

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION



3M™ Scotch-Weld™ Super 77™ Cylinder Spray Adhesive is an industrial grade, versatile bulk mist spray adhesive designed for lightweight applications. Formulated with high tack, high coverage, fast drying and long bonding range. The adhesive is packaged in convenient, portable, no maintenance aerosol cylinders and (5) gallon pails.

Available sizes

- 3M Super 77 Spray Adhesive - 5 Gallon Pails
- 3M Super 77 Spray Adhesive - 24oz Aerosol Cans

Estimated Coverage

- 5 Gallon Pail Coverage @ .5 gm/sq. ft. = 12,000 square feet
- 5 Gallon Pail Coverage @ 1 gm/sq. ft. = 6,000 square feet

PRODUCT FEATURES

- High solids, high coverage adhesive.
- Fast drying formulas with aggressive tack to help speed assembly.
- Uniform mist spray pattern, very low soak in.
- Good heat and moisture resistance to help protect bonds.
- Temporary and permanent lightweight bonds on substrates like drywall, papers, cardboard, concrete, fabrics, foams, wood, foil, metal, glass and most plastics.
- One or two surface bonding capabilities.

APPLICATION

Surface Preparation:

For best results, all surfaces to be bonded must be clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc.

Application Temperature:

For best results, the temperature of the adhesive and the surfaces being bonded should be between 60°-80°F (16°-27°C). Temperatures outside this range may affect the bonding range and sprayability.

Dry Time (minutes):	<1
Open Time (minutes):	10 seconds to 15 seconds (one surface bonding) 1-30 minutes (two surface bonding)

One Surface Bonding: Less demanding applications. Spray or roll the more non-porous surface and bond within Open Time (see Open Times in above table).

Two Surface Bonding: Permanent, more demanding applications. Spray or roll both surfaces and bond within Open Time (see Open Times in above table).

PHYSICAL PROPERTIES

Properties	Typical Values
Base	Synthetic Elastomer
Solids Content of Adhesive – propellant removed (by wt.)	36.5%
Solids Content – aerosol (by wt.)	27.4%
Color(s)	Clear, Red
Volatile Organic Compounds (VOC)	534 g/L
Hazardous Air Pollutants (HAPS) % wt. (calculated)	4-5%
MACT Compliant	Yes
Flammability	<i>Solvent: Yes</i> <i>Propellant: Yes</i>