

**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 go to work to find the best products to help maximize your product performance, increase your efficiency, streamline your assembly productivity and meet your sustainability goals.

## 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 optimizes 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, pressurized, portable
- Minimal equipment investment
- Low maintenance
- Optimized spray patterns cut waste and maximize 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 maximize value
- Ideal for large surface areas and large industrial manufacturers

## Sustainability: Find the products that achieve your goals.

Maximizing sustainability doesn't have to mean giving up performance. For more than 40 years 3M engineers have been developing water-based, low VOC and GREENGUARD™ certified adhesives for some of the most demanding applications in the world. So if you're ready to "go greener," we're ready to take you there.

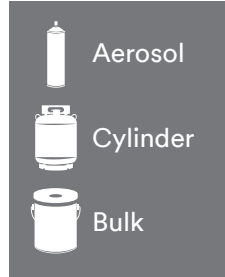


\*Meets applicable 2017 California Air Resource Board VOC limits for mist and web spray adhesives.



# 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.



# Adhesive Selector: Find the Right Adhesive by Selecting the Substrates You're Bonding

Choose Adhesive Delivery System


Choose Substrate



Substrate	Aerosol	Cylinder	Solvent-Based Bulk	Water-Based Bulk
Paper, Cardboard	27, 77	77	77	49
Fabric, Felt, Fiberglass, Cork	20, 27, 77	70, 77, 78ET	77	49
Flexible Foam: Urethane, Latex	24, 74	74	74	100NF
Rigid Foam: Polystyrene, Beadboard	78	70, 78ET	78	30NF
High Pressure Laminates, Melamine	20, 90, 94ET	94CA, 94ET	94CA, 94ET	30NF
Wood, MDF, Particle Board	20, 90, 94ET	94CA, 94ET	94CA, 94ET	30NF
Metal: Steel, Aluminum	20, 90	90, 94CA, 94ET	90, 94CA, 94ET	30NF
Plastics: ABS, PVC, Phenolic, Acrylic	20, 90	90, 94CA, 94ET	90, 94CA, 94ET, 4491	30NF
FRP: Fiberglass Reinforced Plastic	20, 90	70, 90, 94CA, 94ET	90, 94CA, 94ET	30NF
Painted Surfaces	20, 90	90, 94CA, 94ET	90, 94CA, 94ET	30NF
Rubbers: Nitrile, Neoprene, SBR	20, 80, 90	70, 90, 94CA, 94ET	90, 94CA, 94ET, 4491	N/A
Plasticized Vinyl	80	NA	4491	4224NF

Substrates are ranked from lightweight, heavy duty to specialty substrates.

# Adhesive Selector: Find the Right Adhesive by Selecting the Attributes You Need

Product	Non-Flammable	Postforming	Class A Rating: ASTM E-84	Plasticizer Resistant	 GREENGUARD GREENGUARD GREENGUARD	Low VOC	Helps Contribute to LEED® Credits	California Compliant	Spray Pattern	Color
20							✓		Variable Lace	Clear
20CA						✓	✓	Aerosol Only	Variable Lace	Clear
24							✓		Variable Lace	Orange
27							✓		Mist	Clear
30NF	✓	✓			✓	✓	✓	✓	Pebble	Green, Neutral
49	✓		✓		✓	✓		✓	Pebble	Clear
60CA			✓			✓		✓	Variable Lace or Pebble	Clear
70			✓						Heavy Body Lace	Clear
71								Aerosol Only	Mist	Clear
72							✓		Variable Lace	Blue
74							Aerosol Only		Variable Lace	Clear, Orange
74CA					✓	✓	Aerosol Only	Aerosol Only	Variable Lace	Clear, Orange
76							Aerosol Only		Variable Lace	Clear
77			✓				Aerosol Only		Mist	Clear
77 Classic							Aerosol Only		Mist	Clear
77CA					✓	✓	Aerosol Only	Aerosol Only	Mist	Clear
78							Aerosol Only	Aerosol Only	Variable Lace	Clear
78ET			✓						Variable Lace	Clear, Green
78HT			✓						Variable Lace	Clear, Green
80				✓					Variable Lace	Yellow
90							Aerosol Only		Variable Lace	Clear
90CA					✓	✓	Aerosol Only	Aerosol Only	Variable Lace	Clear
92		✓							Variable Lace	Clear, Red
94CA		✓	✓		Cylinder Only	✓		✓	Pebble	Clear, Red
94ET		✓			✓	✓	✓	✓	Pebble	Clear, Red
100NF	✓				✓	✓	✓	✓	Pebble	Lavender, Neutral
1000NF	✓		✓		✓	✓	✓	✓	Pebble	Purple, Neutral
1357			✓						Lace	Gray-Green, Light Yellow
2000NF	✓				✓	✓	✓	✓	Pebble	Blue, Light Orange, Neutral
4224NF	✓		✓		✓			✓	Pebble	Clear, Blue
4491				✓					Lace	Light Tan

\*Solid weight percent can vary by format.

## Heavy Duty

20

### 3M™ Heavy Duty 20 Spray Adhesive

- Economical, fast-grabbing, industrial-grade adhesive
- Variable-width spray pattern
- Forms powerful, permanent bonds to concrete, wood, MDF, laminates and polyethylene

Clear
Aerosol
00 51111 07861 7

20CA

### 3M™ Heavy Duty 20CA Spray Adhesive

- Economical, fast-grabbing adhesive
- Meets CARB/OTC VOC requirements
- Bonds to concrete, wood, MDF and laminates

Clear
Aerosol
00 76308 14271 1

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

Green		Neutral	
Bulk		Bulk	
1 Gallon Pail	00 21200 21186 7	1 Gallon Pail	00 21200 21181 2
5 Gallon Pail	00 21200 21187 4	5 Gallon Pail	00 21200 21182 9
Open Head Steel Drum	00 21200 21188 1	Open Head Steel Drum	00 21200 21183 6
270 Gallon Poly Tote	00 21200 31344 8		

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

Clear		Inverted	
Aerosol		Aerosol	
12.23 oz.	00 76308 86235 0	00 51111 07278 3	
17.6 oz.	00 21200 30023 3		
Cylinder			
Large	00 21200 41554 8		
Intermediate	00 51115 25774 2		
Jumbo	00 51115 25775 9		
Bulk			
5 Gallon Pail	00 21200 43797 7		
Open Head Steel Drum	00 21200 43814 1		

90CA



### 3M™ Hi-Strength 90CA Spray Adhesive Low VOC <25%

- High strength and fast-tack adhesive performance
- Bonds to concrete, wood, MDF, laminates and polyethylene
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear
Aerosol
00 51111 97957 0

92

### 3M™ Hi-Strength Laminating 92 Adhesive

- High performance laminating adhesive for large surfaces
- High solids and high coverage
- Lace spray pattern and fast-tack adhesive performance

Clear		Red	
Cylinder		Cylinder	
Large	00 48011 61697 1	Large	00 48011 61700 8
Intermediate	00 48011 61698 8	Intermediate	00 48011 61701 5
Jumbo	00 48011 61699 5		
Bulk			
5 Gallon Pail	00 51115 31591 6		
Closed Head Steel Drum	00 51115 31592 3		

94CA



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

- Unique, non-telegraphing spray pattern delivers postformable strength
- High solids maximize coverage
- Low VOC, SCAQMD Rule 1168 compliance

Clear		Red	
Cylinder		Cylinder	
Large	00 48011 61703 9	Large	00 4801 61663 6
Intermediate	00 48011 61704 6	Intermediate	00 48011 61664 3
Bulk			
5 Gallon Pail	00 51115 25016 3	5 Gallon Pail	00 48011 61666 7
Closed Head Steel Drum	00 51115 25017 0	Closed Head Steel Drum	00 48011 61667 4
Open Head Steel Drum	00 51111 18858 3	Open Head Steel Drum	00 51111 07280 6

94ET



### 3M™ Hi-Strength 94ET Spray Adhesive Low VOC <20%

- Unique, non-telegraphing spray pattern delivers postformable strength
- Long open time
- Meets CARB/OTC VOC requirements, SCAQMD Rule 1168 compliance, helps contribute to LEED® Credits, and low VOC

Clear		Red	
Aerosol		Aerosol	
00 51111 97977 8		00 51111 97978 5	
Cylinder			
Large	00 51111 97979 2	Large	00 51111 97986 0
Intermediate	00 51111 97980 8	Intermediate	00 51111 97987 7
Bulk			
5 Gallon Pail	00 51111 97983 9	5 Gallon Pail	00 51111 97990 7
Closed Head Steel Drum	00 51111 97984 6	Closed Head Steel Drum	00 51111 97991 4

1357

### 3M™ Neoprene High Performance Contact Adhesive 1357

- 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

Grey-Green		Light Yellow	
Bulk		Bulk	
1 Gallon Pail	00 21200 19894 6	1 Gallon Pail	00 21200 22586 4
5 Gallon Pail	00 21200 19897 7	5 Gallon Pail	00 21200 64963 9
Agitator Steel Drum	00 21200 19898 4	Agitator Steel Drum	00 21200 22589 5
Open Head Steel Drum	00 21200 19899 1		

2000NF



### 3M™ Fastbond™ Contact Adhesive 2000NF

- A water-dispersed, high solids activated adhesive
- Immediate bonding and handling strength without forced drying

Blue		Light Orange	
Bulk		Bulk	
5 Gallon Pail	00 21200 87965 4	5 Gallon Pail	00 21200 87953 1
Open Head Steel Drum	00 21200 87966 1	Open Head Steel Drum	00 21200 87955 5
270 Gallon Poly Tote	00 21200 87969 2	270 Gallon Poly Tote	00 21200 87959 3

Neutral

Bulk	
5 Gallon Pail	00 21200 89337 7
5 Gallon Box	00 21200 31337 0
Open Head Steel Drum	00 21200 89338 4
270 Gallon Poly Tote	00 21200 89341 4

## Multipurpose

27

### 3M™ Multi-Purpose 27 Spray Adhesive

- Versatile, economical, industrial-grade adhesive
- Bonds paper, fabrics, cardboard, soft foams and more
- Mist spray pattern and fast-tack adhesive performance

Clear
Aerosol
00 51111 07832 7

49



### 3M™ Fastbond™ Insulation Adhesive 49

- Fast-tacking, high performance, water-based, pressure-sensitive adhesive
- Ideal for lightweight materials such as fiberglass, felt, shoddy and paper
- Low VOC content

Clear	
Bulk	
5 Gallon Pail	00 21200 45163 8
5 Gallon Box	00 21200 50044 2
Open Head Steel Drum	00 68060 00090 3
Poly Drum	00 68060 00073 6
Poly Tote	00 21200 45193 5
255 Gallon EZ Drain Tote	00 21200 56521 2
100 Gallon EZ Tote	00 21200 56520 5

60CA

**3M™ General Purpose Adhesive 60CA**

- Low VOC, general-purpose industrial-grade adhesive with lace spray pattern
- High solids content
- Bonds fabric, foam, plastic, heavy paper to wood, plastics and metals

Clear	
Cylinder	
Large	00 48011 61687 2
Intermediate	00 48011 61688 9
Bulk	
5 Gallon Pail	00 51115 31589 1
Closed Head Steel Drum	00 51115 31590 9

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

Clear	
Cylinder	
Mini	00 51115 32201 3
Large	00 48011 61690 2
Intermediate	00 48011 61691 9
Jumbo	00 48011 61692 6
Bulk	
5 Gallon Pail	00 51115 63935 7
Closed Head Steel Drum	00 51115 63934 0

77MP

**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

Clear	
Aerosol	
13.44 oz.	00 76308 86234 3
16.0 oz.	00 21200 21210 9

77 Classic

**3M™ Super 77™ Classic Spray Adhesive**

- Original formula
- Fast aggressive tack and low soak-in of adhesive
- Bonds lightweight materials
- Bonds in 10–15 seconds

Clear	
Aerosol	
16.75 oz.	00 21200 96315 5
Cylinder	
Large	00 51115 25776 6
Bulk	
5 Gallon Pail	00 21200 43793 9
Open Head Steel Drum	00 21200 43813 4

77CA

**3M™ Super 77™ CA Multipurpose Spray Adhesive Low VOC <25%**

- Bonds many lightweight materials such as foils, carpeting, paper, cardboard, felt and more
- Low soak-in and long open time
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear	
Aerosol	
00 51111 97956 3	

Foam & Fabric

24

**3M™ Foam & Fabric 24 Spray Adhesive**

- Fast-tack, industrial-grade adhesive
- Aggressive tack with foam-tearing strength
- Bonds foam to substrates such as fabric, wood and more

Orange	
Aerosol	
00 51111 07862 4	

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

Clear		Orange	
Aerosol		Aerosol	
00 51111 50045 9		00 21200 82242 1	
Cylinder		Cylinder	
Large	00 21200 49919 7	Large	00 21200 49158 0
Intermediate	00 51115 25741 4	Intermediate	00 51111 18853 8
Jumbo	00 51115 25742 1	Jumbo	00 51111 18854 5

74CA

**3M™ Foam Fast 74CA Spray Adhesive Low VOC <25%**

- Ideal for bonding flexible urethane or latex foam to many substrates such as wood, metal, fabrics and more
- Soft, non-dimpling glue lines
- Meets CARB/OTC VOC requirements and helps contribute to LEED® credits

Clear		Orange	
Aerosol		Aerosol	
00 51111 97967 9		00 51111 97958 7	

100NF

**3M™ Fastbond™ Foam Adhesive 100NF**

- A water-dispersed, neoprene-based contact adhesive
- One part, rapid setting adhesive
- Ideal for bonding foam to many substrates such as wood, metal, fabrics and more

Lavender		Neutral	
Bulk		Bulk	
5 Gallon Pail	00 21200 41542 5	5 Gallon Pail	00 21200 39203 0
Open Head Steel Drum	00 48011 58433 1	Open Head Steel Drum	00 48011 58713 4
Poly Drum	00 21200 41543 2	Poly Drum	00 21200 39204 7
270 Gallon Poly Tote	00 21200 41544 9	270 Gallon Poly Tote	00 21200 39205 4
100 Gallon EZ Tote	00 21200 56512 0		

Specialty

71

**3M™ Hi-Tack Composite Spray Adhesive 71**

- Specifically designed to optimize the ultimate strength of resin-infused composite parts
- Consistent fine mist spray with high adhesive solids content for exceptional coverage
- Meets CARB and OTC VOC requirements

Clear	
Aerosol	
00 76308 14327 5	

72

**3M™ Pressure Sensitive Spray Adhesive 72**

- Pressure-sensitive adhesive gains strength as pressure is applied
- Permanent tack ideal for many one-surface bond applications
- Long open time allows bonds to be made hours or days after application
- Variable-width lace spray pattern allows for precise dispensing

Blue	
Aerosol	
00 21200 30025 7	

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

Clear	
Aerosol	
00 21200 30026 4	

78

**3M™ Polystyrene Insulation 78 Adhesive**

- High solids adhesive formulated for expanded polystyrene and foam insulations
- Bonds without cavitating foams
- Fast grabbing, fast drying formula

Clear		Inverted	
Aerosol		Aerosol	
00 21200 41593 7		00 51111 07279 0	
Bulk			
5 Gallon Pail	00 48011 53438 1		

78ET

**3M™ Polystyrene Insulation 78ET Adhesive**

- Bonds polystyrene with no surface degradation
- Long tack time extends working time
- Uniform spray pattern ensures fast and easy application

Clear		Green	
Cylinder		Cylinder	
Large	00 48011 61693 3	Large	00 48011 61695 7
Intermediate	00 51115 25704 9	Intermediate	00 51115 25705 6
Jumbo	00 48011 61694 0	Jumbo	00 48011 61696 4

# Specifications and Ordering Information

78HT

## 3M™ Hi-Temperature Polystyrene Insulation 78HT Adhesive

- Permanently bonds to polystyrene foam and other materials
- Will not degrade the foam
- Sprays with a lace pattern optimized for foam

Blue	
Cylinder	
Mini	00 51115 31593 0
Large	00 51115 31595 4
Intermediate	00 51115 31594 7
Jumbo	00 51115 31596 1

80

## 3M™ Rubber and Vinyl 80 Spray Adhesive

- High strength adhesive provides strong bonds for rubber and vinyl
- High temperature and plasticizer resistant
- Fast-setting contact adhesive produces rapid results

Yellow	
Aerosol	
00 21200 82618 4	

1000NF

## 3M™ Fast Tack Water Based Adhesive 1000NF

- Quick bond in a one-part adhesive
- 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

Neutral		Purple	
Bulk		Bulk	
1 Gallon Pail	00 51115 64581 5	1 Gallon Pail	00 51115 64679 9
5 Gallon Pail	00 51115 64674 4	5 Gallon Pail	00 51115 64680 5
5 Gallon Box	00 51115 64675 1	5 Gallon Box	00 51115 64681 2
Open Head Steel Drum	00 51115 64677 5	Open Head Steel Drum	00 51115 64683 6
Closed Head Poly Drum	00 51115 64676 8	Closed Head Poly Drum	00 51115 64682 9
255 Gallon Poly Tote	00 51115 64676 8	255 Gallon Poly Tote	00 51115 64684 3

4224NF

## 3M™ Fastbond™ Pressure Sensitive Adhesive 4224NF

- Water-based carpet adhesive
- Permanent pressure-sensitive adhesive with an aggressive tack
- Low VOC content

Clear		Blue	
Bulk		Bulk	
5 Gallon Pail	00 21200 85780 5	5 Gallon Pail	00 21200 21159 1
Open Head Steel Drum	00 21200 85781 2	Open Head Steel Drum	00 21200 65080 2

4491

## 3M™ 4491 Adhesive

- Fast-drying adhesive with good resistance to plasticizer migration
- Bonds many vinyl extrusions and sheeting
- Excellent environmental resistance

Light Tan	
Bulk	
5 Gallon Pail	00 21200 50046 6
345 Gallon Tote	00 51115 63475 8

## 3M™ Fastbond™ Spray Activator 1

- Water-dispersed formula is low VOC
- High coverage with mist spray application
- Spray activator compatible with 100NF and 2000NF

Bulk	
5 Gallon Pail	00 21200 89324 7
30 Gallon Tight Head Drum	00 21200 39289 4

## 3M™ Shipping-Mate™ Case Sealing Adhesive

- Permanently seals closure flaps to protect corrugated shipping containers
- Fast-tack adhesive with low soak-in
- Offers heat- and moisture-resistance for long-lasting durability

Aerosol	
00 21200 30024 0	

## Industrial Cleaner

### 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

Aerosol	
00 21200 76394 6	

### 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

Aerosol	
00 21200 21305 2	

## 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

Aerosol	
00 21200 85822 2	

## 3M™ Silicone Spray Low VOC 60%

Aerosol	
00 51111 07732 0	



## 3M™ Adhesive Remover

- Removes grease, oil, ink and most adhesives without the need to soak
- Provides mold-release agents
- Removes adhesive without damaging the surface underneath

Aerosol	
00 21200 49048 4	

## 3M™ Adhesive Remover Low VOC < 20%

Aerosol	
00 51111 97974 7	



## Cylinder Equipment

Applicator	Hoses	
Reduced Output “H”	00 51115 25039 2	6 ft. 00 51115 25036 1
Regular Output	00 48011 61706 0	12 ft. 00 48011 61988 0
High Output	00 51111 07329 2	25 ft. 00 48011 61989 7
Extended Applicator	00 51115 25779 7	50 ft. 00 51115 25782 7
Fitting	Tips	
T-Fitting	00 48011 61987 3	QSS 00 48011 61993 4
Swivel	00 48011 61992 7	4001 00 48011 61990 3
		6501 00 48011 61991 0
		9501 00 48011 61707 7
		250050 00 51115 25780 3
		650050 00 51115 25781 0



\*Meets applicable 2017 California Air Resource Board VOC limits for mist and web spray adhesives.



## Industrial Adhesives and Tapes Division

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

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