



3M Industrial Tapes and Adhesives product catalogue





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Double Coated Tapes

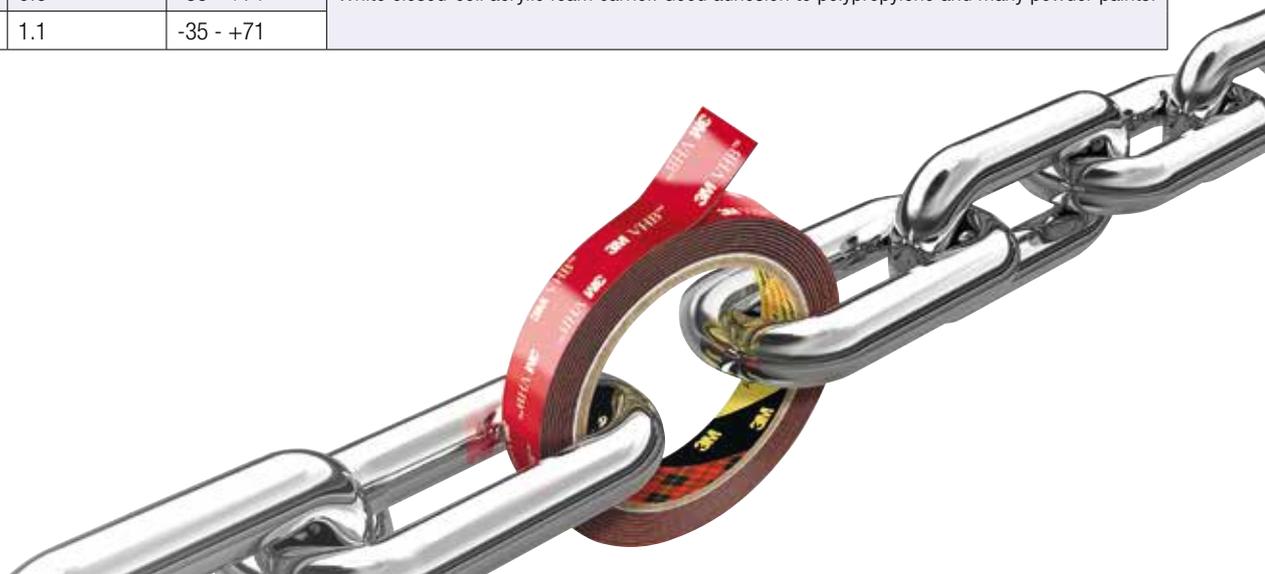
3M™ VHB™ Tapes and Acrylic Foam Tapes



VHB-tapes are acrylic foam tapes with a 100% closed cell structure that completely adjust to bonded surfaces. The VHB acrylic foam tape is suitable for practically any surface and can be used both in- and outdoors. Unlike regular foam tapes, the VHB tape permanently adapts to surface form and is not trying to restore its original shape. Acrylic foam tapes are special bonding tapes that have a proven strength to replace screws, rivets, welding, and other mechanical connecting methods. The need for investment in devices is decreased. The products have a better quality and appearance, they are stronger and resist corrosion and environmental impact. All VHB tapes are moisture resistant and adhere to materials with high/low surface energy.

Many VHB tapes are available with both paper and plastic liner. Additional information on tapes can be found in the following table.

Product	Colour	Thickness (mm)	Temperature resistance	Additional information
Conformable Modified Acrylic Foam Tapes				
5925	Black	0.6	-35 - +93	Bond muntin bars to windows. Bond and seal polycarbonate lens over LCD. Bond-prepainted metals in truck assembly. Bond and seal plastic windows to pre-painted control panels/switch gear. Mount vinyl wiring ducts and conduit channels.
5930	Black	0.8	-35 - +93	
5952	Black	1.1	-35 - +93	
5962	Black	1.5	-35 - +93	
Conformable Acrylic Foam Tapes				
4936	Gray	0.6	-35 - +93	Conformable acrylic foam is suitable for bonding various materials in difficult conditions. The tapes fill gaps, suppress vibration and resist chemicals, including softeners. Usage: metals, plastics with high/low surface energy, softened plastics, relief and uneven surfaces.
4941	Gray	1.1	-35 - +93	
4956	Gray	1.5	-35 - +93	
4991	Gray	2.2	-35 - +93	Tapes are well conformable. Bonding surfaces at low temperatures up to 0°C.
4943	Gray	1.1	-35 - +93	
4957	Gray	1.5	-35 - +93	
Acrylic Foam Tapes				
4646	Gray	0.6	-35 - +149	Tapes for bonding metal with metal. Pre-powder coat paint applications: hat channels and stiffeners.
4611	Gray	1.1	-35 - +149	
4655	Gray	2	-35 - +149	
Transparent Tapes				
9469	Clear	0.13	-35 - +150	The tapes are suitable for various transparent attachments, amongst others for fastening signs, light advertising and lightings. Clear adhesive transfer tape. High shear strength adhesive. UL 746C.
9473	Clear	0.25	-35 - +150	
4905	Clear	0.5	-35 - +93	
4910	Clear	1.0	-35 - +93	
4915	Clear	1.5	-35 - +93	
4918	Clear	2.0	-35 - +93	
Low Surface Energy Material Tapes				
4932	White	0.6	-35 - +71	White closed-cell acrylic foam carrier. Good adhesion to polypropylene and many powder paints.
4952	White	1.1	-35 - +71	



Accessories used with VHB tape applications

In order to achieve optimum adherence, the surfaces to be bonded have to be clean, dry and smooth. 3M recommends using special accessories for installing VHB tapes. The surfaces should be cleaned with VHB cleaner in advance. The 3M Cleaner spray easily removes impurities, grease and oils from surfaces. If needed, the surfaces can be roughened by using a Scotch-Brite abrasive sheet and re-cleaned with the VHB cleaner. With VHB installation roller or plastic spatula, the maximum adherence of the tape is ensured and air from the connection is removed.



Scotch-Brite™ abrasive sheets



3M™ Scotch-Weld™
Cleaner spray



VHB surface cleaning cloths



VHB surface cleaner



VHB installation roller



Spatula

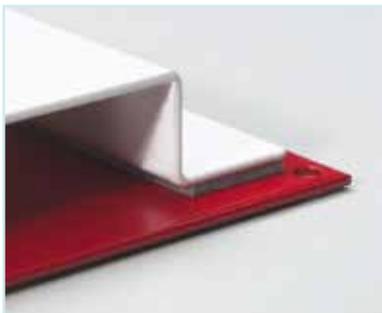


3M™ Adhesion Promoter 111



Primer 94

* For special equipment requirements please contact your local 3M sales representative.



3M™ VHB™ 5952 acrylic foam tape

3M™ VHB™ Tape 5952 is a very conformable, double-sided, pressure-sensitive, closed-cell acrylic foam tape. Bonds most painted metal and plastic without surface priming or abrading. Specially formulated synthetic adhesive bonds most paints and powder coats, as well as window materials such as glass, acrylic, and polycarbonate. Best selection for connecting materials with a low surface energy.



3M™ VHB™ 4941 acrylic foam tape

The Most Valuable Player. All acrylic adhesive and conformable acrylic foam have made 3M™ VHB™ 4941 a proven performer in harsh environments, as well as a top performer for:

- Glass
- Many medium surface energy plastics such as rigid PVC, many plasticized vinyls, acrylic and polycarbonate
- Outdoor and harsh environmental applications
- Painted/sealed porous surfaces such as wood and concrete



3M™ VHB™ 4611 acrylic foam tape

4611 is a dark grey acrylic foam tape with a high temperature resistance. This tape is indicated for connecting metal with metal. Thanks to temperature resistance, the tape can be used for bonding components before powder coating.



3M™ VHB™ 9473 adhesive transfer tape

10.0 mil 100MP high performance acrylic with 4.2 mil 58 lb polycoated kraft paper liner - printed.

- 10.0 mil high performance industrial joining and metal fabrication
- Excellent long-term holding power with higher adhesion strength than typical PSAs
- Transparent and ideal for use in many interior and exterior industrial applications to replace rivets, spot welds, liquid adhesives and other permanent fasteners



3M™ VHB™ Tape 4910

3M™ VHB™ Tape 4910 is a clear double-sided, pressure-sensitive, acrylic tape with PE film liner. 40 mil thick. This family of clear tapes is excellent for applications where clear or colorless is desired. The general purpose adhesive on both sides is suitable for high surface energy substrates.

- High strength
- Durable
- Clean appearance





Double Coated Thin Tapes

3M™ Double Coated Tapes provides a high level of adhesive peel and shear performance. The product range contains tapes for both permanent and temporary applications.

Double Coated Tapes with and without carrier

The 9080 series consists of four various tape types based on the same adhesive. All tapes can be used for bonding materials with both high and low surface energy and are UV and softener resistant. Bond painted and unpainted surfaces, stainless steel, glass, polycarbonate, polypropylene, ABS, wood, fabric, leather, foam, and more.

The 9084 is a mounting tape with a tissue carrier that can be easily torn with hand. Suitable for light and temporary fastenings.

9086 is a general mounting tape that can be torn by hand.

9087 is a white mounting tape with a soft carrier that is suitable for both smooth and rough substrates.

9088 is a transparent mounting tape that can be used on colourless, transparent and shiny surfaces.

9088FL tape has a red foil liner that is more suitable if the liner has to have tensile strength, adaptability and moisture proofness.

467MP is a high performance acrylic adhesive on 4.2 mil polycoated kraft liner. Excellent shear strength, temperature resistance and chemical resistance. Ideal for graphic and nameplate attachment. Easy to die-cut and process. Excellent moisture and solvent resistance. Excellent high temperature resistance and shear strength. UV resistant.

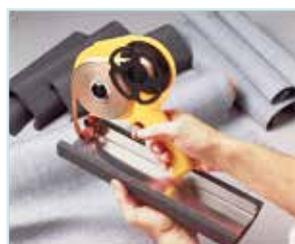


Product	Colour	Tape structure (carrier/adhesive)	Thickness (mm)	Temperature resistance (°C)	Additional information
Double Coated tapes with carrier					
9088FL	Transparent	Polyester / acrylic adhesive	0.21	+93	Good temperature resistance, with red film liner.
9088	Transparent	Polyester / acrylic adhesive	0.21	+93	Good temperature resistance.
9087	White	PVC / acrylic adhesive	0.27	+70	Adheres to uneven surfaces.
9086	Transparent/grey	Synthetic fibre / acrylic adhesive	0.19	+85	Easy to use, breaks when torn by hand.
9084	Light brown	Paper / acrylic adhesive	0.10	+65	Suitable for temporary fastenings.
Double Coated tapes without carrier					
467MP	Transparent	- / 200MP	0.05	+149°C	Great adherence on metals and plastics with a high surface energy. Very resistant, good UV radiation and chemical resistance. Sheet/rolls measurements 615 x 610 mm.
468MP	Transparent	- / 200MP	0.13	+149°C	
7952MPL	Transparent	- / 200MP	0.05	+121°C	
7955MPL	Transparent	- / 200MP	0.13	+121°C	
9471	Transparent	- / 300LSE	0.05	+66°C	The product is available in rolls.
8132LE	Transparent	- / 300LSE	0.05	+93°C	Very good adherence on plastics with low surface energy, and oily metals. The product is available in sheets.
8153LE	Transparent	- / 300LSE	0.09	+93°C	
9626	Transparent	- / 360	0.05	+93°C	Great initial adherence, achieves maximum strength in a couple of minutes. The product is available in rolls.
9627	Transparent	- / 360	0.13	+93°C	



Double-sided tapes without carrier

Double-sided tapes without a carrier only consist of adhesive and the protective paper layer. Thanks to the protective paper, the adhesive can be easily and precisely installed.



3M™ 900 series dispenser Scotch® ATG-700

The gun-shaped ATG-700 is an easy and fast tape dispenser. The device covers the surface to be mounted with a thin adhesive layer and collects the protective paper automatically. The dispenser ATG-700 can be used with the following tape types:



924 is the reverse-wound version of the 465 double-sided tape that can be used with the ATG- dispenser. Like 465, the 924 can be used for bonding paper, foil and aluminium foil. The tape is UV resistant.



926 adheres strongly to many plastics, amongst others to plastics with a low surface energy. 926 can also be used for fastening fabrics or strips to roll curtains as well as for fastening insulation materials. It also resists UV radiance.

969 is a 300 acrylic, reverse wound, pressure sensitive adhesive on a densified kraft paper liner. High tack adhesive transfer tape.

Product	Colour	Tape structure (carrier/adhesive)	Total thickness (mm)	Maximum temperature resistance (°C)	Additional information
Double Coated tapes without carrier					
465	clear	- / acrylic (400)	0.05	+82	A great tape for fastening paper, a general-purpose tape in office, for decoration and in industry. The tape has an ATG version, 924.
924	clear	- / acrylic (400)	0.05	+82	A great tape for fastening paper, a general-purpose tape in office, for decoration and in industry. The tape has an ATG version, 924.
9485PC	clear	- / acrylic (350)	0.13	+149	Strong adherence, good temperature and load resistance, great adherence on materials with low surface energy and uneven surfaces. The tape has an ATG version, 936.
926	clear	- / acrylic (350)	0.13	+149	Strong adherence, good temperature and load resistance, great adherence on materials with low surface energy and uneven surfaces. The tape has an ATG version, 936.
928	white	tissue / acrylic (400/1000)	0.05	+80	2.0 mm, 400/1000 high tack/low tack acrylic, reverse wound, pressure sensitive adhesive double coated tape with a white tissue carrier on a polycoated kraft paper liner. For use with Scotch ATG Adhesive Applicators.
950	clear	- / acrylic (300)	0.13	+80	Good adherence on materials with low surface energy, well suitable for fastening packings. The tape has an ATG version, 969.
969	clear	- / acrylic (300)	0.13	+80	Good adherence on materials with low surface energy, well suitable for fastening packings. The tape has an ATG version, 969.

Fasteners



Reclosable fastener system allow fast and simple connection of surfaces without screws, bolts, nails and other conventional fasteners. With 3M™ Dual Lock™ fasteners and 3M™ Hook and Loop tapes, repairing, care and replacement of surfaces is easy and fast, offering more options for easy bonding of surfaces.

3M™ Scotchmate™ Hook and Loop Reclosable Fasteners

Mushroom-shaped stems on one side of the fastener interlock with identically shaped stems on the other side for 5X greater closure strength than hook and loop; peel apart for opening

- Pressure sensitive adhesive-backed versions* bond on contact to a variety of flexible and rigid materials; choice of specialized adhesive properties (see charts on pages 5-8)
- Choice of stems per square inch: 170, 250, 400 (higher the combined number, greater the closure strength—see chart at right)
- Larger the fastener area, greater the strength for holding weight and resisting shear and peel
- Low profile option for a snug fit with about half the thickness of the standard products

3M™ Dual Lock™ Reclosable Fasteners

Stiff hooks on one side of the fastener mesh with pliable loops on the other side for secure closure; peel one side away for opening

- Pressure sensitive adhesive-backed versions* bond on contact to a variety of flexible and rigid materials; variety of adhesive properties
- The larger the fastener area, the greater the strength for holding weight and resisting shear and peel
- Low profile option for applications where thickness is more critical than number of closures; 75% thinner than standard product with fewer openings and closings

Product	Colour	Adhesive	Type/cm ²	Temperature resistance (°C)	Additional information
3M™ Scotchmate™ Hook and Loop Reclosable Fastener					
SJ-3526	White, black, beige	Rubber adhesive	With hooks	-29- +49	Hook and loop fastener backed with a high performance rubber based adhesive designed for indoor applications requiring medium temperature resistance. Aerospace, Electronics, Construction, Specialty Vehicle, Military, Medical, Furniture, General Industrial Securing Fabric to Furniture Cushions, Air-plane Seating, Carpet Panel Attachments, Uniforms, Gloves and Clothing.
SJ-3527	White, black, beige	Rubber adhesive	With loops	-29- +49	
SJ-3572	White, black, beige	Rubber adhesive	With hooks	-29- +70	Good moisture and temperature resistance. Suitable for outdoor use.
SJ-3571	White, black, beige	Rubber adhesive	With loops	-29- +70	
3M™ Dual Lock™ Reclosable Fastener					
SJ-3540	Black	Rubber adhesive	38	-29- +49	Dual Lock fastening system with rubber adhesive. Suitable for indoor use.
SJ-3541	Black	Rubber adhesive	62	-29- +49	
SJ-3542	Black	Rubber adhesive	26	-29- +49	
SJ-3550	Black	Acrylic adhesive	38	-29- +70	Dual Lock fastening system on VHB tape base, UV and softener resistant. Can be used outdoors.
SJ-3551	Black	Acrylic adhesive	62	-29- +70	
SJ-3552	Black	Acrylic adhesive	26	-29- +70	
SJ-3560	Clear	Acrylic adhesive	38	-29- +70	SJ-3560 has a transparent VHB-tape base that is especially suitable for transparent materials.
SJ-3870	Black	Acrylic adhesive	38	-29- +70	The fastening is based on an especially well moulding acrylic foam simplifying taping and adhesion to substrate. Suitable for all materials with high surface energy, especially for powder coatings, relief and uneven surfaces. Can be used outdoors.
3M™ Dual Lock™ Reclosable Fasteners – Low Profile/Thin					
SJ-4570	Clear	Acrylic adhesive	-	-29- +50	Low to medium temperature performance. Bonds well to metals, glass, many plastics (polypropylene, polyethylene, polycarbonate, ABS) powder coated paints and medium to low surface energy materials. Half standard thickness. Indoor and limited outdoor use.
SJ-4575	Black	Acrylic adhesive	-	-29- +50	
SJ-4580	Clear	Acrylic adhesive	-	-29- +70	High temperature performance. Bonds well to CARC and enamel paint, bare metal, glass, wood (painted or sealed) and many plastics (acrylic, polystyrene, polycarbonate, ABS). Half standard thickness. Indoor and outdoor use.



3M™ Scotchmate™ SJ-3526 and SJ-3527 tape

3M™SJ-3526 is a tape with hooks and SJ-3527 a tape with loops that together form a strong connection. The backside of each ribbon has rubber adhesive that adheres well to various materials and is moisture resistant.



3M™ Dual Lock™ SJ-3550

SJ-3550 is a Dual Lock fastening system with VHB acrylic adhesive base that is UV and softener resistant. SJ-3550 adheres well to many materials with high surface energy, and uneven surfaces. SJ-3550 can be used outdoors.



3M™ Dual Lock™ SJ-3560

The base of SJ-3560 is a transparent VHB acrylic foam tape. It is well suited for invisible fastening of transparent materials. SJ-3560 resists UV radiation and therefore can be used outdoors.



3M™ Dual Lock™ SJ-4570

3M™ Dual Lock™ Low Profile Reclosable Fasteners SJ4570 can replace conventional fasteners, such as screws, clips, rivets, snaps, hook and loop and bolts in many applications where access or repositioning is needed.

The Dual Lock low profile reclosable fastener SJ4570 is a clear fastener offering transparent properties to allow color and patterns to visibly show through giving the fastener an almost invisible appearance.



Single Coated Tapes

Vinyl, polyethylene and polypropylene tapes



Vinyl (PVC), Polyethylene (PE), Polypropylene (PP) are a recommended alternative for applications where adaptation, colour coding, wearing and chemical resistance are decisive selection criteria.

Product	Colour	Tape structure (carrier/adhesive)	Total thickness (mm)	Bond strength on steel (N/100mm)	Tensile strength (N/100mm)	Temperature resistance (°C)	Additional information
VINYL TAPES							
One-coloured marking tapes							
471	Black, green, blue, brown, orange, red, white, yellow and transparent	PVC / rubber adhesive	0,13	27	263	+4 - +75	Usable under demanding conditions. Protection, marking of paths, colour coding, markings, connecting, sealing and strengthening.
764i	Black, green, blue, brown, orange, red, white, yellow, transparent and grey.	PVC / rubber adhesive	0,12	21	228	+15 - +27	For regular use. Colour coding, marking, bonding and strapping in bunches. Not recommended for marking on floor.
472	Black	PVC / rubber adhesive	0,26	25	560	up to 105°C	Wear resistance.
Double-coloured marking tapes							
5700	Black-white	PVC / rubber adhesive	0,14	21	260	+4 - +75	For use under demanding conditions, printing on adhesive side.
5702	Black-yellow	PVC / rubber adhesive	0,14	21	260	+4 - +75	For use under demanding conditions, printing on adhesive side.
766i	Black-yellow	PVC / rubber adhesive	0,12	21	228	+15 - +27	Not recommended for marking on floor.
767i	Red-white	PVC / rubber adhesive	0.12	21	228	+15 - +27	General-purpose tape.
For galvanising and anodising							
470	Yellowish brown	PVC / rubber adhesive	0.18	28	350	up to +77°C	Chemical resistance.
POLYETHYLENE AND POLYPROPYLENE TAPES							
480	Transparent	PE / acrylic adhesive	0.13	24	180	-5 - +75	Joints and repairs on PE surfaces. Suitable for use under outdoor conditions for protecting and sealing works for up to three months.
481	Black	PE / rubber adhesive	0.25	33	298	-7 - +75	Suitable for use under outdoor conditions for protecting and sealing works for up to two years. Can be removed without adhesive traces.
483	Black, red, blue, green, white, yellow, transparent	PE / rubber adhesive	0.13	13	193	up to +77°C	Suitable for use under outdoor conditions for protecting and sealing works for up to two years. Can be removed without adhesive traces.
3336	Silver, black	PP / acrylic adhesive	0.08	46	392	up to +127°C	Sealing and protecting tape for air pipes and insulation materials. Resistant to moisture and cold. Suitable for outdoor use.
4811	White	PE / rubber adhesive	0.25	36	263	-7 - +75	Sealing tape for storage.



3M™ 471 vinyl tape

471 is a PVC tape with rubber adhesive that can be used under demanding conditions and is suitable for sealing, surface protection and marking, thanks to its elasticity. 471 has a very good wear resistance wherefore it is used for long-term floor marking. The tape adheres strongly on the floor, however, it can be removed without traces even after a long time. Available in many colours.



3M™ 5702 vinyl tape

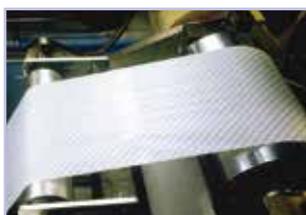
5702 is a warning tape with a black and yellow striped laminated protective surface for use under demanding conditions. Thanks to the good resistance, the tape is used in places where high wearing resistance is required, e.g. for marking floors.





3M™ 850 polyester tape, silver

3M™ Polyester Film Tape 850 can generally be used for splicing and applications where chemical resistance and/or clean removal is necessary. The silver backing is a transparent polyester with a thin layer of aluminum.



3M™ 850 polyester tape, transparent

The 850 polyester tape is resistant, thin and has a long service life. The tape is transparent and does not leave any traces upon removal. Suitable for use in graphic industry.



3M™ 8902 powder coating masking tape

The blue 8902 tape is designed for use in places with high temperature. In addition to heat, the tape also resists chemical and mechanical load. The 8900 series tapes can be used for powder coating, amongst others. Application Ideas:

- Splicing of silicone treated webs.
- Masking parts for powder coat painting
- Holding parts or sealing vacuum bags during processing
- Masking edges of overlap seams in metal bonding process where excess adhesive flows onto tape. Minimizes clean-up on tape removal.
- Composite bonding – sticks well to molds treated with release agent, works as a flash breaker tape on removal of part from mold, seals vacuum bags if vacuum bag treatment is part of the process.
- Provides a good barrier for separation of dissimilar metals.
- Holding silicone or silicone treated parts.



3M™ 5419 low-static polyimide tape

When unwinding the 5419 tape, less static load is produced, so that circuits are not damaged. The tape is used for protecting gold-plated surfaces and connections of printed boards during wave soldering. The tape has a high chemical and temperature resistance.



Extreme Sealing and All Weather Flashing Tape

3M™ Extreme Sealing Tape is an acrylic tape that creates water tight seals over numerous substrates. It easily conforms over contours, edges, rivets, and screw heads resulting in a paintable surface with good outdoor durability.

All Weather Flashing Tape 8067 is a self-adhered, waterproof flashing membrane designed for sealing around openings and penetrations in exterior walls. This product has a unique acrylic pressure sensitive adhesive that aggressively sticks and stays stuck both at lower and higher application temperatures than traditional flashing tapes.

Product	Colour	Tape structure (carrier/adhesive)	Total thickness (mm)	Adhesion strength on steel (N/100mm)	Temperature resistance (°C)	Additional information
Extreme Sealing Tape						
4411G	Grey	Acrylic ethylene / acrylic	1.0	273*	-40 - +93	Family of single coated, pressure sensitive adhesive tapes designed for difficult sealing applications. The backing on this tape is an ionomer film that is very tough yet flexible and abrasion resistant. The very soft and thick acrylic adhesive has excellent sealing properties and good outdoor durability. This single coated tape is designed to seal over an existing joint, seam, or penetration. The adhesive is designed to adhere well to the ionomer film so that overlapping tape joints can be made while maintaining a strong seal.
4411N	Transparent white	Acrylic ethylene / acrylic	1.0	264*	-40 - +93	
4412G	Grey	Acrylic ethylene / acrylic	2.0	307*	-40 - +93	
4412N	Transparent white	Acrylic ethylene / acrylic	2.0	315*	-40 - +93	
All Weather Flashing Tape						
8067	Tan	Acrylic	0.25	66	-40 - +80	Split liner for easier, faster installation.

* With 3M AP111 primer



3M™ Extreme Sealing Tape 4412N

A tape series based on the technology known from the 3M VHB acrylic foam tapes has a very good adherence and can replace adhesive sealing masses and other regular hermetics. A thick adhesive layer adheres quickly to metallic and plastic surfaces and will perfectly adapt to surface. To achieve a finished final result, the special friction proof surface foil of the tape 4412 can be painted. The tapes are well resistant to various weather conditions. Usage in sealing connections in vehicles, ventilation devices and channels as well as in sealing passages in construction industry.



Metal Foil tapes

Metal foil tapes can be used in places where extreme strength of the tape is required. Metal foil tapes resist moisture, UV radiation, chemical load and temperature fluctuations. The tapes can also be used in places where fire resistance or thermal conductivity is of utmost importance.

Aluminium tapes can be used for protecting against moisture and chemicals. Thanks to good thermal conductivity, the aluminium tapes help maximising the efficiency of cooling or heating. Thanks to light and heat reflecting properties of the aluminium tape, it can be used for protecting light-sensitive places or improving light reflection.

Aluminium tapes reinforced with glass fabric are elastic and adapt to the substrate to the bonded. The tape protects elastic cables without reducing their elasticity. Besides that, the tapes are wear, tear and puncture resistant.

Lead tapes are conductive tapes that help avoiding depositions on metal surfaces. Due to their acid proofness, the lead tapes can be used for etching and surfacing works. The high density of lead allows using tapes as mass adding and balancing means, thanks to its impermeability to X-rays, the tape can be used for marking and positioning in X-ray examinations. The soft lead tape can be easily formed by tools.

Product	Tape structure (carrier/adhesive)	Total thickness (mm)	Adhesion strength on steel (N/100mm)	Tensile strength (N/100mm)	Temperature resistance (°C)	Additional information
Aluminium tapes						
425	Aluminium / acrylic adhesive	0.12	54	525	-54 - +149	Universal aluminium tape with a good thermal reflectivity and conductivity. Suitable for sealing, amongst others.
427	Aluminium / acrylic adhesive	0.12	47	473	-54 - +149	425 version with protective paper.
431	Aluminium / acrylic adhesive	0.08	45	333	-54 - +149	Aluminum foil backing with acrylic adhesive. Light weight foil tape for aerospace, appliance, automotive.
433	Aluminium/silicone	0.09	40	403	-54 - +316	High temperature resistance.
1404	Aluminium / acrylic adhesive	0.06	40	270	-50 - +150	Universal tape.
1436	Aluminium / Rubber adhesive	0.075	12	18	-25 - +70	Rubber adhesive bonds to many surfaces. Low water vapor transmission rate offers excellent sealing and patching performance. Best results obtained when applied to clean dry surfaces above 0°C.
2552	Aluminium / viscoelastic acrylic	0.38	72	1400	+5 - +60	Aluminum foil constraining layer coated with a pressure-sensitive viscoelastic polymer on a poly-coated paper easy-release liner.
3334	Aluminium, pe fibre / acrylic	0.17	36	445	> +80	For bonding insulation materials.
3369	Aluminium / acrylic adhesive	0.03 (kalvo)	90	326	> +120	Under moist and cold conditions.
Aluminium tape reinforced with glass fibres						
363	Aluminium, glass fibre / silicone	0.19	59	1944	-54 - +316	High temperature resistance.
Lead foil tapes						
420	Lead / rubber adhesive	0.17	49	350	-54 - +106	Dark silver lead foil tape, lead foil backing with a green rubber adhesive and a clear, easy-release film liner.
421	Lead / rubber adhesive	0.16	34	263	-54 - +106	Dark silver lead foil backing with a green rubber adhesive.



3M™ 425 aluminium tape

425 is a universal aluminium tape that adheres well to substrate. The tape can be used for protecting wires and cables from heat and fire, fastening cooling pipes in cooling devices, and sealing layered plastic plate structures from dust and moisture. Repair tears on truck trailers and aircraft, splicing of thin gauge foils, general purpose holding, patching, sealing applications – indoors and out.



3M™ 2552 damping tape

2552 is a damping tape based on 3M VHB-technology. The tape reduces noise, vibration and shaking load in both plastic and metal structures. The dampening characteristics of the tape are best at temperature range + 5°C till 60°C. General use, trucks, buses, trains, appliances, HVAC, aircraft, aerospace, die-cut aluminum foil parts.



3M™ 420 Lead foil tape

420 is a foil tape with protective liner. The tape is well moulding and easily adapts to uneven substrates.

Application Ideas

- Electroplating
- Radiation barrier
- Moisture barrier
- Chemical milling
- X-ray plate masking
- Maskant during paint stripping
- Add weight (balance) to equipment parts (golf clubs, tennis rackets, etc.)





Duct and masking tape

Ventilation and fabric tapes are basic products used in all manufacturing industries. More often, the usage areas are strapping in bunches, fastening, marking, sealing, and temporary repair of small places. Duct and fabric tapes are strong, adhere to various substrates and resist moisture.

Masking tapes are mostly used for bordering surfaces, however, they can also be used for strapping in bunches, marking, sealing, and small temporary repair works. The tape allows creating a clean paint line, and prevents paint absorption. Masking tapes can be easily used and they do not leave marks after removal.

Note! Masking tapes are usually not used for a long term, therefore, all maximum temperatures in tables apply to short-term use (up to one hour).

Fine Line bordering tapes are thin and resistant, leaving clear borders on painted surfaces. These tapes are moisture and solvent resistant, thanks to which the paint does not infiltrate the tape.

Upon removal, the tape does not break.

Product	Colour	Tape structure (carrier/adhesive)	Total thickness (mm)	Adhesion strength on steel (N/100mm)	Tensile strength (N/100mm)	Temperature resistance (°C)	Additional information
Duct tapes							
1900	Black, silver	Polyethylene coated fabric / rubber adhesive	0.17	60	280	+60	For regular use.
3900	Silver, blue, black, white	Polyethylene coated dense fabric / rubber adhesive	0.19	62	385	+93	For regular use and for more demanding places.
2902	Silver, black, yellow and white	Polyethylene coated fabric / synthetic	0.26	90	800	+65	Hanging, fastening and bonding.
3939	Silver	Polyethylene coated fabric / rubber adhesive	0.23	60	438	+93	For use under demanding conditions.
8979	Blue, olive black	Polyethylene coated fabric / rubber adhesive	0.31	53	630	+93	For indoor and outdoor applications. This tape is removable with little or no adhesive residue from most opaque surfaces up to six months after application.
Masking tapes							
2214	Beige	Paper / rubber adhesive	0.135	26	350	+60	Medium temperature resistance.
2321	Beige	Paper / rubber adhesive	0.135	26	352	+80	Medium temperature resistance, allows curved tape lines.
2364	Beige	Paper / rubber adhesive	0.16	44	400	+100	Medium temperature resistance.
2836	Beige	Paper / rubber adhesive	0.17	44	400	+100	High temperature resistance.
Fine Line masking tapes							
218	Beige	Polypropylene plastic film/rubber adhesive	0.13	40	228	+121	Easy tear, pressure sensitive.
470	Tan	Pigmented vinyl/rubber adhesive	0.18	40.4	350	+121	Excellent resistance to most chemicals, used in typical electroplating processes.
471	Yellow, white, red, black, brown, green, orange, purple, blue, transparent	PVC / rubber adhesive	0.13	27	263	+75	Low temperature resistance.
472	Black	Vinyl/rubber adhesive	0.26	25	560	+107	Extra thick, durable backing, protection from blasting, abrasion resistance, outdoor weathering applications.
4712	Yellow, white, red, black, brown, green, orange, purple, blue, transparent	PVC / rubber adhesive	0.14	25	270	+77	Can be printed using thermal printing process.



3M™ 3900 multi-purpose duct tape

Multi-Purpose Duct Tape 3900 is a general purpose, conformable cloth duct tape made with polyethylene film over cloth scrim and rubber adhesive. A good choice for general maintenance, wrapping, sealing, protecting and color coding.



3M™ 8979 performance plus duct tape

Performance Plus Duct Tape 8979 has a unique tape construction that allows for both permanent and temporary applications indoor and outdoor. It is removable with little or no adhesive residue from most opaque surfaces up to 6 months after application. The backing is also UV resistant for up to one year of outdoor exposure.

Application Ideas

- Ideal for demanding duct tape applications in the construction, electrical, industrial, marine and military markets.
- Applications for sealing, holding, identification and protection.
- Maintenance Repair and Other (MRO) applications for patching, bundling, reinforcing, tabbing and temporary repair.
- Taping and splicing insulation, capping pipe and conduit ends, marking and labeling.
- Hanging polyethylene drapes, industrial masking and light sandblast overspray protection.



Scotch® 2214 masking tape

Paper Tape 2214 is a general purpose paper masking tape for holding, bundling, sealing and non-critical masking. It is thin, has a good adherence and resistance, and it can be used at up to 60°C.



Scotch® 2321 masking tape

Paper masking tape 2321 is a chamois coloured crepe paper coated with a cross linked rubber resin adhesive.

The elastic carrier allows bordering surfaces with curved edges. The tape is solvent proof and does not absorb paint when used for masking.

Designed for indoor use only.



Packaging tapes

3M offers packaging tapes for both heavy and light packages. From 3M tapes, you can find an alternative for other packing materials, such as for recycled fibre material. Besides that, the tape is printable.



Tartan™ 369 box sealing tape

Tartan™ 369 box sealing tape is a clear polypropylene box sealing tape with a rubber adhesive used for noncritical box sealing applications. This product has a conformable backing and a pressure sensitive hot melt adhesive system. This construction provides a good closure for lightweight boxes exposed to minimal distribution hazards.



Scotch® 371 packaging tape

The 371 packaging tape has a rubber resin based Hot Melt adhesive that does not contain solvents. The tape adheres well to both regular and recycled cardboard and seals boxes in a reliable manner. Resistant to moisture and wearing. Scotch® Box Sealing Tape 371 is a valued performance polypropylene film box sealing tape. Scotch® Box Sealing Tape 371 is an industrial packaging tape used for box sealing, splicing, recoupage and other packaging applications. This product has a conformable backing and a consistent pressure sensitive hot melt synthetic rubber adhesive system.



Scotch® 373 packaging tape

The 373 packaging tape is a polypropylene carton sealing tape, with a strong backing and high performance adhesive that provides a secure and durable closure. Tape can be custom printed to provide security and/or branding.

Product	Colour	Tape structure (carrier/adhesive)	Total thickness (mm)	Additional information
Packaging tapes				
6890	Transparent, brown	PVC/ rubber adhesive	0.050	For sealing boxes and strapping products in bunches. Noiseless.
Packaging tapes - with rubber adhesive				
3701	Transparent, brown	PP/ rubber adhesive	0.046	Resists splitting when subjected to rough handling and absorbs impact shock. Abrasion and moisture resistant. No dwell time necessary, adheres immediately.
3739	Transparent, brown	PP/ rubber adhesive	0.056	Box sealing tape with a bi-axially orientated polypropylene film backing and hot melt solvent free (synthetic rubber/resin) adhesive. The polypropylene backing resists splitting when subjected to rough handling and absorbs impact shock.
371	Transparent, brown	PP/Hot-Melt	0.048	For sealing light boxes, also usable with boxes made from recycled fibres. General tape for sealing, available with EAN code.
373	Blue, clear, green, orange, red, tan, white, yellow	PP/Hot-Melt	0.064	For box sealing, splicing, recoupage and other demanding packaging applications.
375E	Transparent, brown	PP/Hot-Melt	0.075	For closing heavy boxes, resists rough handling. Very strong tape.
Packaging tapes - with rubber adhesive				
3703	Transparent, brown	PP / rubber adhesive	0.053	3703, 3705, 3707 are performance box sealing tapes with a bi-axially orientated polypropylene film backing and solvent (natural rubber/resin) adhesive. The Scotch-Pro™ polypropylene backing resists splitting when subjected to rough handling and absorbs impact shock. The adhesive is specifically formulated to provide high initial tack and shear adhesion to fibreboard – including recycled fibreboards.
3705	Transparent, brown	PP / rubber adhesive	0.073	
3707	Transparent, brown	PP / rubber adhesive	0.055	



Tape dispensers

For simplifying the application of tapes, 3M offers various manual dispensers for both packaging and strapping tapes.



H-180



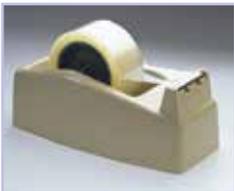
TI-1756

Scotch® H-180 and Scotch® H-150 manual dispensers for packaging tapes

Manual dispensers H-180 and H-150 have been designed for wrapping and cutting off packaging tapes with a width of 50 mm. H-150 is designed to reduce the noise of tape unwind during application. The dispenser TI-1756 has an adjustable friction brake.



H-150



C-22



C-23



P-52



P-56



H-12



H-130

Product	Product characteristics
Packaging tapes	
TI-1756	Dispenser with handle for packaging tapes with a width of up to 50 mm. Equipped with adjustable friction brake.
H-180	Dispenser with handle for packaging tapes with a width of up to 50 mm. Equipped with friction brake.
H-183	Dispenser with handle for packaging tapes with a width of up to 75 mm. Equipped with friction brake.
H-150	Dispenser with handle for packaging tapes with a width of up to 50 mm. Equipped with noise dampening mechanism.
C-22	Sturdy table mounted dispenser for two rolls with a width of up to 50 mm.
C-23	Sturdy table mounted dispenser for a tape with a width of up to 25 mm.
P-52	Table or wall mounted model for a tape with a width of up to 50 mm. Fastening with double sided tape or screws.
P-56	Same as P-52, but for packing tape with a width of up to 150 mm.
Pocket tapes	
M-777	Table mounted model for pocket tapes 8241/8242. Portable - equipped with weights.
Strapping tape with glass fibre	
H-12	Plastic hand dispenser for strapping tape with a width of up to 25 mm. Equipped with rolling/tension adjustment brake.
H-130	Plastic hand dispenser for strapping tape with a width of up to 19 mm. Equipped with rolling/tension adjustment brake.

Special Materials

3M™ Label materials

Whenever you need marking your components, number your batches, write customer data, produce user instructions or labels for printing by thermal or laser printers or that have to resist high or low temperatures, moisture, etc., as well as when a label is just the final touch on your product, 3M has a solution.

The labels should adhere to any surfaces and be easily removable. 3M has carried out thorough research, and solutions have been found for all needs.



Label materials for thermal printers

With this system, labels can be printed quickly and quietly for various solutions. The toner is transferred from toner band to label by heat.

- High resolution
- Good resistance
- Bar code compliant
- Colour print
- Various adhesives for many substrates available
- Flexible printing process

Label materials for laser printers

On label materials for laser printers, both monochrome and colour printers can be used. No other devices are required.

- Printing with available office equipment
- No additional investment required
- Immediate printing out, if required
- Deep colours
- Various adhesives for many substrates available

Label materials for laser marking

Information is engraved by a laser beam in a special foil manufactured at 3M, so that resistant labels with precise resolution for safety related use can be produced.

- Great wearing resistance
- Great resistance to chemicals
- Great temperature resistance
- Great readability of bar codes
- Adheres well to many substrates
- Material is breakable and can be easily torn, it is difficult to remove the labels in one piece

Protective laminate foils

For some applications, a very good resistance is required. To this end, a printed label can be covered with transparent protective label.

- Better resistance
- For in- and outdoor use
- The appearance of labels is improved
- High-quality impression
- Protects print mark
- Protects the image of your product

Special materials

Different industry branches have different requirements to labels. Maybe you need labels that need be reliably fastened for a long time, and then be easily removed without leaving any traces. Maybe the label has to be scannable or easily visible from a distance. And when the label is attached to a product that the manufacturer has to recycle after end of usage, the label has to be recyclable together with the product. Some labels have to resist high temperature, some labels are part of security system. The special materials of 3M™ labels satisfy all such needs.





3M™ Laminating tapes

Double-sided tapes where reliable adherence on almost any substrate is achieved by various adhesive types. The products are manufactured under strict quality supervision as rolls or sheets. Adhesives suitable for demanding applications are high temperature, moisture and chemical resistant, and reliably adhere on problematic substrates.

Double-sided 3M laminated tapes are used for attaching:

- product labels on machines and devices
- printed control panels on electronic and electric devices used under demanding conditions
- styrofoam and sealing materials for the most difficult applications in vehicle industry

Sheet tape is used when it has to be cut into a precise shape – double-sided high-quality cover paper with plastic surfaces also ensures a fast and smooth fastening.



Spacers for membrane switches

3M™ spacers are single- or double sided tapes with support foil for manufacturing membrane switches and keypads. 3M has designed a product range for various membrane switch applications. The tapes reliably resist loads occurring during usage and ensure operation of devices under toughest conditions during the whole service life of a membrane switch.

Upon pressing a switch, the 3M spacers separate the printed boards included in the membrane switch from each other. Tape adhesive has a very high internal strength and tapes are designed for withstanding extreme temperature, moisture, UV radiance and chemicals. A full reliability and functionality is ensured by the 3M laminating tape selected as fastening tape for switches. This way, a faultless operation of the controlled device is ensured. The reliability achieved by 3M materials is a characteristic that leading device manufacturers in the health industry, for instance, have trusted for decades.



Structural Adhesives

3M™ Scotch-Weld™ EPX™ structural adhesives



Structural adhesives are very strong adhesives that allow making connections that resist high loads (7MPa). The strength of the adhesive connection is often as high as the internal strength of connected materials or even higher. 3M™ Scotch-Weld™ EPX structural adhesives range is widely used in product assembly where high bonding performance is required, and also for sealing and potting in electrical / electronic applications.

The EPX is system of controlled dosing two component adhesive.

Product	Colour	Mixing ratio (B:A)	Working time (in minutes)	Time to handling strength	Viscosity	Shear strength (AI, N/mm ²)			Peeling strength (AI, N/cm)	Temperature resistance (°C)
						-55°C	+23°C	+80°C		
EPOXIDE ADHESIVES										
DP-100	Transparent	1:1	3-5	15 min	liquid	6	9	2	4	-50- +80
DP-105	Transparent	1:1	4-5	20 min	liquid	24	14	2	62	-50- +80
DP-110	Transparent or grey	1:1	8-10	20 min	semi-liquid	14	18	1	35	-50- +80
DP-125	Grey	1:1	25	2-3 h	semi-liquid	24	24	3	62	-50- +80
DP-190	Grey	1:1	90	4-6 h	semi-liquid	11	18	3	21	-50- +80
DP-270	Transparent or black	1:1	60-70	4-6 h	very thin liquid	8	17	2	<4	-50- +80
DP-410NS	Yellowish white	2:1	8-10	30 min	non-sagging	29	34	8	100	-50- +80
DP-460	Yellowish white	2:1	60	4-6 h	semi-liquid	31	31	5	107	-50- +80
DP-490	Black	2:1	180	4 h	non-sagging	24	30	12	92	-50- +120
DP-760	White	2:1	45-60	4-6 h	non-sagging	20	29	24	60	-50- +230
POLYURETHANE ADHESIVES										
DP-609	Yellowish white	1:1	7	45 min	non-sagging	17	14	2	70	-50- +80
DP-610	Transparent	1:1	10	2 h	liquid	34	23	3	78	-50- +80
ACRYLIC ADHESIVES										
DP-801	Green	1:1	1-2	7 min	non-flowing	19	13	2	24	-50- +80
DP-804	Transparent	1:1	3	4	very thin liquid	-	8	9		0- +100
DP-807	Yellow	1:1	5	10 min	non-flowing	14	29	6	46	-50- +80
DP-810	Green	1:1	8	10-15 min	non-flowing	8	30	3	52	-50- +80
DP-812	Yellow	1:1	10	20 min	non-flowing	15	33	7	52	-50- +80
DP-825	Yellow	1:1	25	35 min	non-flowing	18	31	7	49	-50- +80
DP-8005	Yellowish white	10:1	2-3	90 min	non-sagging	12*	6*	2*	28**	-50- +80
DP-8010	Yellowish white	10:1	10	120 min	non-sagging	6*	10*	2*	28**	-50- +80
DP-8405NS	Green	10:1	2-4	14-16 min	mixed 75000	na	28.5	na	8.8	-50- +80
DP-8810NS	Blue-Green	10:1	8-12	16-20 min	mixed 90000	na	23.6	na	5.3	-50- +80

* PP/PP

** HDPE

Selection table for EPX adhesives by substrates

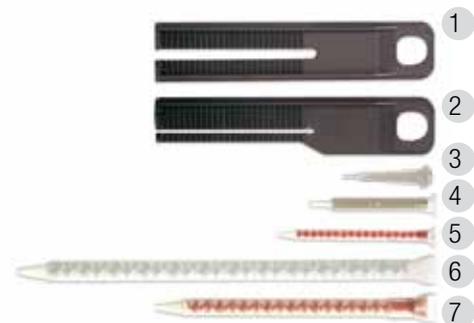
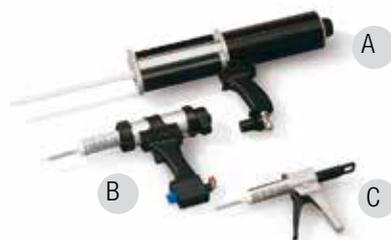
	Wood	Metal	Rubber	Glass	Plastic ¹	Nylon	Strong foams ²	LSE materials ³
Wood	DP-100 DP-125 DP-190 DP-609 DP-8405NS DP-8810NS	DP-125 DP-190 DP-460 DP-810 DP-8405NS DP-8810NS	DP-125 DP-190	DP-125 DP-190 DP-620NS DP-8405NS DP-8810NS	DP-125 DP-190 DP-620NS DP-8405NS DP-8810NS	DP-125 DP-190 DP-460 DP-609 DP-8405NS DP-8810NS	DP-125 DP-190 DP-620NS	DP-8005 DP-8010
Metal	DP-125 DP-190 DP-460 DP-810 DP-8405NS DP-8810NS	DP-110 DP-125 DP-190 DP-410NS DP-460 DP-810 DP-8405NS DP-8810NS	DP-125 DP-190	DP-125 DP-190 DP-804 DP-8405NS DP-8810NS	DP-110 DP-125 DP-190 DP-410NS DP-460 DP-609 DP-804 DP-8405NS DP-8810NS	DP-125 DP-190 DP-8405NS DP-8810NS	DP-125 DP-190	DP-8005
Rubber	DP-125 DP-190	DP-125 DP-190	DP-125 DP-190	DP-125 DP-190	DP-125 DP-190	DP-125 DP-190	DP-125 DP-190	DP-8010
Glass	DP-125 DP-190 DP-620NS DP-8405NS DP-8810NS	DP-125 DP-190 DP-804 DP-8405NS DP-8810NS	DP-125 DP-190	DP-125 DP-190 DP-620NS DP-8405NS DP-8810NS	DP-125 DP-190 DP-620NS DP-8405NS DP-8810NS	DP-125 DP-190 DP-8405NS DP-8810NS	DP-125 DP-190 DP-620NS	DP-8010
Plastic ¹	DP-125 DP-190 DP-620NS DP-8405NS DP-8810NS	DP-110 DP-125 DP-190 DP-410NS DP-460 DP-609 DP-804 DP-8405NS DP-8810NS	DP-125 DP-190	DP-125 DP-190 DP-620NS DP-8405NS DP-8810NS	DP-110 DP-125 DP-190 DP-410NS DP-460 DP-804 DP-8405NS DP-8810NS	DP-125 DP-190 DP-460 DP-8405NS DP-8810NS	DP-125 DP-190	DP-8005 DP-8010
Nylon	DP-125 DP-190 DP-460 DP-609 DP-8405NS DP-8810NS	DP-125 DP-190 DP-8405NS DP-8810NS	DP-125 DP-190	DP-125 DP-190 DP-8405NS DP-8810NS	DP-125 DP-190 DP-460 DP-8405NS DP-8810NS	DP-125 DP-190 DP-460 DP-8405NS DP-8810NS	DP-125 DP-190 DP-460	-
Strong foams ²	DP-125 DP-190 DP-620NS	DP-125 DP-190	DP-125 DP-190	DP-125 DP-190 DP-620NS	DP-125 DP-190	DP-125 DP-190 DP-460	DP-125 DP-190 DP-620NS	DP-8005 DP-8010
LSE materials ³	DP-8005 DP-8010	DP-8005	DP-8010	DP-8010	DP-8005 DP-8010	-	DP-8005 DP-8010	DP-8005 DP-8010

1) Plastics include ABS, PVC, acrylic, etc. (polyolefines are not included)

2) Rigid foams include styrene and urethane

3) LSE (low surface energy) materials include polyolefines, e.g. polypropylene and polyethylene.

EPX adhesive applicators and accessories



A EPX adhesive applicator with pressure air for 1:1 and 2:1 400 ml cartridges EPX adhesive applicator with pressure air for DP8005, DP8010 and 265 ml cartridges (not shown in the picture)

B EPX adhesive applicator with pressure air for 1:1 and 2:1 50 ml cartridges
Manual EPX adhesive applicator set with a 1:1/2:1 piston - suitable for 50 ml cartridges

C Note! For 38 ml 10:1 cartridges (DP8005, DP8010), a 10:1 plunger is required.

- 1** EPX plunger for 50 ml cartridges with a mixture ratio of 1:1/2:1
- 2** EPX plunger for 38 ml DP8005/DP8010 cartridges with a mixture ratio of 10:1
- 3** Nozzle for 50 ml DP800 series adhesives
- 4** EPX™ Square Orange Mixing Nozzle for 45 ml
- 5** Nozzle for 38 ml DP8005/DP8010 cartridges
- 6** Nozzle for all 400 ml cartridges
- 7** Nozzle for 265 ml DP8005/DP8010 cartridges



3M™ Scotch-Weld Structural Adhesives in Duo-Pack Cartridges and Bulk

3M 7200 series adhesives are high performance, two-part toughened adhesive. Offers high shear and peel adhesion and outstanding levels of durability.

Product/colour	Main substance	Flowability	Mixing ratio (B:A)	Curing time	Shear strength (23°C, MPa) t	Additional information
7240 B/A FR	Modified Epoxy	thick	2:1	5 h	20-25	Fire proof (F.A.R. 25).
7260 B/A	Modified Epoxy	liquid	2:1	18 h	30-35	Also available in liquid version S/W 7260 B/A FC NS.
7260 B/A FC	Modified Epoxy	liquid	2:1	7 h	30-35	Also available in liquid version S/W 7260 B/A NS.
7231 B/A	Epoxy	liquid	10:7, By weight	6-8 h	-	Easily applied floor adhesive.
1838 green	Epoxy	liquid	4:5	60 min	-	Excellent for bonding many metals, woods, rubbers and some plastics.
2214 regular gray	Modified Epoxy	paste	-	60 min	-	High temperature strength, low temperature curing
2216 gray	Modified Epoxy	liquid	2:3	10 h	-	High performance, rigid bonds
3532	Urethane	-	1:1	90 min	25	Multi purpose, semi-rigid bonds.
3549	Urethane	thick	1:1	8 h	30-35	Tough Flexible bonds.
7260NS	Modified Epoxy	half-thick	2:1	5 days	-	
7271	Epoxy acrylate	thick	1:1	-	-	Extremely non-sag.
9323	Epoxy	half-thick	2:1	7 days	-	High impact resistance. High environmental resistance.

* Products are available in duo pack and bulk packaging.



3M™ Scotch-Weld™ cyanoacrylate adhesive

Scotch-Weld™ Cyanoacrylate Adhesives are high specification - single component adhesives. Fast and easy to use - these adhesives are solvent free and exhibit high tensile and shear strengths. Scotch-Weld Cyanoacrylate Adhesives bond a wide variety of substrates and can be easily used with both manual and automated dispensing equipment.



3M™ Scotch-Weld™ pipe sealant PS77

The pipe sealant has been designed for sealing in order to avoid leakages of gaseous and liquid substances. Replaces regular pipe tape and allows save costs.



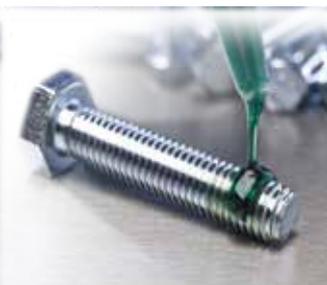
3M™ Scotch-Weld™ cylindrical component bond RT38

Bonding adhesives are especially strong, have a long service time and a high temperature resistance. They can be used for reliable bonding gear wheels to shaft, or bearings. RT38 creates a strong and reliable connection where disassembly is not required for maintenance. Fastening bushes, sleeves to shaft.



3M™ Scotch-Weld™ bonding adhesive RT41

RT41 is formulated for bonding cylindrical parts, to give medium strength retaining. Typical applications include mounting bearings in place on shafts and in housings. The controlled medium strength allows disassembly for servicing and bearing re-use. RT41 is designed to augment the strength of press fit assemblies. Once applied, parts slip together easily, lubricated by the adhesive. RT41 prevents corrosion of assembled parts.



3M™ Scotch-Weld™ medium-strength oil proof thread adhesive TL43

Fast curing, medium strength screw lock. Prevents screws, nuts, and other threaded metal parts from loosening as a result of vibration. Besides that, seals and protects from corrosion, can be opened by hand tools. Suitable for slightly oiled surfaces.

Non Structural Adhesives

The 3M™ Scotch-Weld™ hot melt system is a universal and simple way for manufacturing most often used materials in industry. A great selection contains suitable products for packing, connecting plastics as well as for furniture and electronics industry.

Hot melts do not contain solvents and are made from thermal plastics that become liquid upon heating. After cooling off, they form a strong bond. Hot melts can be used with many different materials such as wood, plastics, foamed materials: foamed materials, fabric, polystyrene and cardboard. Hot melt is not recommended for metals.

Specifications of Hot Melts

Adhesive	Colour	Product range	Temperature resistance	Shear strength (N/mm ²)	Peeling strength (N/cm)	Additional information
LOW-MELT hot melts. Adhesives can be used already at 130°C as well as for fastening sensitive materials such as styrofoam.						
3762LM	Light brown	TCQ LT, EC	0 - +55	3.3	10	Great adherence on surface.
3792LM	Transparent	TCQ LT, EC	0 - +60	2.4	22	Long usage time.
3731	Off-white, Tan	B, Q	0 - +129			High temperature resistance, fast setting, low surface energy (LSE) substrate bonding thermoplastic adhesive.
Hot Melt						
3738	Brown	TCQ, EC, SW2	0 - +55	2.58	23	Long working time.
3747	Light brown	TCQ, EC, SW2	0 - +65	2.96	35	General purpose. Compatible for plastics and wood.
3748	Natural white	TCQ, EC, SW2	0 - +80	1.7	31	Good temperature resistance. For use in electronics.
3748V-0	Light yellow	TCQ, EC	0 - +80	1.89	26	3748 is self-extinguishing.
3762	Brown	TCQ, EC, SW2	0 - +55	3.75	12	Great adherence to substrate.
3764	Transparent	TCQ, EC, SW2	0 - +60	2.69	25	Great adhesive for plastics.
3779	Transparent, yellowish brown	TCQ, EC, SW2	0 - +150	4.82	32	High temperature resistance, for use in electronics.
3789	Transparent, yellowish brown	TCQ, EC, SW2	0 - +105	3.9	28	Good softener and fuel resistance.
3792	Transparent	TCQ, EC, SW2	0 - +60	1.7	23	Universal adhesive, long working time.
3796	Brown	SW2	0 - +100	3.8	51	High temperature resistance, perfect for plastics.



Scotch-Weld Quadrack cartridge measurements are 15 x 200 mm and weight 30 grams. They are used together with adhesive applicators TC Quadrack, TC Quadrack LT and EC. Cartridges are sold in 5 kg boxes containing about 165 cartridges.

Scotch-Weld PG cartridge measurements are 26 x 76 mm and weight 36 grams. They are used together with the adhesive applicator SW2. Cartridges are sold in 10 kg boxes containing about 270 cartridges.



Hot Melt selection table

Substrate to be bonded		and	Hot Melt
Plastic components:	Acrylic	Plastic, wood and cardboard	3764, 3792, 3792LM
	Soft vinyl		3789
	Hard vinyl		3764, 3789, 3792, 3792LM
	Polyester		3764, 3792, 3792LM
	PE/PP		3731, 3748, 3764, 3792, 3792LM
	Abs/polycarbonate		3764, 3792, 3792LM
	Strong polystyrene		3764, 3789
	Polystyrene foam		3762LM, 3792LM
	Polyurethane foam		3764, 3789, 3792, 3792LM
Rubber	Plastic, rubber and wood		3747, 3748, 3789
Metal	Metal		3738, 3747, 3796*
	Rubber		3738, 3747, 3796*
	Wood, paper, textile and fabric		3738, 3747
	Glass and ceramics		3796*
	Leather		3789, 3796*
	Plastic		3747, 3796*
Paper and cardboard	Paper and cardboard		3762, 3762LM
	Metal, plastics or glass		3738, 3747, 3792, 3792LM
Wood	Metal		3738, 3796*
	Rubber		3717, 3789
	Wood		3738, 3747, 3789, 3792, 3792LM
	Paper, cardboard, textile or fabric		3738, 3747, 3789, 3792, 3792LM
Textile, fabric	Plastics, wood or glass		3738, 3764, 3789, 3792, 3792LM
Glass and ceramics	Glass, ceramics, textiles, fabric, cardboard or plastic		3764, 3789
	Metal		3796*
Leather	Leather, metal or wood		3789, 3796*



* available with a Scotch-Weld 2 adhesive applicator only.



3M™ Low Melt adhesives

Low Melt adhesives (LM) already melt at 130°C. 3762 LM has been designed for sealing packages. Thanks to immediate adhesion, the connection is produced quickly.

3792 LM multi-purpose adhesive for bonding polystyrene foam, polyolefines, ABS, polycarbonate and wood.



3M™ Hot Melt 3748

3748 is a hot melt that easily adapts to temperature changes. The adhesive can replace silicones curing at room temperature as well as polyamide based hot melts. It adheres well to plastics with low surface energy.

3M™ Scotch-Weld™ EC hot melt applicator

EC is the newest and most universal adhesive applicator. Temperature adjuster allows dosing the melt at various temperatures between 130-232°C. Ergonomic grip and adjustable feed mechanism allow exact dosing.

Feed capacity of adhesive: 50 g/min
 Weight: 860 g
 Capacity: 380 W
 Adhesive cartridges:
 S/W Quadrack and S/W Quadrack/LM



3M™ Scotch-Weld™ TC Quadrack hot met applicator

3M™ Scotch-Weld™ hot melt applicator TC Quadrack palm trigger causes less tiredness when long glue strips are required.

Feed capacity of adhesive: 36 g/min
 Weight: 370 g
 Power: 150 W
 Adhesive cartridges: S/W Quadrack

3M™ Scotch-Weld™ LT Quadrack adhesive gun

Weld adhesive applicator LT Quadrack is an adhesive applicator for Low Melt adhesives where adhesive temperature is about 130°C.

Feed capacity of adhesive: 36 g/min
 Weight: 370 g
 Power: 150 W
 Adhesive cartridges: S/W Quadrack/LM

3M™ Scotch-Weld™ Polygun 2 adhesive applicator

This pressure air adhesive applicator has the biggest feed capacity in the series. The adhesive applicator Scotch-Weld 2 is recommended when long adhesive strips or big adhesive amounts are required. A feed magazine is available for the adhesive applicator. Besides that, the adhesive applicator can be fastened to table, allowing to use the adhesive applicator with a semi-automatic pedal.

Feed capacity of adhesive: 60 g/min
 Weight: 1500 g
 Capacity: 500W
 Adhesive cartridges: S/W PG



3M™ Scotch-Weld™ hot melt accessories



Nozzle	Tip no.	Description	Adhesive applicator
A	9922	Nozzle for flowable adhesives. 1.6mm opening.	EC/TCQ/TCQ LT
B	9921	Standard nozzle. 2.3mm opening.	EC/TCQ/TCQ LT
C	9940	Nozzle for solid adhesives. 3.2mm opening.	EC/TCQ/TCQ LT
D	9725	Long nozzle. 1.8mm opening.	EC/TCQ/TCQ LT
E	9785	Long conical aluminium nozzle. 1.8mm opening.	EC/TCQ/TCQ LT
F	9846	Long brass nozzle. 1.8mm opening.	SW 2
G	9726	T-nozzle + valve	EC/TCQ/TCQ LT
H	9727	L-nozzle + valve	EC/TCQ/TCQ LT
I	9929	Nozzle + valve for solid adhesives recommended for 3779, 3789 and 3747 adhesives)	EC/TCQ/TCQ LT

3M™ Scotch-Weld™ Aerosol Adhesives



3M aerosol adhesives can be easily used and applied. Always ready for use products create a strong, elastic and consumption efficient bond. The range includes five aerosol adhesives for different purposes:

- 74: styrofoam and textile adhesive that is perfect for upholstery.
- 75: adhesive for temporary bonding of light materials.
- 77: multi-purpose adhesive for permanent bonding of light materials.
- 80: contact adhesive for bonding various rubbers (e.g. EPDM). Also suitable for fastening vinyl and leather
- 90: fast adhesive for plastics. Bonds even polyethylene and polypropylene to wood, metal and many other materials.



By spraying, an even and thin adhesive layer can be achieved.



A special spray pattern allows achieving clear contours.

Product	S-W 74	S-W 75	S-W 77	S-W 80	S-W 90
Adhesion strength	Good	Removable	Moderate	Especially good	Good
180° peeling strength N/25mm	89	22	67	155	111
Weather proofness	Good	Moderate	Especially good	Good	Good
Water proofness	Good	Good	Especially good	Especially good	Good
UV radiance proof	Moderate	Good	Moderate	Good	Moderate
Softener proofness	Not good	Not good	Moderate	Especially good	Not good
Oil and fuel proofness	Not good	Not good	Not good	Good	Not good
Time resistance	Great	Great	Especially good	Great	Great
Temperature resistance°C	49	49	43	93	71
Open time: When covering a single surface When covering both surfaces	-	5 sec - hour	30 sec - 15 min	-	30 sec - 2 min
	15 min	5 sec - hour	30 sec - 30 min	4 min - 30 min	2 min - 10 min
Sprayer	Adjustable	Fixed	Adjustable	Fixed	Adjustable
Spray Pattern	Lace	Mist	Mist	Lace	Lace



3M™ Scotch-Weld™ Cleaner spray

The cleaner spray is a universal cleansing agent that efficiently removes regular dirt such as grease, oil and mud. It can also remove residues of many adhesives. The cleaner spray does not contain solvents.





Aerosol Adhesive Cylinders

The 3M™ Sprayable Adhesives portfolio offers a complete continuum of products for bonding a variety of surfaces; water-based adhesives, solvent-based adhesives, aerosol, cylinder, and bulk dispensing options. GreenGuard™ Certified and LEED -Compliant products, regulatory compliance solutions.

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

Product	Colour	Substrate
70	Clear	EPDM Rubber, Fabric, Felt, Cork & Fibrous Glass, Flexible Foam (Latex, Urethane), Glass & Ceramics, Leather, Metal, Paper & Cardboard, Plastics (ABS, PVC, Acrylic), Plastics (Flexible Vinyl), Plastics (High Performance Nylon), Plastics (Polyolefins and Thermoplastic Elastomers), Rigid Foam (Beadboard Styrene), Rigid Foam (Urethane), Rubber (Except EPDM), Wood & Hardboard
74	Clear, Orange	Rubber (Except EPDM), Metal, Paper & Cardboard, Leather, Wood & Hardboard, Plastics (ABS, PVC, Acrylic), Fabric, Felt, Cork & Fibrous Glass, Plastics (Flexible Vinyl), Flexible Foam (Latex, Urethane), Plastics (Polyolefins and Thermoplastic Elastomers), Glass & Ceramics, Rigid Foam (Urethane), EPDM Rubber, Plastics (High Performance Nylon)
77	Translucent, Clear	Rubber (Except EPDM), Metal, Paper & Cardboard, Leather, Wood & Hardboard, Plastics (ABS, PVC, Acrylic), Fabric, Felt, Cork & Fibrous Glass, Plastics (Flexible Vinyl), Flexible Foam (Latex, Urethane), Plastics (Polyolefins and Thermoplastic Elastomers), Glass & Ceramics, Rigid Foam (Urethane), EPDM Rubber, Plastics (High Performance Nylon)
78HT	Blue	Rubber (Except EPDM), Metal, Paper & Cardboard, Leather, Wood & Hardboard, Plastics (ABS, PVC, Acrylic), Fabric, Felt, Cork & Fibrous Glass, Plastics (Flexible Vinyl), Flexible Foam (Latex, Urethane), Plastics (Polyolefins and Thermoplastic Elastomers), Rigid Foam (Beadboard Styrene), Glass & Ceramics, Rigid Foam (Urethane), EPDM Rubber, Plastics (High Performance Nylon)
94CA	Red, Clear	Rubber (Except EPDM), Metal, Paper & Cardboard, Leather, Wood & Hardboard, Plastics (ABS, PVC, Acrylic), Fabric, Felt, Cork & Fibrous Glass, Plastics (Flexible Vinyl), Flexible Foam (Latex, Urethane), Plastics (Polyolefins and Thermoplastic Elastomers), Glass & Ceramics, Rigid Foam (Urethane), EPDM Rubber, Plastics (High Performance Nylon)
Adhesive Remover Cylinder	Pale Yellow, Clear	All substrates



Aerosol Adhesive Cylinders Equipment

Product
Applicator W/QSS Tip
Output (incl 4001)
Output (incl 9501)
VE 12 Foot Hose
VE 4001 Spray Tip
VE 6501 Spray Tip
VE 9501 Spray Tip
VE QSS Spray Tip

Solvent based adhesives

Aerosol adhesives table

What is glued	With what	Recommended adhesive
Plastic (acrylic)	Metal, plastic, wood (plate), acrylic	77, 90
Plastic (vinyl)	Metal, plastic wood (plate)	90** 80, 90**
Plastic (polyester) and plastic foil	Metal, plastic, wood (plate)	80, 90 77, 80, 90 80, 90
Plastic (polyethylene and polypropylene)	Metal, plastic, wood (plate)	90
Plastic (ABS and polycarbonate)	ABS, polycarbonate, metal, wood (plate)	77, 80
Plastic (polystyrene)	Metal, plastic, wood (plate)	80, 90
Plastic (polystyrene foam)	Metal, plastic, wood (plate)	77
Plastic (PU foam)	Metal, plastic, wood (plate)	74, 75*, 77, 80, 90
Plastic (PVC)	Metal, plastic, wood (plate)	77, 80, 90
Plastic (vinyl, softened)	Metal, plastic, wood (plate)	80
Rubber	Metal, plastic Painted surfaces, rubber, wood (plate)	80 90 (vain SBR)
Metal	Fabric, felt, cork, glass fibre. Glass, ceramic, leather, metal. Paper and cardboard, rubber.	77, 90 80, 90 75, 77 80
Paper and cardboard	Metal, glass, ceramic, paper, cardboard, wood (plate)	75*, 77
Wood (plate)	Fabric, felt, cork, paper, cardboard, glass fibre. Metal, rubber, wood (plate)	75*, 77, 90 80, 90
Fabric	Metal, glass, ceramic, paper, cardboard, wood (plate)	75*, 77 74
Felt and cork	Metal	77, 80, 90
Glass fibre	Glass, ceramic, paper, cardboard, wood (plate), painted surfaces.	74
Glass and ceramics	Fabric, felt, cork, glass plastic, paper and cardboard. Glass and ceramic, metal, plastic.	75*, 77 80, 90
Leather	Leather, metal, wood (plate)	80, 90

* for temporary bonding ** plastic softeners can affect the strength/durability of bond

Other solvent based adhesives

Product	Colour	Base	Viscosity	Density	Open time	Temperature resistance°C	Application method	Additional information
847	Brown	Nitrile	Medium liquid	33-39%	20 min	-40 - +120	Brush, spatula, air gun	Special adhesive for rubber, foil, steel, aluminium and leather. Resistant to most oils.
1099	Light	Nitrile	Very thin	31-37%	15 min	-40 - +120	Brush, spatula, air gun	Compatible with foil, metal and rubber materials and especially on hard and soft PVC.
4475	Transparent	Synthetic resin	Thick/dense liquid	41-45%	10 min	-30 - +80	Brush, spatula, air gun	Great resistance to softeners. Compatible with plastics, glass, leather, fabrics and metals.
10	Yellow	Polychlorpren	Liquid	21-23%	30 min	-30 - +105	Brush, syringe	Contact adhesive for bonding laminates, rubber, fabrics and PVC.
1300L	Yellow	Polychlorpren	Liquid	28-35%	8 min	-21 - +149	Brush, syringe	Good temperature resistance.

Water based contact adhesives



Water based contact adhesives are an environmental friendly alternative to solvent based adhesives as they do not contain volatile organic compounds. Water based adhesives allow bonding many materials such as wood, paper, cork, leather, fabric, plastics, glass and ceramics. The adhesives resist moisture and are durable.

	Contact adhesives				Foam rubber adhesive	Insulation materials adhesive	Pressure sensitive adhesive
Product	S/W 30	S/W 40	S/W 2000	FT 1000NF	S/W 100	S/W 49	S/W 4235
Product characteristics	Good mechanical properties for laminating. Long usage time. Adheres well on many various surfaces. S/W 2000 is two-component.			3M™ Fast Tack Water Based Adhesive 1000NF is a high performance waterbased one part adhesive formulated for fast bonding. This adhesive adheres to many types of flexible foam, latex foams, fabric, polyester, fibrefill, wood, plywood, particleboard and many types of plastic and metal surfaces.	Fast drying / tack phase achieved quickly. For porous materials.	Fast adherence. Possibility to apply on one surface only. For bonding light materials.	Lower adherence allows repositioning Working time several days, can be applied on one surface only.
Adherence	Slow	Medium	Fast	Fast, repositionable whilst wet	Fast	Fast	Medium
Base	Polychloropren	Polychloropren	Polychloropren	Acrylic	Polychloropren	Acrylic	Acrylic
Adhesive colour (after drying)	Neutral or blue	White	Neutral or blue	Neutral, Purple	Neutral or blue	Transparent	Transparent
Viscosity (cPs)	400 (liquid)	8000 (non-sagging)	400 (liquid)	400-1100	15-40 (very thin)	450-650 (liquid)	4000 (medium liquid)
Dry-substance content	50%	49%	50%	46-51%	47%	47%	55%
Usage time	4 h	4 h	2 h	1-10 min	20 min	Over 30 days	Over 30 days
Temperature resistance°C	-40 - +110	-40 - +110	-40 - +110	+149	0 - +110	-40 - +90	-40 - +60
Coverage (m ² /l) ¹	7-21	6-12	7-21	17.7	About 24	About 20	6-18
Application method	Sprayer, roll, brush	Sprayer, roll, brush, spatula	Sprayer	Brushed, rolled, spray	Sprayer	Sprayer, roll, brush	Sprayer, roll, brush
Application areas	Wood, cork, leather, felt, plastics (incl. PP), elastic and rigid foam, high-pressure laminate, steel ² , aluminium, painted metal, glass plastic, insulation (glass and stone wool), polystyrene.			Bond foamed materials, plastic laminates, wood, plywood and canvas	Flexible PU foam, latex, fabric, polyester, wood, plywood, chipboard, many plastics and metals.	Glass and stone wool, insulation foil, paper and other materials.	Glass wool, canvas, paper, cardboard, plastic (incl. PP, PE), rubber (incl. EPDM), wood, glass, steel ² , aluminium, painted metal and polystyrene.

¹ depends on application method and substrate porosity

² has to be protected from corrosion, cannot be applied on clean metal



3M™ Scotch-Weld™ 30 water based contact adhesive

Scotch-Weld 30 is polychloroprene based single-component multi-purpose contact adhesive. Suitable for gluing high-pressure laminate in furniture industry. Does not ignite and has a great temperature resistance.



Fast Tack Water Based Adhesive 1000NF

3M™ Fast Tack Water Based Adhesive 1000NF is a high performance water-based, one part adhesive formulated for fast bonding and long term heat resistant bonds. Adheres to many types of flexible foam, latex foams, fabric, polyester fiberfill, wood, plywood, particleboard and many plastic and metal surfaces.



3M™ Scotch-Weld™ 100 water based fast styrofoam adhesive

Scotch-Weld 100 is polychloroprene based styrofoam adhesive that is suitable for fast bonding of porous materials. The adhesive is compatible with various foam plastics, wood plates, many plastics and metals.



3M™ Scotch-Weld™ 49 water based sealing adhesive

Scotch-Weld 49 is single-component, fast tacking sealing adhesive. The bond will have a sufficient strength for treatment almost directly after connecting the components. Unlike contact adhesives, this adhesive does not have to be applied on both connected components.