

March, 2015

3M™ Industrial Adhesive 4475

Product Features

- Dries quickly to a firm bond.
- Excellent resistance to water, plasticizer migration, many detergent and soap solutions, oils and grease.
- A general purpose adhesive for bonding most vinyls, ceramics, glass, leather and cloth to a variety of substrates.



Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties

Property	Values	Notes	Test Condition
Color	Clear		
Solids Content by Weight	41 to 45 %		
Flash Point	20 °F	Closed Cup	
Solvent	methyl ethyl ketone (MEK)		
Coverage	487 sq ft/gal	1 mil dry film	
Viscosity	6,500-10,500 cP	Brookfield Viscometer RVF #5 sp. @ 20 rpm	80°F(27°C)

Typical Uncured Physical Properties

Property	Values
Base	Synthetic Resin
Net Weight	8.3 lb/gal

Typical Performance Characteristics

180° Peel Adhesion	Dwell/Cure Time	Test Condition
208 oz/in	1 day @ Room Temperature	Room Temperature
384 oz/in	3 days @ Room Temperature	Room Temperature
440 oz/in	5 days @ Room Temperature	Room Temperature
520 oz/in	7 days @ Room Temperature	Room Temperature
560 oz/in	2 wk @ Room Temperature	Room Temperature
704 oz/in	3 wk @ Room Temperature	Room Temperature
352 oz/in	After 3 wk @ Room Temperature	-30°F(-34°C)
272 oz/in	After 3 wk @ Room Temperature	150°F(66°C)
112 oz/in	After 3 wk @ Room Temperature	180°F(82°C)

Property: 180° Peel Adhesion
Substrate: Canvas to Steel

Handling/Application Information

Application Equipment

Note: Appropriate application equipment can enhance adhesive performance. The user is responsible for evaluating application equipment in light of the user's particular purpose and method of application.

1. Pumping

5-Gallon Pail Dispensing System

Pump – 9:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 41/4" diameter air motor minimum.

Pail cover to be used to reduce solvent loss.

55-Gallon Drum Dispensing System

Pump – 10:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 41/4" diameter air motor minimum, Bung mount type.

2. Accessories

Hose – 1000 psi minimum working pressure, nylon lined. Flow rate at 40°F, 20 ft. of 3/4-ID plus 10 ft. 1/2-ID and a flow gun equals 1 pound/minute at pump air pressure of 75 psi.

3. Chemical Resistance Requirements

Synthetic materials in contact with this product must be resistant to ketones and aromatic solvents. Compare, nylon or PTFE coatings are suggested for packings and gaskets.

Directions for Use

1. Surface Preparation: Best results are achieved on clean, dry surfaces. Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone (MEK).*

2. Application: Apply adhesive to one or both surfaces (best results are obtained by coating both surfaces) and bond immediately using firm pressure.

3. Drying Time: Allow to dry a minimum of 24 hours for maximum strength.

4. Cleanup: Remove unhardened or hardened material with cloth dampened with a solvent such as methyl ethyl ketone (MEK).*

*Note: When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

Storage and Shelf Life

Best storage temperature is 60-80°F (16-27°C). Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a "first in, first out" basis.

When stored at the recommended temperature in the original, unopened container, this product has a shelf life of 30 months from date of manufacture.

Trademarks

3M is a trademark of 3M Company.

References

Safety Data Sheet (SDS)

https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=4475

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Technical Information

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