

# Technical data sheet



Product: 3779

Manufacturer: 3M DEUTSCHLAND GMBH

Product group: KLEBSTOFF

Article group: SCHMELZKLEBSTOFF

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## 3M™ HOT MELT ADHESIVE 3779

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# Technical Data Sheet

3M™ Hot Melt Adhesive 3779



[Product Details](#)



[Regulatory Info/SDS](#)

## Product Description

3M™ Hot Melt Adhesives are heat applied, 100% solids adhesives. 3M™ Hot Melt 3779 is a thermoplastic adhesive to bond to wide variety of substrates such as wood, plastic, vinyl, metal and glass.

- High strength bonding with excellent environmental stability including very high heat resistance. Fast set time.

## Product Features

- 100% solids, no VOCs
- Easy to use
- Long open times allow for easy use on large assemblies and large surfaces
- Adhesive sets and obtains strength in seconds
- Creates high performance bonds
- Ideal for woodworking and general industrial applications.

## 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 | Temperature     | Substrate | Value  |
|----------------|-------------|-----------------|-----------|--|
| Color          |             |                 |           | Amber  |
| Density        |             |                 |           | 0.99 g/cm <sup>3</sup> (0.036 lb/in <sup>3</sup> ) |
| Open Time      |             |                 | OSB       | 25 s <sup>1</sup>                                  |
| Flash Point    | ASTM D92-72 |                 |           | 288 °C (550 °F) <sup>2</sup>                       |
| Delivery Time  |             |                 |           | 75 s <sup>3</sup>                                  |
| Viscosity      |             | 191 °C (375 °F) |           | 7,000 cP <sup>4</sup>                              |

<sup>1</sup> Open time is the max time between the application of the adhesive and joining the parts. Data based on 1/8in semicircular bead on non-metallic substrates at 75°F. Higher environmental temperatures and/or larger beads will lengthen open times.

<sup>2</sup> Cleveland Open Cup

<sup>3</sup> Extrusion time for one 1"x3" PG cartridge.

<sup>4</sup> Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

## Typical Performance Characteristics

| Attribute Name         | Test Method | Temperature   | Substrate                             | Value                  |
|------------------------|-------------|---------------|---------------------------------------|------------------------|
| 180° Peel Adhesion     |             | 22 °C (72 °F) | Flexible canvas bonded to Douglas Fir | 288 oz/in              |
| Overlap Shear Strength |             | 22 °C (72 °F) | Douglas Fir                           | 700 lb/in <sup>2</sup> |
| Ball & Ring Melt Point | ASTM E28-67 |               |                                       | 163 °C (325 °F)        |

| Attribute Name          | Value                                      |
|-------------------------|--|
| Application Temperature | 177 to 196 °C (350 to 385 °F) <sup>1</sup> |
| Temperature Resistance  | 149 °C (300 °F) <sup>2</sup>               |

<sup>1</sup> Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.

<sup>2</sup> Highest temperature that the adhesive will support a 2 psi dead load

## **Handling/Application Information**

### **Directions for Use**

1. Surface Preparation: Surfaces must be clean, dry and dust free. Wipe with a solvent such as isopropyl alcohol for plastic, metal and glass substrates to remove oil and dirt.\*

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

2. Application: 3M™ Hot Melt Adhesives are designed for application with a 3M™ Hot Melt Applicators. Read and follow the precautions and directions for use in the user's manual before operating the applicator. 3M™ Hot Melt Adhesives are applied at 350-385°F. Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead. Extruded bead sizes can be customized using 3M™ applicator tips.

3. Coverage: 3M™ Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.

4. Set up time: After the bond is made, 3M™ Hot Melt Adhesives immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates.

## **Storage and Shelf Life**

Store product below 120°F (49°C).

When stored at the recommended conditions, this product has a shelf life of 24 months from date of manufacture.

## **Available Sizes - Detailed**

5/8 in x8 in Q  
5/8 in x2 in TC  
1 in x3 in PG  
1/8 in Bulk

## **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.

## **Information**

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## **ISO Statement**

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

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