

# Technical data sheet



Product: 77 ZYLINDER

Manufacturer: 3M DEUTSCHLAND GMBH

Product group: KLEBSTOFF

Article group: LÖSEMITTEL

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## 3M™ SUPER 77 CYLINDER SPRAY

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## Technical Data Sheet

### 3M™ Super 77™ Multipurpose Cylinder Spray Adhesive



Product Details



Regulatory Info/SDS

#### Product Description

A high tack, high coverage and fast drying adhesive.

#### Product Features

- A high tack, high coverage fast drying, transparent adhesive for permanently attaching foils, carpeting, many lightweight foams, paper, cardboard, felt and cloth to painted or unpainted metals, wood, hardboard and other base materials.
- It provides high initial "grab" with sufficient open time to allow for positioning of materials.
- Low soak-in gives better looking and higher coverage bonds.
- Soft, non-dimpling glue lines

#### 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

Attribute Name	Test Method	Value
Density	ASTM D3574	6.5 lb/gal <sup>1</sup>

<sup>1</sup> Foam with adhesive

#### Typical Physical Properties

Attribute Name	Value
Color	Translucent
Solids Content by Weight	27 %
Base	Synthetic Elastomer
Spray Pattern	Mist
Coverage	124 ft <sup>2</sup> <sup>1</sup>
Bonding Range	15 sec - 15 min
Dry Time	15 to 60 s <sup>2</sup>
Flammable Solvent	Yes
Flammable Propellant	Yes
SCAQMD 1168 Compliant	No
VOC	548 g/L
Hazardous Air Pollutants (HAPS)	0.9 % by weight

<sup>1</sup> @ 2.5 gms /ft<sup>2</sup> per lb (sqft)

<sup>2</sup> Dry time will depend on ambient temperature, humidity and coverage applied.

## Typical Performance Characteristics

Attribute Name	Value
Shear Adhesion Failure Test - SAFT	150 °F <sup>1</sup>

<sup>1</sup> SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90°F and ramped 10°F every 10 min. until complete failure.

## Storage and Shelf Life

Store product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis. When stored at the recommended conditions in original, unopened container, this product has a shelf life of 21 months from date of manufacture.

## Available Sizes - Detailed

Container Size	3M Stock Number	UPC Number
24 Fl. Oz. (Net Wt. 16.75 oz.)	62-4977-4930-9	00-021200-21210-9
Large Cylinder – 29.3 lbs.	62-4979-8030-0	00-051115-25776-6
5 gallon pail – 32.5 lbs.	62-4458-8530-4	00-021200-43793-9
52 gallon drum – 338 lbs.	62-4458-9530-3	00-021200-43813-4

## 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.

## Automotive Disclaimer

**Select Automotive Applications:** This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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