

Technical data sheet



Product: 1074

Manufacturer: 3M DEUTSCHLAND GMBH

Product group: KLEBSTOFF

Article group: SPRAY

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3M FASTBOND 1074 SPRAY ADHESIVE

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Technical Data Sheet

Preliminary 3M™ Fastbond™ Water-Based Foam and Fabric Adhesive 1074, Low VOC



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Product Description

3M™ Fastbond™ Water-Based Foam and Fabric Adhesive 1074, Low VOC is designed for use in foam and fabric applications.

Product Features

- Water-based
- Solventless air propelled system, eliminates the need for traditional propellants
- Less than 1 % VOC by weight
- High solid content

Technical Information Note

3M will continue to test samples from additional manufacturing lots and issue a new Technical Data Sheet if the results change. The technical information and data should be considered representative or typical only and should not be used for specification purposes. The following data is taken from tests conducted on a limited number of production runs.

Typical Uncured Physical Properties

Attribute Name	Temperature	Value
Base Viscosity	25 °C (77 °F)	100-700 mPa.s ¹
Base Density		1.0 g/mL (8.34 lb/gal)

¹ Brookfield Viscometer spindle #2 at 50 rpm

Typical Physical Properties

Attribute Name	Value
Color	Milky White (wet), Clear (dry)
Solids Content by Weight	45-50 %
pH	8.0-8.5
Dry Time	15 min ¹
Spray Pattern	mist
Base	Synthetic Elastomer
Bonding Range	15-30 min
Flammable Propellant	No
Coverage	4.0 m ² (43.7 ft ²) ²

¹ Dry time will depend on ambient temperature, humidity and coverage applied.

² @ 27 g/m² (2.5 g/ft²) dry

Handling/Application Information

Directions for Use

The actuators are not inserted during the manufacturing process to avoid accidental dispensing of the adhesive that may dry and clog the valve, ensuring that the customer does not experience issues when dispensing the adhesive. Depending on your usage criteria, you may only need one actuator per can. We are providing an extra actuator for customers who may not use the adhesive frequently.

To use the can do the following:

1. Remove the cap, note the actuators under the cap.
2. Peel the seal off the top of the can. Do not puncture through the seal, pieces of the seal could clog the valve.
3. Pointing the actuator away from the user, or other people in the area, gently insert the stem into the valve. Gently rotate the actuator during insertion, if needed.
4. Begin spraying.

Work Stoppage

For short work stoppages, covering the spray tip is unnecessary. Adhesive may need to be wiped away from the orifice on the actuator. If the stoppage is more than 10 minutes, cover the spray tip with tape and replace the cap. If unused for an extended period, adhesive may dry, requiring the installation of the second actuator to resume spraying.

Application Guidelines

Surface Preparation: Surfaces must be clean, dry and dust free. Remove all dirt, dust, oil, grease, wax, loose paint, etc. to ensure proper adhesion.

Application: Apply a uniform coat of adhesive to the surfaces to be bonded. Very porous material may require more than one coat. (Allow adhesive to dry completely between coats). Bonds to porous substrates can generally be made without significant drying, typically less than 15 minutes depending on environmental factors and adhesive coverage. Pressure must be applied to activate the adhesive. Non-porous substrates need to dry until adhesive does not transfer when touched with a gloved hand.

Temperature: Maintain temperature between 16-27 °C(60-80 °F) for adhesive and substrates to be bonded. Lower or higher temperatures may affect the spray pattern and performance of the product.

Coverage: Coverage is dependent upon porosity of the substrate and the method by which the adhesive is applied. apply the adhesive in a uniform pattern at a coverage rate between 21-32 g/m²(2.0 - 3.0 dry gms./sqft).

Drying: Allow adhesive to dry until the surface becomes tacky, and does not transfer to a gloved knuckle when touched. The substrates may then be bonded using hand pressure. Bonded parts may be handled immediately.

Cleanup: Wet adhesive may be removed using water or soapy water. For dry adhesive removal, use 3M™ Citrus Base Adhesive Remover.

Disposal: Empty the aerosol completely. Remove the actuator and dispose in accordance with local regulations.

Lower or higher temperatures may affect the spray pattern and performance of the product.

Storage and Shelf Life

Store under normal conditions of 16° to 27 °C (60° to 80 °F) and 40 to 60 % relative humidity in the original, unopened packaging, out of direct sunlight.
For best performance, use this product within 12 months from date of manufacture.

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.

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.

3M™ Industrial Adhesives and Tapes Division
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