

3M Industrial Adhesives and Tapes

3M™ Cylinder Spray Adhesives

Efficient, Portable and Easy to Use

3M™ Cylinder Spray Adhesives have benefits over more traditional spray methods. Minimal startup costs, reduced downtime, simple hose and applicator setup make cylinders an obvious choice.

Whether your priorities are improving speed of application, making spraying easier or reducing capital equipment maintenance and other costs, 3M Cylinder Spray Adhesives get you there.

Advantages and benefits:

- Very efficient speed of application and reduction of overspray
- Convenient, portable and easy to use delivery system
- Maintenance free and very low equipment costs

Other benefits include:

- More efficient spraying over large surface areas or multiple parts means virtually all adhesive is used and very little is wasted
- Easy to learn, use and train new employees to spray
- Portable for easy transition and setup for multiple stations or field work

Key features include:

- High coverage
- Various spray patterns
- Non-flammable adhesives
- Greenguard Certified
- Range of open time (worklife)



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Spray patterns from 1–18+” are achievable using 3M™ Cylinder Spray Adhesives and various spray tips.

Where to Start

Product Selection

The lead products for 3M™ Cylinder Adhesives are:

- 3M™ Postforming 94 CA Cylinder Spray Adhesive
- 3M™ Hi-Strength 94 ET Cylinder Spray Adhesive
- 3M™ Holdfast 70 Cylinder Spray Adhesive

The majority of applications can be done with these three cylinder products.



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3M™ Postforming 94 CA Cylinder Spray Adhesive is a low telegraphing that dries quickly to reach postformable strength in 1–5 minutes. A 1–15 minute open time provides flexibility in assembly speed. **3M™ Hi-Strength 94 ET Cylinder Spray Adhesive** offers all the benefits of 3M™ Postforming 94 CA Cylinder Spray Adhesive, but delivers a higher tack and increased bonding range.



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For fast, easy foam board installation, above and below grade, simply spray and stick with **3M™ HoldFast 70 Cylinder Spray Adhesive**. Bonds foam to concrete, waterproofing, OSB and more without damaging the foam.

Save Yourself the Hassle of Inefficient Spraying

Most common applications:

- High pressure laminate
- Foam/paper core steel door
- Upholstery
- Metal lamination
- Insulation bonding

Where to find these applications:

- Cabinet shops
- Elevator interiors
- Countertop shops
- Exhibit manufacturing
- Fixture/display manufacturing
- Office furniture
- Theatre/production sets
- Acoustic panel/partition

Key Questions

Asking the right questions related to the application will help you arrive at an adhesive selection quickly and painlessly.

Use A.S.P.E.C.

- What is the **APPLICATION** you are currently using the adhesive for?
- What **SUBSTRATES** does the adhesive need to bond too?
- Are there special **PROCESS** details the adhesive needs to accommodate? Such as high temperatures or VOC regulations?

- What kinds of **END USE** stress or environment will the bond be subject to? (e.g., boat carpet and saltwater conditions or exterior applications).
- How do you determine the **VALUE** beyond simply the **COST** of a product? (e.g., Improved coverage, reduced flammability or speed of application).

Adhesives and Sealants

3M™ Cylinder Spray Adhesive Quick Reference Guide

Product	Application	Solids (%)	Solids - Bulk (%)	VOCs (g/L)	Open Time (min)	Spray Pattern	Spray Applicator	Recommended Tips
MULTI-PURPOSE								
60 CA	General Purpose	43	42	>80	2-60	Web	Applicator	9501, 6501
70	Construction, Marine, RV, Polystyrene	21	41	544	1-60	Web	Applicator	QSS tip
77	Multi-Purpose	27	36	534	1-30	Mist	Applicator	250050, 650050
HEAVY DUTY								
90	Laminating	13	23	571	1-15	Web	Applicator	9501, 6501, 250050
92	Laminating	23	34	654	1-20	Web	Applicator	9501, 6501, 250050
94 CA	Laminating	28	28	79	1-15	Pebble	Applicator H	4001, 6501
94 ET	Laminating	28	34	<80	1-60	Pebble	Applicator H	9501, 6501, 4001
98NF	Laminating	20	25	254	1-60	Web	Applicator	9501, 6501, 4001
FOAM & FABRIC								
74	Foam Bonding	22	36	563	1-15	Web	Applicator	9501, 6501
74NF	Foam Bonding	22	28	248	1-60	Web	Applicator	9501, 6501
SPECIALTY								
78 ET	Polystyrene	17	31	570	1-60	Web	Applicator	9501, 6501



3M™ Cylinder Spray Adhesives do not atomize spray patterns with added airline. This means you get consistent even spray patterns, potentially saving rework and cleanup.

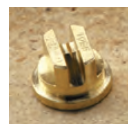


Consistent spray patterns and portable cylinders mean you can realize big improvements in efficiency and save time and labor costs.

3M™ Cylinder Spray Adhesive Equipment and Accessories



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9501



6501



4001



QSS



T-Fitting



Hose Swivel

Spray Tip	Angle	Spray Pattern Width
9501	95°	Wide
6501	65°	Medium
4001	40°	Narrow
QSS*	—	Very Wide
250050	25°	Very Narrow
650050	65°	Medium

*For 3M™ HoldFast 70 Spray Adhesive

Note: The technical information and data on these pages should be considered representative or typical only and should not be used for specification purposes.