



# Scotch-Weld™ Super 77™ Cylinder Spray Adhesive

## Product Data Sheet

Date: July 2013  
Supersedes: New

### Product Description

A high tack, high coverage and fast drying adhesive.

### Key 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

### Typical Properties

Product	Super 77™ Cylinder Spray Adhesive
Base:	Synthetic Elastomer
Solids Content - (by wt.)	27%
Colour	Blue, Red, Translucent
Viscosity (cps)	N/A
Density	0.78 g/cm <sup>3</sup>
Coverage (11gr/m <sup>2</sup> ) (dry wt.)	25 m <sup>2</sup> /kg (wet wt)
Spray pattern	Mist
Dry time	15 s – 1 min
Bonding range	15 s – 15 min
Shear Adhesion Failure Test - SAFT <sup>(1)</sup> :	74°C
Flammable Solvent:	Yes
Flammable Propellant:	Yes

<sup>(1)</sup>SAFT Shear Adhesion Failure Test with birch plywood, 25mm overlap, 100 grams used, temperature start at 30°C and ramped 10°C every 10 min. until complete failure.

### General Use Instructions

**Do not use this product if you have not read or do not understand the Special Instructions (User's Guide)**

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**Cold Weather Warning**

Please follow the directions for use described in the Special Instructions (User's Guide)

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**Trouble Shooting –  
Applicator / Hose Clog**

Please follow the directions for use described in the Special Instructions (User's Guide)

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**Storage**

Store product at 16°C – 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.

The units can be stored in the Shut Down modes referenced above or if the storage is of a longer term nature or transport, they could be shut down and the hose taken off.

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**Shelf Life**

When stored at the recommended conditions in original, unopened container, this product has a shelf life of 15 months from date of manufacture.

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**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](http://www.3M.com)

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**For Additional Information**

Before you set-up and use the equipment please read the MSDS and the Cylinder Spray Adhesive Special Instructions (User's Guide)

To request additional product information or to arrange for sales assistance, call.....

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**Important Notice**

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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**Insert Company Information Before Issue**