductwork</li> </ul>

\* CA: California compliant

ET: Extended Tack

NF2: Non-flammable adhesive and propellant

	3M™ Scotch-Weld™ Spray Adhesive Cylinder	Differentiating Features	Application ideas for Markets and Substrates
High Performance, High Strength, High Temperature	Hi-Strength 90	<ul style="list-style-type: none"> <li>• FDA listed dry ingredients</li> <li>• Fast, high contact bond strength</li> <li>• One to 10-minute open time</li> <li>• Very high temperature resistance</li> <li>• Creep resistance</li> <li>• High peel strength</li> <li>• MACT compliant; HAPs free</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Furniture:</b> bond kickplates to desks</li> <li>• <b>Construction and containment:</b> adhere polyethylene and polypropylene to wood, metal, and other materials; attach plastic signs</li> <li>• <b>Construction:</b> attach plastic cornerbead and expansion joints to drywall; laminate drywall to drywall</li> </ul>
	Hi-Strength Laminating 92	<ul style="list-style-type: none"> <li>• High strength</li> <li>• High temperature resistance</li> <li>• MACT compliant; HAPs free</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Motor homes:</b> bond HPL to wood and steel</li> <li>• <b>Marine:</b> bond HPL to wood and steel; attach carpeting and insulation</li> <li>• <b>Construction:</b> attach plastic cornerbead and expansion joints to drywall; laminate drywall to drywall</li> </ul>
	Hi-Strength Postforming 94 CA*	<ul style="list-style-type: none"> <li>• Postformable high strength</li> <li>• Low telegraphing spray pattern</li> <li>• SCAQMD Rule 1168 Compliant Contact Adhesive</li> <li>• MACT Compliant; HAPs free</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Fixtures:</b> bond HPL to wood and steel</li> </ul>
	Waterbased Hi-Strength Contact Adhesive W99 NF2*	<ul style="list-style-type: none"> <li>• High strength</li> <li>• High temperature resistance</li> <li>• Very high coverage</li> <li>• 1.5 g/liter VOC</li> <li>• SCAQMD Rule 1168 Compliant Contact Adhesive</li> <li>• MACT Compliant; HAPs free</li> </ul>	<ul style="list-style-type: none"> <li>• <b>Woodworking and cabinetry:</b> bond HPL for countertops, cabinets, and shelves</li> <li>• <b>Fixtures:</b> bond HPL to wood and steel</li> <li>• <b>Construction:</b> bond rubber matting to metal concrete forms for pre-cast; bond insulation to metal conduit</li> <li>• <b>Furniture:</b> bond fabrics, non-wovens, or soft foams to metal, wood, and plastic office partitions, walls, and furniture</li> </ul>

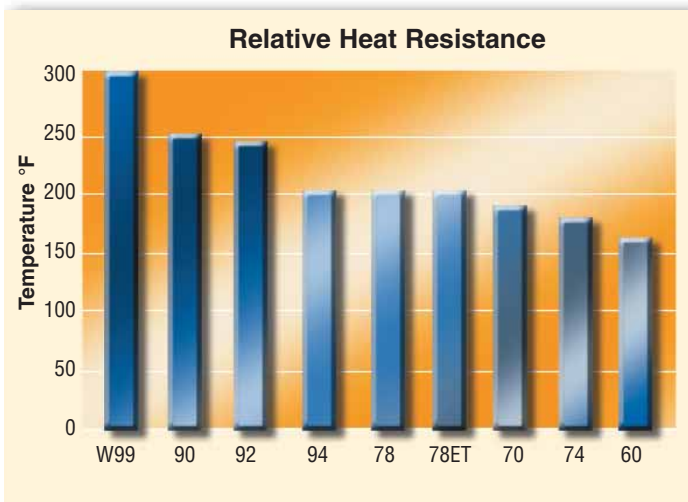
\* CA: California compliant  
ET: Extended Tack  
NF2: Non-flammable adhesive and propellant

# Product Information and Packaging

Product	Flammable Adhesive/ Propellant	Solids % w/propellant	Solids % w/o propellant	California Compliant	VOCs (g/liter)	Dry time (minutes)	Open time (minutes)
General Purpose 60 CA	◆ Yes/Yes	43	43	Yes	79	2-5	2-60
HoldFast 70	◆ Yes/Yes	21	41	No	544	1-4	1-60
FoamFast 74	◆ Yes/Yes	22	36	No	563	1-5	1-15
Polystyrene Foam Insulation 78	◆ Yes/Yes	19	35	No	558	1-5	1-10
Polystyrene Foam Insulation 78 ET	◆ Yes/Yes	17	31	No	570	1-5	1-60
Hi-Strength 90*	◆ Yes/Yes	13	23	No	571	1-5	1-15
Hi-Strength Laminating 92	◆ Yes/Yes	23	34	No	654	1-4	1-20
Hi-Strength Postforming 94 CA	◆ Yes/Yes	28	28	Yes	79	1-5	1-15
Waterbased Hi-Strength W99 NF2	◆ No/No	50	50	Yes	1.5	10-30	10-60

\* Ingredients when dried after application are listed as indirect food additives under FDA regulation 21 CFR 175.105

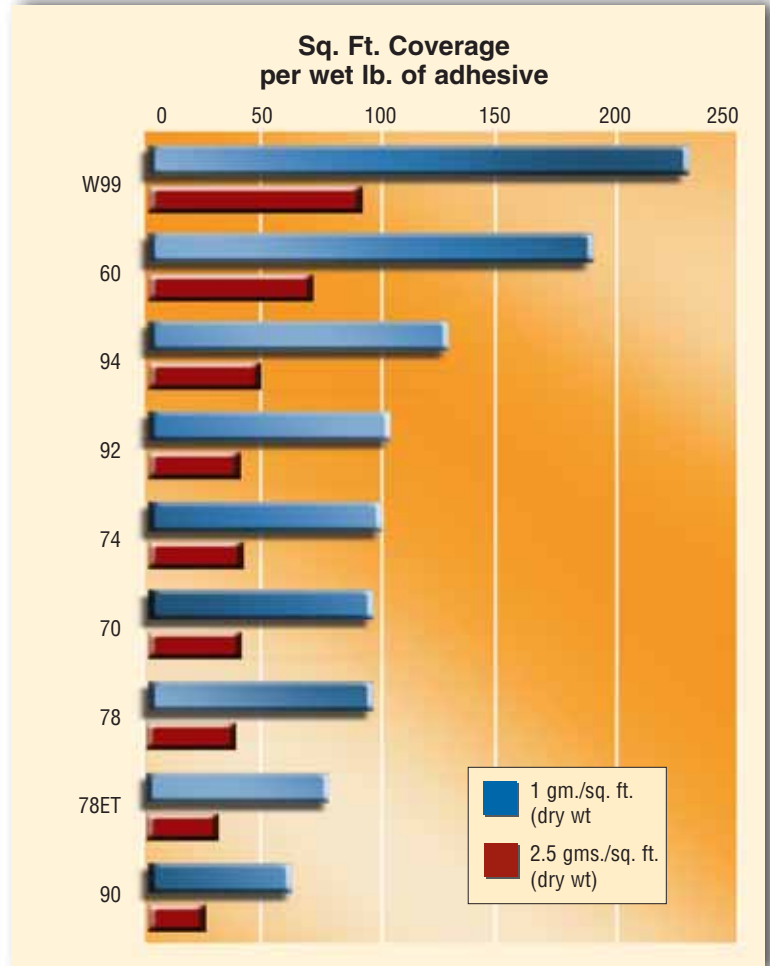
**Note:** This technical information and data should be considered representative or typical only and should not be used for specification purposes.



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



	Temperature Rating	Spray Pattern	MACT Compliant	Color
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	Yes	Clear/Translucent
	Med.	Web	No	Clear or Orange
	High	Web	Yes	Clear/Translucent
	High	Web	No	Green
	Very High	Web	Yes	Clear/Translucent
	Very High	Web	Yes	Clear or Red
	High	Pebble	Yes	Clear or Red
	Very High	Mist	Yes	Neutral



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

Selection Guide for High Performance, High Temperature Laminating Adhesives	Starting Product	Added features	Product
	92	High temperature and creep resistance	90
		Postformable, CA compliant, reduced open time, low telegraphing	94 CA
		Water-based non-flammable adhesive/non-flammable propellant	W99 NF2

### Size Availability



Product	Cylinder sizes				Bulk	
	Mini	Large	Intermediate	Jumbo	5-gal	55-gal
60 CA		X	X	X		
70		X	X	X		
74		X				
78		X			X	X
78 ET		X		X		
90	X	X			X	X
92		X	X	X		
94 CA	X	X	X	X	X	X
W99 NF2		X				

# Equipment simplification with 3M™ Scotch-Weld™ Cylinder Spray Adhesives



*Compare the equipment and tools needed for a typical compressor and drum operation (above) with the savings and simplicity of the 3M™ Scotch-Weld™ Cylinder Spray Adhesives system (at right).*



3M™ Scotch-Weld™ Cylinder Spray Adhesive Equipment and Accessories	
Description	
Cylinder Adhesive Applicator (includes 9501 Tip)	
Cylinder Adhesive Applicator H (includes 4001 Tip)	
Cylinder Adhesive 9501 Spray Tip	
Cylinder Adhesive 4001 Spray Tip	
Cylinder Adhesive 6501 Spray Tip	
Cylinder Adhesive QSS Spray Tip	
Cylinder Adhesive Hose Swivel	
Cylinder Adhesive T-Fitting	
Cylinder Adhesive 6-Foot Hose	
Cylinder Adhesive 12-Foot Hose	
Cylinder Adhesive 25-Foot Hose	

**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:** 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. **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, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to repair or replace the product or refund the purchase price. **LIMITATION OF LIABILITY:** Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.



**Industrial and Transportation Business  
Industrial Adhesives and Tapes Division**

3M Center Bldg. 21-1W-10  
900 Bush Ave.  
St. Paul, MN 55144  
1-800-362-3550  
www.3M.com/adhesives

3M and Scotch-Weld are  
trademarks of 3M Company.  
Printed in U.S.A.

78-9236-7134-7  
© 2007 3M