

# Hot Melt Adhesives Jet-melt™ & Hot Melt Spray

The image shows the iconic 3M logo in a bold, red, sans-serif font. The '3' is a single digit, and the 'M' is a double-digit 'M'. The logo is centered horizontally and vertically within its white rectangular background.

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*SERVING INDUSTRY  
FOR OVER 73 YEARS*



# 3M™ Scotch-Weld™ Hot Melt Adhesives and Applicators

## The 3M systems approach to help you improve productivity and lower costs

3M™ Scotch-Weld™ Hot Melt Adhesives and Applicators are advanced hand-held systems to help you improve productivity, lower cost, and minimize waste.

Adhesives are 100% solids thermoplastic resins that become fluid when heated and quickly wet the bonding surface. They cool, harden, and reach bond strength in seconds. You can move assemblies immediately to keep production flowing. This helps eliminate clamps, fixturing and drying, and saves time, energy, and space.

Each adhesive is designed and precisely manufactured for efficient use in one of the portable 3M™ Scotch-Weld™ Hot Melt Applicators. Bond wood, plastic, foam, fabric, cardboard, and more.



3M™ Scotch-Weld™ Hot Melt Applicator EC can be used with 3M low temperature (265°F/129°C) adhesive to effectively bond heat-sensitive substrates such as styrene foam.



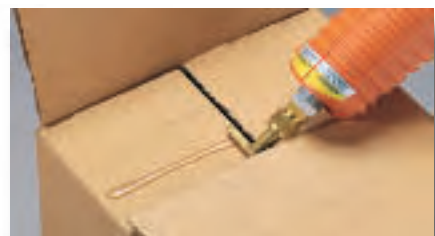
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For bonding the guide to a drawer bottom, 3M™ Scotch-Weld™ Hot Melt Adhesive 3738 provides high delivery rate and long bonding range to meet production requirements.



For versatility in P.O.P. assembly, 3M™ Scotch-Weld™ Hot Melt Adhesives bond a variety of plastics, woods, and light gauge metals.



For economical package sealing 3M™ Scotch-Weld™ Hot Melt Adhesive 3762 is a versatile formulation with 35-second bonding range for production speed. Variety of tips for package types.



For great value, 3M™ Scotch-Weld™ Hot Melt Applicator AE II combines the best features of a high volume industrial system into a compact, self-contained applicator that delivers up to 4 pounds of adhesive per hour. Plugs into any 110V outlet for convenient portability.



3M™ Scotch-Weld™ Hot Melt Applicator LT and 3M™ Scotch-Weld™ Hot Melt Adhesives applied at low temperature (265°F/129°C) make quick work of wetting, gimping, and bonding fabric to wood.








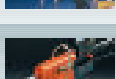


Combine 3M™ Scotch-Weld™ Hot Melt General Purpose Adhesive 3750 and the 3M™ Scotch-Weld™ Hot Melt Applicator AE II for a high volume system at a great value. Easily keep up with demanding packaging and wood assembly applications.



## Product Information: 3M™ Scotch-Weld™ Hot Melt Applicators

These lightweight, easy-to-use units use 3M's innovative melt-on-demand or progressive feed technology.

3M™ Scotch-Weld™ Hot Melt Applicator	Weight <sup>(1)</sup>	Output <sup>(2)</sup> lb/hr	Temperature <sup>(3)</sup>	Adhesive		Accessories Available <sup>(4)</sup> (see keyed photos below)
				Type	Size dia. x length, inches	
 76 3M™ Scotch-Weld™ Hot Melt Applicator LT	10.0 oz.	2.6	265°F (129°C)	LM TC	5/8 x 2	Tips ① <sup>(4)</sup> , Benchstand ⑥, Quadrack Converter ②, Palm Trigger ③
 77 3M™ Scotch-Weld™ Hot Melt Applicator LT with Quadrack™ Converter	13.8 oz.	2.6	265°F (129°C)	LM Q	5/8 x 8	Tips ①, Benchstand ⑥
 78 3M™ Scotch-Weld™ Hot Melt Applicator TC	10.0 oz.	3.5	385°F (196°C)	TC	5/8 x 2	Tips ①, Benchstand ⑥, Quadrack Converter ②, Palm Trigger ③
 79 3M™ Scotch-Weld™ Hot Melt Applicator TC with Quadrack™ Converter	13.8 oz.	3.5	385°F (196°C)	Q	5/8 x 8	Tips ①, Benchstand ⑥
 80 3M™ Scotch-Weld™ Hot Melt Applicator AE II	20.0 oz.	4.0	400°F (204°C)	AE	1/2 x 12	Includes stand
 81 3M™ Scotch-Weld™ Hot Melt Applicator EC	24.0 oz.	5.5	260°F-450°F (127°-232°C)	Q and LMQ	5/8 x 8	Tips ①, Benchstand ⑥
 82 3M™ Scotch-Weld™ Hot Melt Applicator PG II LT with Speedloader	4.3 lbs.	6.0	265°F (129°C)	LM PG	1 x 3	Tips ①, Magazine Feeder ⑦, Heavy-Duty Benchstand ⑤, Benchmount ⑧, Foot Pedal ④,
 83 3M™ Scotch-Weld™ Hot Melt Applicator PG II with Speedloader	4.3 lbs.	7.5	385°F (196°C)	PG	1 x 3	Tips ①, Magazine Feeder ⑦, Heavy-Duty Benchstand ⑤, Benchmount ⑧, Foot Pedal ④,

(1) Weight shown is for applicator only — does not include adhesive capacity.

(2) Adhesive output will vary with conditions and the adhesive used. Values are approximate and are based on maximum steady-state flow.

(3) Temperatures shown are nominal control values. Actual temperature will range slightly above and below this value.

(4) Accessory tips used will depend on applicator selected and adhesive used.

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

## Accessories to improve your productivity

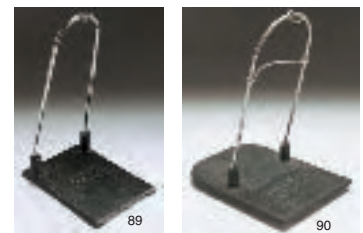


Tip No.	Description
9913	2 Hole Spreader (1/4" hole span)
9916	3 Hole Spreader
9917	3 Hole 1" Spreader for Scotch-Weld Applicator II only
9921	.090" Fluted Tip
9922	.063" Fluted Tip
9940	.125" Fluted Tip
9946	.072" Brass Extension for Scotch-Weld Applicator II only
9725	Mini Extension Tip .072" Opening for all Scotch-Weld Applicators
9726	"T" Tip (shown with valve and adapter) for all Scotch-Weld Applicators
9727	"L" Tip (shown with adapter and valve) for all Scotch-Weld Applicators
9729	High Viscosity Valve (TC, EC, PG-II)
9785	.070" Tapered Aluminum Extension for all Scotch-Weld Applicators
9777	1/4" Slotted Spreader (3755LM adhesive only)
9782	1/2" Slotted Spreader (3755LM adhesive only)
9764	3/4" Slotted Spreader (3755LM adhesive only)

① A general purpose tip (.090) is supplied with each 3M™ Scotch-Weld™ Applicator. To increase productivity, optional tips can provide multiple beads, flat ribbons, guided beads for carton sealing, and extended reach.

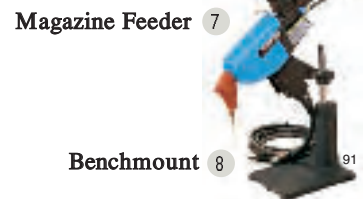


**Increase capacity** and ease of operation with Quadrack™ Converter and Palm Trigger.



⑤ ⑥ **Heavy-Duty Benchstands** provide added convenience.

Accessories (4, 7, 8) can provide high capacity, hands-free operation for 3M™ Scotch-Weld™ Applicator II and 3M™ Scotch-Weld™ Applicator II LT.



⑦ **Magazine Feeder**

⑧ **Benchmount**

## Product Information: 3M™ Scotch-Weld™ Hot Melt Adhesives

	Product (Color)	FDA Listed Components <sup>1)</sup>	UL 94 Listing	Features Application Ideas	Sizes	EC Temp Control Modules	Flash Point (°F/°C)	
Low Melt Technology: Applied 250°-270°F (127°-132°C)	3755LM Clear	Y	N/A	• “Delayed-tack” applied in thin-glue-line ribbon for bonding paper, corrugated, chipboard, P.O.P. displays and exhibits	5/8" x 2"TC	N/A	509/265	
	3762LM* Lt. Amber	Y	N/A	• Excellent “hot tack”, fast setting • Bonds variety of corrugated packaging, beadboard, recouperage, repacking area • Economical, general purpose • Can bond chipboard and wood	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC	1	509/265	
	3776LM Tan	N/A	N/A	• Bonds variety of plastics, woods and light-gauge metals	5/8" x 8"Q 1" x 3"PG	1	460/238	
	3792LM* Clear	Y	V2	• Clear, multi-purpose for wood, coated paper, polyolefins and other heat-sensitive materials • P.O.P. displays	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC	1	550/288	
	3798LM Clear	Y	N/A	• Gummy glue removable adhesive • Strength in seconds, removes easily • A wide variety of substrates • No residual tack	5/8" x 2"TC	N/A	474/246	
Hot Melt Technology: Applied 350°-385°F (177°-196°C)	3731	N	N/A	• High heat resistance • Bonds a variety of plastics including polyethylene and polypropylene	5/8" x 8"Q 1" x 3"PG	5	N/A	
	3738* Tan	Y	V2	• High delivery rate and long bonding range • General purpose for foundry sand cores, wood bonding, corrugated, selected plastics and chipboard	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC 1/2" x 12"AE	4	550/288	
	3747 Tan	Y	N/A	• General purpose • Bonds wide variety of plastics, wood and lightweight metals	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC 1/2" x 12"AE	4	509/265	
	3748* Off-white	Y	V2	• Good thermal shock resistance • Non-corrosive to copper for many electronic applications • Bonds polyolefins	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC	4	536/280	
	3748 VO Light Yellow	N	VO	• Self-extinguishing version of 3748 • Meets UL 1410 requirements	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC	4	536/280	
	3750 Tan	Y	V2	• Low viscosity for high flow rate and increased production • Packaging and wood assembly • Good hot tack for quick grab	1/2" x 1/2"AE	N/A	495/234	
	3762 Tan	Y	V2	• Excellent “hot tack”, fast-setting • Economical, general purpose for corrugated packaging, beadboard, recouperage, repacking area • Can bond chipboard and wood	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC 1/2" x 12"AE	3	500/260	
	3764* Clear	Y	V2	• Bonds variety of plastics including polycarbonate, polyethylene, and polypropylene • Flexible at low temperatures	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC 1/2" x 12"AE	4	514/267	
	3779* Amber	Y	VO	• High heat resistance • High strength • Good fuel and oil resistance	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC	5	550/288	
	3789* Brown	Y	V2	• High performance for plastics • Impact resistant • Bonds vinyl and wood • Good fuel and oil resistance	5/8" x 8"Q 1" x 3"PG	5	635/335	
	3792 Clear	Y	V2	• Clear, multi-purpose for wood, corrugated, fabric, furniture, upholstery, novelties, and other lightweight materials	5/8" x 8"Q 1" x 3"PG 5/8" x 2"TC 1/2" x 12"AE	4	450/232	
	3796 Lt. Tan	N	N/A	• High performance for plastics and light-gauge metals	1" x 3"PG 5/8" x 2"TC	N/A	480/249	
	3797 Off-white	Y	V2	• High ball and ring • Low viscosity • Good for electrical potting	1" x 3"PG 5/8" x 2"TC	N/A	570/299	
Bulk	3794 Hi Tack PSA Lt. Tan	Y	N/A	• Sprayable for plastic bonding, paper, metals, die-cut labels • Transportation, P.O.P.	2 lb. bricks	N/A	515/268	

(1) Made from components listed as indirect food additives under FDA regulations for adhesives (21 CFR 175.105). (2) Brookfield Thermosel Viscometer in Centipoise. (3) ASTM E-28-6-7 (4) On canvas (5) On Douglas Fir (6) 1/8" semicircular bead, Douglas Fir to Douglas Fir.

	Viscosity CPS <sup>(2)</sup>	Delivery Time (sec) for 1" x 3" Cartridge**	Ball & Ring Soft Point <sup>(3)</sup> (°F/°C)	Heat Resistance (°F/°C)	Impact Resistance (in.-lbs.) 72°F (22°C)	Peel Strength PIW <sup>(4)</sup> 72°F (22°C)	Shear Strength PSI <sup>(5)</sup> 72°F (22°C)	Tensile Strength PSI 72°F (22°C)	Elongation %	Bonding Range 1/8" Bead (sec) <sup>(6)</sup>
	13,000 @250°F	N/A	157/70	120/49	14	13	500	380	400	120
	4000 @250°F	45	205/96	130/54	13	6	480	600	300	25
	8250 @250°F	47	184/84	140/60	13	9	600	270	600	40
	10,500 @250°F	57	178/81	140/60	62	13	350	547	125	40
	9500 @250°F	N/A	191/88	120/49	N/A	N/A	N/A	62	250	30
	12,000 @375°F	N/A	315/157	265/130	N/A	22	490	N/A	N/A	30
	2875 @375°F	35	186/86	130/54	36	13	375	360	1000	50
	4100 @375°F	45	220/104	145/63	25	20	430	750	1300	45
	5000 @375°F	65	292/144	175/79	24	18	250	375	1100	45
	5500 @375°F	65	305/152	175/79	50	15	275	200	1850	30
	1900 @375°F	30-40	200/93	125/52	N/A	6	500	N/A	N/A	N/A
	1870 @375°F	30	201/94	130/54	20	7	545	450	400	35
	6000 @375°F	55	190/88	140/60	58	14	390	650	625	40
	7000 @375°F	75	325/163	300/149	22	18	700	2100	300	25
	5200 @375°F	70	270/132	220/104	40	16	570	520	600	50
	5000 @375°F	45	179/81	140/60	42	13	250	400	750	50
	23,000 @375°F	120	240/116	200/93	29	29	550	363	930	40
	2650 @375°F	55	304/151	170/77	19	10	350	283	98	30
	15,000 @325°F	N/A	224/107	120/49	N/A	16	N/A	N/A	N/A	> 60

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\* Also available in bulk.

\*\* Time to deliver the third consecutive cartridge through PG II or PG II LT @ 80 PSI.

N/A = Not available



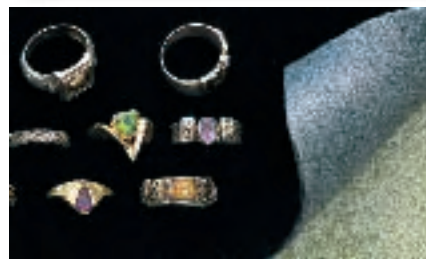
# 3M™ Scotch-Weld™ Hot Melt Spray Adhesives

Solventless fast track for immediate bonding of foam and other lightweight materials

3M™ Scotch-Weld™ Hot Melt Spray Adhesive is a fast, neat alternative to solvent-based systems for bonding most foams, fabrics, plastics, particle board, and light-gauge metals. Applications range from furniture cushions to cushioning inserts, modular office panels to gym floor pads, and more. You simply spray a neat track of 100% solids adhesive right where you want it. Apply to one or both surfaces and bond substrates immediately.

Other features include:

- Up to 10-minute open time for handling convenience and bonding larger areas.
- One-part to eliminate the fuss of mixed systems.
- Designed for hand-held or bulk applicators.



In display cases for jewelry and other retail items, foam is bonded to foam and fabric. Low temperature spray will not damage heat-sensitive substrates.



In carrying case assembly, 3M™ Scotch-Weld™ Hot Melt Spray Adhesive bonds foam to foam, plywood, metal or plastic.

## Product Information: 3M™ Scotch-Weld™ Hot Melt Spray Adhesives

Adhesives Characteristics and Suggested Coverage			
	6111/6111 Green	6111 HT/6111 HT Blue	6116
Description	Standard product	Higher heat resistance	Low viscosity
Color	Tan/Green	Tan/Blue	White
Open Time <sup>(1)</sup> One surface (Foam/PVC)	1 minute	3 minutes	2 minutes
Open Time <sup>(1)</sup> Two surface (Foam/Foam)	6 minutes	8 minutes	6 minutes
Heat Resistance <sup>(2)</sup>	145°F (63°C)	175°F (79°C)	160°F (71°C)
Peel Adhesion (PIW) <sup>(3)</sup>			
Fir	34.4	25.6	21.4
ABS	12.1	16.5	20.3
Polypropylene	46.3	14.4	16.4
PVC	9.9	16.3	N/A
Cold Rolled Steel	16.5	29.9	20.4
High Density Polyethylene	8.2	2.3	N/A
Typical Coverage	Smooth Surface	Textured Surface	
2-Surface Application	1-2 grams per square foot	2-3 grams per square foot	
1-Surface Application	3-5 grams per square foot	5-7 grams per square foot	

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.

(1) Bonds were made by spraying adhesive onto 3/4 in. thick, 2 lb. density polyester urethane foam. Open time will vary depending on substrate.

(2) Tested per 3M IATD test method C-3093 using 2 lb. dead load.

(3) According to 3M IATD test method C-3012. 180° peel strength was determined at a cross head speed of 2 inches/minute at 73°F (23°C).