

Technical data sheet



Product: 760

Manufacturer: 3M DEUTSCHLAND GMBH

Product group: KLEBSTOFF

Article group: DICHTMASSE

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3M™ HYBRID ADHESIVE SEALANT 760

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Hybrid Adhesive Sealant 760

Product Data Sheet

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Product Description

3M™ Hybrid Adhesive Sealant 760 is a one component sealant without isocyanates which forms permanent elastic bonds. It cures rapidly under the effect of atmospheric humidity to form a flexible and resistant joint with very good adhesion on most materials.

Is suitable for industrial and refrigerated trailers, truck bodies, shipbuilding, air conditioning and ventilation units, sandwich panels and many other industrial applications.

Can also be used for bonding and caulking different materials used in the building industry: concrete, wood, aluminium, most lacquered metals, polyester, glass, concrete, brick, stone, ceramic, etc.)

However, for difficult materials (especially lacquered or non-ferrous metals), it is necessary to make tests. Please contact your local 3M representative in that case.

Key Features

Features	Advantages
One component/moisture curing	<ul style="list-style-type: none">No MixingSimplifies production
Neutral product	<ul style="list-style-type: none">no isocyanates
Seals dissimilar materials	<ul style="list-style-type: none">Gives design flexibility
Adheres to a wide variety of materials	<ul style="list-style-type: none">Multiple uses and design flexibility
Permanently elastic	<ul style="list-style-type: none">Provides long lasting bonds
Fast curing	<ul style="list-style-type: none">Speeds production
Paint-able	<ul style="list-style-type: none">yes

Technical Data

	3M Hybrid Sealant 760
Skin formation time (min) (ISO 291, 23°C, 50% RH)	20min ± 10min
Cure time, mm/24h (ISO 291, 23°C, 50% RH)	3 mm / 24 h
Shore A Hardness (ISO 868-3 seconds)	Approx. 55
Density (g/ml) (DIN EN ISO 2811-2)	White and grey : 1,62 ± 0,05 Black : 1,57 ± 0,05
Elongation at Break (ISO 37)	>300%
Modulus at 100% (ISO 37)	> 1 MPa
Modulus at break (ISO 37)	> 1.8 MPa
Tensile Strength at 100% elongation (ISO 8339)	0.62 MPa

Tensile shear at break (ISO 8339)	1.15 MPa
Sagging (mm) (ISO 7390)	None
Volume loss (%) (ISO 10563)	4,4% (white) 7,1 % (black)
Colours	Grey, white, black
Application temperature	5°C to 35°C
Consistency	Thick paste
UV resistance	Excellent
Compatibility with paints	Water based : yes Solvent based : testing required

UV Properties

The product has good resistance to UV aging and will retain strength and flexibility over long-term exposure to UV light. The white product may show some yellowing with long-term exposure to UV light.

Direction for use

Surface Preparation:

Surfaces to be sealed or bonded must be clean, dry and be free from grease, mould release, oil, water/condensation and other contaminants that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength. Suitable solvents include 3M™ Citrus Based Adhesive Remover, 3M™ Scotch-Weld™ Solvent No. 2 or methyl ethyl ketone (MEK).

When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures. Refer to product label and MSDS for further precautions. Always pre-test solvent to ensure it is compatible with substrates.

Application:

Puncture seal in nozzle and knock out the thin seal at cartridge bottom before placing in a pneumatic caulking gun. (For flex packs cut off the small crimp at the end and then place in caulking gun barrel with the open end up). Assemble tip and retaining ring on gun, cut tip to desired size. Product should be used within 24 hours after seal is punctured and should be pressed firmly into the joint to ensure adequate contact of the sealant with the substrate.

Apply product when temperatures are between 5° C and 35° C. In cold weather, store the product at about 20 °C before use. Do not apply on frozen surfaces or wet surfaces.

Do not apply over silicones or in the presence of curing silicones.

Avoid contact with alcohol and solvents during curing.

Sealant can be tooled immediately after applying to give desired appearance, such as using a putty knife to smooth the joint with soapy water.

Avoid any contact with non-cured hybrid sealant during curing.

Cleanup:

While sealant is still soft cleaning can be done with the same solvents used for surface preparation. If sealant is already cured, removal is done mechanically with razor knife, piano wire, sanding or 3M™ Scotch-Brite™ Moulding Adhesive and Stripe Removal Disc. This disc is available from 3M Automotive Aftermarket Division.

Application Equipment Suggestions	Cartridge, Flex Pack, Bulk dispensing Please contact your local 3M representative
Shelf Life	9 months in the original, hermetically sealed packaging between 5°C and 25°
Precautionary Information	Refer to product label and Material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com
For Additional Information	To request additional product information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA
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