



## Material Safety Data Sheet

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### SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

**PRODUCT NAME:** 3M(TM) Scotch-Weld(TM) Hot Melt Adhesive 3764-AE / 3764-PG / 3764-TC / 3764-TC-Q / 3764-B

**MANUFACTURER:** 3M

**DIVISION:** Industrial Adhesives and Tapes Division

**ADDRESS:** 3M Center, St. Paul, MN 55144-1000

**EMERGENCY PHONE: 1-800-364-3577 or (651) 737-6501 (24 hours)**

**Issue Date:** 08/09/11

**Supercedes Date:** 08/09/11

**Document Group:** 11-0058-5

#### Product Use:

Intended Use: hot-melt adhesive  
Specific Use: hot-melt adhesive

### SECTION 2: INGREDIENTS

<u>Ingredient</u>	<u>C.A.S. No.</u>	<u>% by Wt</u>
ETHYLENE-VINYL ACETATE POLYMER	24937-78-8	50 - 65
HYDROCARBON RESIN	Mixture	25 - 35
POLYETHYLENE POLYMER	9006-26-2	5 - 10
POLYOLEFIN WAX	Mixture	1 - 5
ANTIOXIDANT	6683-19-8	0.5 - 1.5

### SECTION 3: HAZARDS IDENTIFICATION

#### 3.1 EMERGENCY OVERVIEW

**Specific Physical Form:** Waxy Solid

**Odor, Color, Grade:** clear white, solid adhesive in rods or pellets, odorless. (Molten state: resinous odor.)

**General Physical Form:** Solid

**Immediate health, physical, and environmental hazards:** May cause thermal burns.

## 3.2 POTENTIAL HEALTH EFFECTS

### **Eye Contact:**

Vapors from heated material may cause eye irritation. Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

Thermal Burns: Signs/symptoms may include severe pain, redness and swelling, and tissue destruction.

### **Skin Contact:**

Thermal Burns: Signs/symptoms may include intense pain, redness and swelling, and tissue destruction.

### **Inhalation:**

Vapors from heated material may cause irritation of the respiratory system. Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

### **Ingestion:**

Physical Blockage: Signs/symptoms may include cramping, abdominal pain, and constipation.

## SECTION 4: FIRST AID MEASURES

### 4.1 FIRST AID PROCEDURES

The following first aid recommendations are based on an assumption that appropriate personal and industrial hygiene practices are followed.

**Eye Contact:** Immediately flush eyes with large amounts of water for at least 15 minutes. DO NOT ATTEMPT TO REMOVE MOLTEN MATERIAL. Get immediate medical attention.

**Skin Contact:** Immediately flush skin with large amounts of cold water for at least 15 minutes. DO NOT ATTEMPT TO REMOVE MOLTEN MATERIAL. Cover affected area with a clean dressing. Get immediate medical attention.

**Inhalation:** If signs/symptoms develop, remove person to fresh air. If signs/symptoms persist, get medical attention.

**If Swallowed:** Do not induce vomiting unless instructed to do so by medical personnel. Give victim two glasses of water. Never give anything by mouth to an unconscious person. Get medical attention.

## SECTION 5: FIRE FIGHTING MEASURES

### 5.1 FLAMMABLE PROPERTIES

**Autoignition temperature**

*No Data Available*

**Flash Point**

514 °F [Test Method: Cleveland Open Cup] [Details: CONDITIONS: ASTM D-92-72]

**Flammable Limits(LEL)**

*Not Applicable*

**Flammable Limits(UEL)**

*Not Applicable*

### 5.2 EXTINGUISHING MEDIA

Ordinary combustible material. Use fire extinguishers with class A extinguishing agents (e.g., water, foam).

### 5.3 PROTECTION OF FIRE FIGHTERS

**Special Fire Fighting Procedures:** Wear full protective equipment (Bunker Gear) and a self-contained breathing apparatus (SCBA).

**Unusual Fire and Explosion Hazards:** Not applicable.

**Note:** See STABILITY AND REACTIVITY (SECTION 10) for hazardous combustion and thermal decomposition information.

## SECTION 6: ACCIDENTAL RELEASE MEASURES

### 6.1. Personal precautions, protective equipment and emergency procedures

Evacuate unprotected and untrained personnel from hazard area. The spill should be cleaned up by qualified personnel.

### 6.2. Environmental precautions

Reclaim undamaged product.

#### Clean-up methods

Collect as much of the spilled material as possible.

**In the event of a release of this material, the user should determine if the release qualifies as reportable according to local, state, and federal regulations.**

## SECTION 7: HANDLING AND STORAGE

### 7.1 HANDLING

Avoid skin contact with hot material. For industrial or professional use only. Use general dilution ventilation and/or local exhaust ventilation to control airborne exposures to below Occupational Exposure Limits. If ventilation is not adequate, use respiratory protection equipment.

### 7.2 STORAGE

Store away from heat.

## SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

### 8.1 ENGINEERING CONTROLS

Not applicable. Use in a well-ventilated area.

### 8.2 PERSONAL PROTECTIVE EQUIPMENT (PPE)

#### 8.2.1 Eye/Face Protection

Avoid eye contact.

The following eye protection(s) are recommended: Safety Glasses with side shields  
Indirect Vented Goggles

#### 8.2.2 Skin Protection

Avoid skin contact with hot material. Wear heat insulating gloves when handling this material to prevent thermal burns.

#### 8.2.3 Respiratory Protection

Under normal use conditions, airborne exposures are not expected to be significant enough to require respiratory protection.

#### 8.2.4 Prevention of Swallowing

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Not an expected route of exposure.

### **8.3 EXPOSURE GUIDELINES**

<b>Ingredient</b>	<b>Authority</b>	<b>Type</b>	<b>Limit</b>	<b>Additional Information</b>
ANTIOXIDANT	CMRG	TWA	10 mg/m <sup>3</sup>	
POLYOLEFIN WAX	ACGIH	TWA, as fume	2 mg/m <sup>3</sup>	

#### **SOURCE OF EXPOSURE LIMIT DATA:**

ACGIH: American Conference of Governmental Industrial Hygienists

CMRG: Chemical Manufacturer Recommended Guideline

OSHA: Occupational Safety and Health Administration

AIHA: American Industrial Hygiene Association Workplace Environmental Exposure Level (WEEL)

## **SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES**

<b>Specific Physical Form:</b>	Waxy Solid
<b>Odor, Color, Grade:</b>	clear white, solid adhesive in rods or pellets, odorless. (Molten state: resinous odor.)
<b>General Physical Form:</b>	Solid
<b>Autoignition temperature</b>	<i>No Data Available</i>
<b>Flash Point</b>	514 °F [Test Method: Cleveland Open Cup] [Details: CONDITIONS: ASTM D-92-72]
<b>Flammable Limits(LEL)</b>	<i>Not Applicable</i>
<b>Flammable Limits(UEL)</b>	<i>Not Applicable</i>
<b>Boiling Point</b>	<i>Not Applicable</i>
<b>Density</b>	0.95 g/cm <sup>3</sup>
<b>Vapor Density</b>	<i>Not Applicable</i>
<b>Vapor Pressure</b>	<i>Not Applicable</i>
<b>Specific Gravity</b>	0.95 [Ref Std: WATER=1]
<b>pH</b>	<i>Not Applicable</i>
<b>Melting point</b>	<i>No Data Available</i>
<b>Solubility in Water</b>	Nil
<b>Evaporation rate</b>	<i>Not Applicable</i>
<b>Hazardous Air Pollutants</b>	0 % weight [Test Method: Calculated]
<b>Volatile Organic Compounds</b>	0 g/l [Details: EU VOC content]
<b>Kow - Oct/Water partition coef</b>	<i>No Data Available</i>
<b>Percent volatile</b>	0 % weight
<b>VOC Less H<sub>2</sub>O &amp; Exempt Solvents</b>	0 % [Test Method: calculated per CARB title 2]
<b>VOC Less H<sub>2</sub>O &amp; Exempt Solvents</b>	0 g/l [Test Method: calculated SCAQMD rule 443.1]
<b>VOC Less H<sub>2</sub>O &amp; Exempt Solvents</b>	0 lb/gal [Test Method: calculated SCAQMD rule 443.1]
<b>Viscosity</b>	<i>Not Applicable</i>
<b>Solids Content</b>	100 %

## **SECTION 10: STABILITY AND REACTIVITY**

**Stability:** Stable.

**Materials and Conditions to Avoid:**

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**10.1 Conditions to avoid**

None known

**10.2 Materials to avoid**

None known

**Hazardous Polymerization:** Hazardous polymerization will not occur.

**Hazardous Decomposition or By-Products**

<u>Substance</u>	<u>Condition</u>
Carbon monoxide	During Combustion
Carbon dioxide	During Combustion

**SECTION 11: TOXICOLOGICAL INFORMATION**

Please contact the address listed on the first page of the MSDS for Toxicological Information on this material and/or its components.

**SECTION 12: ECOLOGICAL INFORMATION**

**ECOTOXICOLOGICAL INFORMATION**

Not determined.

**CHEMICAL FATE INFORMATION**

Not determined.

**SECTION 13: DISPOSAL CONSIDERATIONS**

**Waste Disposal Method:** Reclaim if feasible. If product can't be reclaimed, dispose of waste product in a sanitary landfill. Alternatively, incinerate the waste product in an industrial, commercial, or municipal incinerator. As a disposal alternative, incinerate in an industrial or commercial facility.

Since regulations vary, consult applicable regulations or authorities before disposal.

**SECTION 14: TRANSPORT INFORMATION**

**ID Number(s):**

62-3764-7230-4, 62-3764-7232-0, 62-3764-7233-8, 62-3764-7234-6, 62-3764-9130-4, 62-3764-9132-0, 62-3764-9135-3, 62-3764-9330-0, 62-3764-9335-9, 62-3764-9337-5, 62-3764-9339-1, 62-3764-9395-3, 62-3764-9399-5, 62-3764-9531-3, 62-3764-9537-0, 62-3764-9830-9

Not regulated per U.S. DOT, IATA or IMO.

***These transportation classifications are provided as a customer service. As the shipper YOU remain responsible for complying with all applicable laws and regulations, including proper transportation classification and packaging. 3M transportation classifications are based on product formulation, packaging, 3M policies and 3M understanding of applicable current regulations. 3M does not guarantee the accuracy of this classification information. This information applies only to transportation classification and not the packaging, labeling, or marking requirements. The original 3M package is certified for U.S. ground shipment only. If you are shipping by air or ocean, the package may not meet applicable regulatory requirements.***

## SECTION 15: REGULATORY INFORMATION

### US FEDERAL REGULATIONS

Contact 3M for more information.

#### 311/312 Hazard Categories:

Fire Hazard - No Pressure Hazard - No Reactivity Hazard - No Immediate Hazard - Yes Delayed Hazard - No

### STATE REGULATIONS

Contact 3M for more information.

### CHEMICAL INVENTORIES

The components of this product are in compliance with the chemical notification requirements of TSCA.

All applicable chemical ingredients in this material are listed on the European Inventory of Existing Chemical Substances (EINECS), or are exempt polymers whose monomers are listed on EINECS. Contact 3M for more information.

### INTERNATIONAL REGULATIONS

Contact 3M for more information.

**This MSDS has been prepared to meet the U.S. OSHA Hazard Communication Standard, 29 CFR 1910.1200.**

## SECTION 16: OTHER INFORMATION

### NFPA Hazard Classification

**Health: 1 Flammability: 1 Reactivity: 0 Special Hazards: None**

National Fire Protection Association (NFPA) hazard ratings are designed for use by emergency response personnel to address the hazards that are presented by short-term, acute exposure to a material under conditions of fire, spill, or similar emergencies. Hazard ratings are primarily based on the inherent physical and toxic properties of the material but also include the toxic properties of combustion or decomposition products that are known to be generated in significant quantities.

#### Revision Changes:

Section 14: ID Number(s) Template 1 was modified.

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# 3M™ Scotch-Weld™ Hot Melt Bonding Systems



## Assembly & packaging Reference guide

Speed and versatility  
for applications success

**3M**

## Applications Success with 3M™ Scotch-Weld™ Hot Melt Adhesives

Do 3M™ Scotch-Weld™ Hot Melt Adhesives offer the best options for success with your assembly and/or closure application? Answers to the following questions can help you decide.

### Would you like to improve your production speed and ease?

3M™ Scotch-Weld™ Hot Melt Adhesives liquefy when heated and quickly fill gaps and wet the bonding surface. Applied to only one surface, they cool, harden, and reach bond strength in seconds. You can move assemblies immediately and eliminate clamps, fixturing, and drying time and energy. Each adhesive is engineered for efficient application with an easy-to-use 3M portable applicator. Minimal operator training.

### Would you like to improve appearance?

Unlike mechanical fasteners and sealing tapes, hot melt adhesive is virtually invisible between the mating surfaces.

### What surfaces do you want to combine?

As you can see on pages 4 and 5, you can combine a wide variety of materials ranging from wood to corrugated cardboard, and even heat-sensitive foam.

### How much strength do you need?

Select from a wide range of non-structural shear and peel strengths as shown on page 7. Structural strength has been defined as a minimum of 1,000 psi in overlap shear to permanently bond load-bearing components. Hot melt non-structural applications range from case sealing to bonding wood stiffeners to drawer bottoms, and securing components on a PC board.

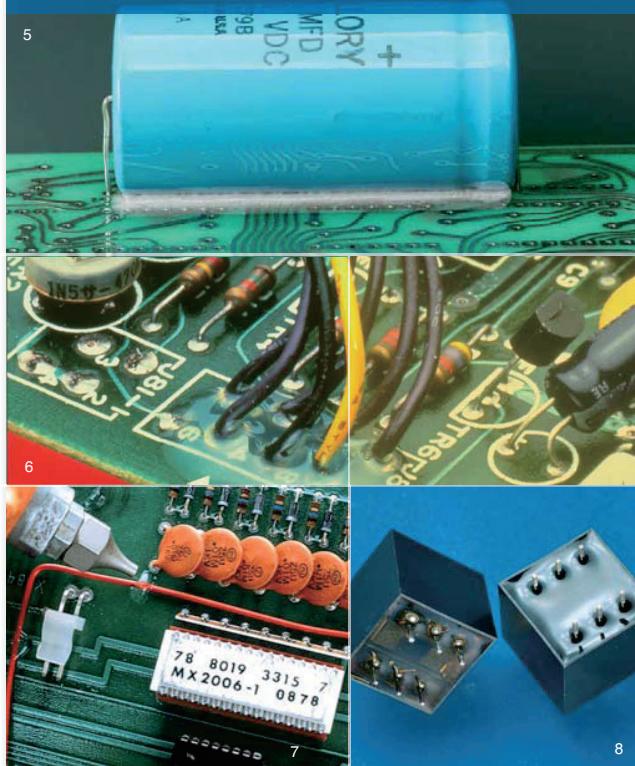
### What is the temperature in the end use environment?

Hot melts are 100% solids thermoplastic resins that can re-melt after bonding if exposed to high enough temperature. As you can see on page 7, there are many options for selecting melt point and heat resistance for your specific application.

### Do you need to reposition parts or delay assembly after adhesive application?

Open time or bonding range is the maximum time between applying adhesive and joining the surfaces. The more quickly you join surfaces, the better the wetting action and bond. With 3M™ Scotch-Weld™ Hot Melt Adhesives you have wide latitude in bonding range selection as shown on page 7.

## Application Success:



## Electronics and Electrical

- Easily secure wires to resist strain and breakage
- Rigidize components on printed circuit boards to add stability during assembly, shipping and end use
- Quick setting for potting even at great depth
- Terminate coils
- Cable strain relief
- Bundle wires for convenient handling

**Go to adhesives** 3748VO: Light yellow, non-corrosive to copper, self extinguishing

3779: Amber, high heat resistance, high strength

**Alternatives** 3748: Off-white, non-corrosive to copper

3764: Clear, bonds HSE/LSE plastics

3797: Off-white, good for potting

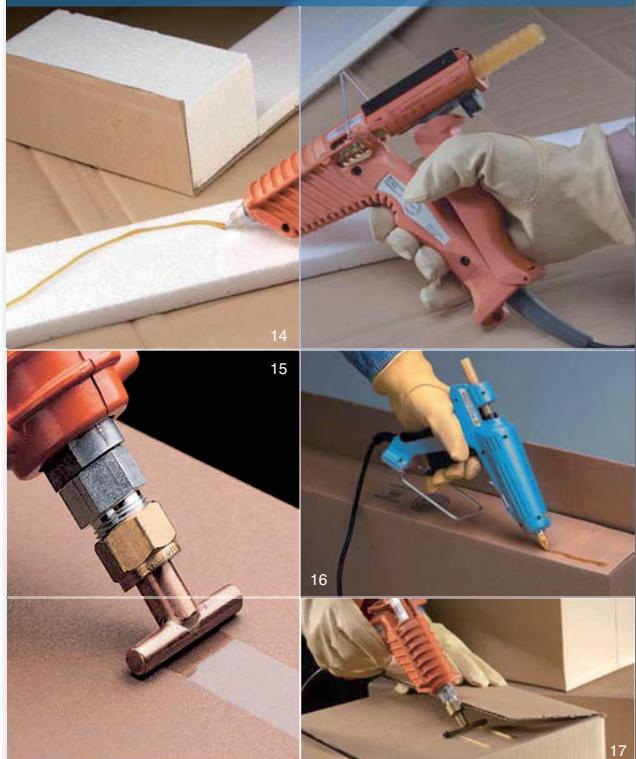
## Application Success:



## Point-of-Purchase, Displays, Trade Exhibits

- Bond foam spacers into 3-dimensional corrugated cardboard POP display
- Attach samples of wood flooring, laminates, foams, fabric, or other materials and small products to display board
- Attach decorations to baskets
- Assemble dried floral arrangements
- Bond polystyrene foam and other materials used in counter top displays, jewelry cases, and exhibitor booths

## Application Success:



## Manual and Corrugated Carton Sealing

- Bond and seal any size and configuration of corrugated carton quickly and invisibly including RSCs, FOLs, and 5-panel folded
- Securely bond lightly waxed surfaces that may be difficult for tape to seal
- Attach inserts including heat-sensitive foam
- Self-contained portable applicator saves the cost of bulk equipment for recouperage, manual random size case sealing, and many contract packaging situations

### Go to adhesives

3762LM: Light amber, fast-setting, low melt for heat sensitive surfaces  
3792LM: Clear, multi-purpose low melt for heat sensitive surfaces

### Alternatives

3748: Off-white, bonds polyolefins  
3755LM: Clear, delayed tack, applied as ribbon for paper, corrugated  
3764: Clear, bonds HSE/LSE plastics

### Go to adhesives

3762: Economical, tan, fast-setting with "hot tack"  
3762LM: Light amber, low melt version of 3762

### Alternatives

3738: Tan with high delivery rate, longer open time than 3762  
3750: Tan, low viscosity for high flow  
3764: Clear, stays flexible at low temp

## Application Success:



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## Furniture and Woodworking

- Wood to wood assembly of non-structural components in home and office furniture and cabinetry
- “Third-hand” holding components while structural wood adhesive cures
- Bond fabric to wood for welting and gimping
- Secure drawer bottoms, guides, and stiffeners
- Attach upholstery to wood and plastic
- Assemble decorative crown moldings

### Go to adhesives

3792: Clear, multi-purpose for wood, fabric, and upholstery  
3792LM: Low melt version of 3792 for heat sensitive surfaces

### Alternatives

3738: Tan, high delivery rate  
3747: Tan, bonds variety of wood, plastics, and lightweight metal  
3789: Brown, impact resistant

## Application Success:



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## Product Assembly

- Bond metal or plastic nameplates to trophies
- Assemble or repair foundry sand cores
- Attach removable credit cards or samples to mailers
- Quick easy assembly of many materials in luggage and carrying cases
- Assemble many materials used in novelties, toys, games, and costumes
- Attach speaker fabric or protective metal grille

### Go to adhesives

3764: Clear, bonds HSE/LSE plastics, flexible at low temp  
3792LM: Clear, multi-purpose low melt for heat sensitive surfaces

### Alternatives

3748: Off-white, resists thermal shock, bonds polyolefins  
3796: Tan, hi-performance on thin metal  
3798LM: Clear removable “gummy glue”

# Substrate Combinations for Applications Success

Substrate	Wood		Thin Metal		Glass or ceramic		Vinyl		Leather		Polyolefin*	
Wood	3747 3789 3738	3776LM 3762LM 3792LM 3750LM	3747 3796	3776LM	3747 3764 3796	3792LM	3789 3779 3796	N/R	3789 3779 3796	N/R	3731 3748 3764 6111 <sup>1</sup>	3792LM
Thin Metal			3747 3796	3776LM	3747 3796	3776LM	3796	N/R	3796	N/R	3796	N/R
Glass or ceramic					3747 3764 3796	3792LM	3796	N/R	3796	N/R	3764 3748	3792LM
Vinyl							3789 3779 3796	N/R	3789 3779 3796	N/R	3796	N/R
Leather									3789 3779 3796	N/R	3796	N/R
Polyolefin*											3731 3748 3764 6111 <sup>1</sup>	3792LM
Plastic**												
Paper												
Uncoated cardboard/ chipboard												
Coated cardboard/ chipboard												
Fabric												
Rigid foam***												
Flexible foam												

■ Low melt adhesives

\* E.g., polyethylene

\*\* E.g., ABS, PVC, acrylic

\*\*\* Beadboard/styrene

<sup>1</sup> 6111 is a family of products that includes 6111, 6111HT, and 6116.

<sup>2</sup> Removable

<sup>3</sup> Must be sprayed on rigid foam to prevent cavitation.

**Note:** This technical information and data should be considered representative or typical only and should not be used for specification purposes.

# Product Information

	Product (Color)	FDA Listed <sup>1</sup>	UL 94 Listing	Features Application Ideas
Low Melt Technology: Applied 250°-270°F (127°-132°C)	3750LM Tan	N	N/A	<ul style="list-style-type: none"> <li>Excellent "hot tack", fast setting for corrugated, beadboard, repack, recoup</li> <li><b>Economical, general purpose</b> • Use with AE II LT applicator only</li> </ul>
	3755LM Clear	Y	N/A	<ul style="list-style-type: none"> <li>"Delayed-tack" applied in <b>thin-glue-line</b> ribbon for paper, corrugated, chipboard, displays, exhibits</li> <li>Use with low melt applicator only</li> </ul>
	3762LM* Lt. Amber	Y	N/A	<ul style="list-style-type: none"> <li>Excellent "hot tack", fast setting for corrugated, beadboard, recouperage, repacking chipboard, wood</li> <li><b>Economical, general purpose</b> • Use with low melt applicator only</li> </ul>
	3776LM Tan	N/A	N/A	<ul style="list-style-type: none"> <li>Bonds variety of <b>plastics, woods and light-gauge metals</b></li> <li>Use with low melt applicator only</li> </ul>
	3792LM* Clear	Y	V2	<ul style="list-style-type: none"> <li><b>Clear, multi-purpose</b> for wood, coated paper, <b>polyolefins</b> and other <b>heat-sensitive materials</b></li> <li>P.O.P. displays • Use with low melt applicator only</li> </ul>
	3798LM* Lt. yellow	Y	N/A	<ul style="list-style-type: none"> <li><b>Removable "gummy glue"</b> for many substrates</li> <li>Removes easily without residual tack • Use with low melt applicator only</li> </ul>
Hot Melt Technology: Applied 350°-385°F (177°-190°C)	3731* Tan	N	N/A	<ul style="list-style-type: none"> <li><b>High heat resistance</b></li> <li>Bonds <b>plastics</b> including <b>polyethylene, polypropylene</b></li> </ul>
	3738* Tan	Y	V2	<ul style="list-style-type: none"> <li><b>High delivery rate and long bonding range</b> • General purpose for foundry sand cores, wood bonding, corrugated, selected plastics and chipboard</li> </ul>
	3747 Tan	Y	N/A	<ul style="list-style-type: none"> <li><b>General purpose</b> for wide variety of plastics, wood and <b>lightweight metals</b></li> </ul>
	3748* Off-white	Y	V2	<ul style="list-style-type: none"> <li>Good thermal shock resistance • <b>Non-corrosive to copper</b> for many <b>electronic applications</b></li> <li>Bonds polyolefins</li> </ul>
	3748 VO Light Yellow	N	VO	<ul style="list-style-type: none"> <li><b>Self-extinguishing</b> version of 3748</li> <li>Meets UL 1410 requirements</li> </ul>
	3750 Tan	N	N/A	<ul style="list-style-type: none"> <li><b>Low viscosity</b> for high flow rate, increased production</li> <li><b>Good hot tack</b>, quick grab for <b>packaging</b> and <b>woodworking</b></li> </ul>
	3750 Clear	N	N	<ul style="list-style-type: none"> <li><b>Low viscosity</b> for high flow rate, increased production</li> <li><b>Good hot tack</b>, quick grab for <b>packaging</b> and <b>woodworking</b></li> </ul>
	3762 Tan	Y	V2	<ul style="list-style-type: none"> <li>Excellent "hot tack", fast setting for corrugated, beadboard, recouperage, repacking chipboard, wood</li> <li><b>Economical, general purpose</b></li> </ul>
	3764* Clear	Y	V2	<ul style="list-style-type: none"> <li>Bonds variety of plastics including <b>polycarbonate, polyethylene, and polypropylene</b></li> <li>Flexible at low temperatures</li> </ul>
	3779* Amber	Y	VO	<ul style="list-style-type: none"> <li><b>High heat resistance</b> • High strength</li> <li>Good fuel and oil resistance • <b>Electronics</b></li> </ul>
	3789* Brown	Y	V2	<ul style="list-style-type: none"> <li><b>High performance for plastics</b> • Impact resistant</li> <li>Bonds vinyl and wood • <b>Good fuel and oil resistance</b></li> </ul>
	3792* Clear	Y	V2	<ul style="list-style-type: none"> <li><b>Clear, multi-purpose</b> for wood, corrugated, fabric, furniture, upholstery, novelties, and other <b>lightweight materials</b></li> </ul>
	3796 Lt. Tan	N	N/A	<ul style="list-style-type: none"> <li>High performance for <b>plastics and light-gauge metals</b></li> </ul>
	3797 Off-white	Y	V2	<ul style="list-style-type: none"> <li>High ball and ring • Low viscosity</li> <li><b>Good for electrical potting</b></li> </ul>
Bulk Only	3794 Hi Tack PSA Lt. Tan	Y	N/A	<ul style="list-style-type: none"> <li><b>Sprayable</b> high tack PSA for bonding <b>plastic, paper, metals</b>, die-cut labels</li> </ul>
	6111 Tan	N	N/A	<ul style="list-style-type: none"> <li><b>Sprayable</b> 100% solventless adhesive for most foams, fabrics, plastics, particle board, and thin metal</li> </ul>
	6111 Green	N	N/A	<ul style="list-style-type: none"> <li>Same as 6111 tan but green in color.</li> </ul>
	6111HT Tan	N	N/A	<ul style="list-style-type: none"> <li>Similar to 6111 but has <b>higher heat resistance</b>.</li> </ul>
	6111HT Blue	N	N/A	<ul style="list-style-type: none"> <li>Similar to 6111 but has <b>higher heat resistance and blue in color</b>.</li> </ul>
	6116 Off-White	N	N/A	<ul style="list-style-type: none"> <li>Similar to 6111 but <b>lower than normal viscosity</b> and <b>mainly used on fabrics</b>.</li> </ul>

\* Also available in bulk. (1) Made from components listed as indirect food additives under FDA regulations for adhesives (21 CFR 175.105).

(2) Brookfield Thermosel Viscometer in Centipoise.

(3) ASTM E-28-99 (4) Temperature at which adhesive fails (5) On canvas (6) On Douglas Fir (7) 1/8" semicircular bead, Douglas Fir to Douglas Fir.

Sizes	EC Temp Control Modules	Viscosity cps <sup>2</sup>	Delivery Time (sec) for 1" x 3" Cartridge	Ball & Ring Melt Point <sup>3</sup> (°F/°C)	Heat Resistance <sup>4</sup> (°F/°C)	Peel Strength PIW <sup>5</sup> 72°F (22°C)	Shear Strength PSI <sup>6</sup> 72°F (22°C)	Open Time 1/8" Bead (sec) <sup>7</sup>	
1/2" x 12"AE	N/A	4000 @250°F	45	200/95	128/54	6	475	25	
58" x 2"TC	N/A	13,000 @250°F	N/A	157/70	120/49	13	500	120	
58" x 8"Q 1" x 3"PG	58" x 2"TC 1/2" x 12"	1	4000 @250°F	45	205/96	130/54	6	480	25
58" x 8"Q 1" x 3"PG	1/2" x 12"	1	8250 @250°F	47	184/84	140/60	9	600	40
58" x 8"Q 1" x 3"PG	58" x 2"TC 1/2" x 12"	1	10,500 @250°F	57	178/81	140/60	13	350	40
58" x 2"TC	N/A	9500 @250°F	N/A	191/88	120/49	N/A	N/A	30	
58" x 8"Q 1" x 3"PG	5	12,000 @375°F	N/A	315/157	265/130	22	490	30	
58" x 8"Q 1" x 3"PG	58" x 2"TC 1/2" x 12"AE	4	2875 @375°F	35	186/86	130/54	13	375	50
58" x 8"Q 1" x 3"PG	58" x 2"TC 1/2" x 12"AE	4	4100 @375°F	45	220/104	145/63	20	430	45
58" x 8"Q 1" x 3"PG	58" x 2"TC	4	5000 @375°F	65	292/144	175/79	18	250	45
58" x 8"Q 1" x 3"PG	58" x 2"TC	4	5500 @375°F	65	305/152	175/79	15	275	30
1/2" x 12"AE	N/A	1900 @375°F	30-40	200/93	125/52	6	500	N/A	
1/2" x 12"AE	N/A	4800 @375°F	35-45	178/81	135/57	12	250	N/A	
58" x 8"Q 1" x 3"PG	58" x 2"TC 1/2" x 12"AE	3	1870 @375°F	30	201/94	130/54	7	545	35
58" x 8"Q 1" x 3"PG	58" x 2"TC 1/2" x 12"AE	4	6000 @375°F	55	190/88	140/60	14	390	40
58" x 8"Q 1" x 3"PG	58" x 2"TC	5	7000 @375°F	75	325/163	300/149	18	700	25
58" x 8"Q 1" x 3"PG		5	5200 @375°F	70	270/132	220/104	16	570	50
58" x 8"Q 1" x 3"PG	58" x 2"TC 1/2" x 12"AE	4	5000 @375°F	45	179/81	140/60	13	250	50
1" x 3"PG 58" x 2"TC	N/A	23,000 @375°F	120	240/116	200/93	29	550	40	
1" x 3"PG 58" x 2"TC	N/A	2650 @375°F	55	304/151	170/77	10	350	30	
2 lb. bricks	N/A	15,000 @325°F	N/A	224/107	120/49	16	N/A	> 60	
.75"x.75" chips	N/A	3,000-5,000 @375°F	N/A	284/140	145/63	34	N/A	1 surface 60 2 surface 360	
.75"x.75" chips	N/A	3,000-5,000 @375°F	N/A	284/140	145/63	34	N/A	1 surface 60 2 surface 360	
.75"x.75" chips	N/A	2,500-4,500 @375°F	N/A	224/107	175/79	26	N/A	1 surface 180 2 surface 480	
.75"x.75" chips	N/A	2,500-4,500 @375°F	N/A	224/107	175/79	26	N/A	1 surface 180 2 surface 480	
.75"x.75" chips	N/A	1,300 @375°F	N/A	199/93	160/69	20	N/A	1 surface 120 2 surface 300	

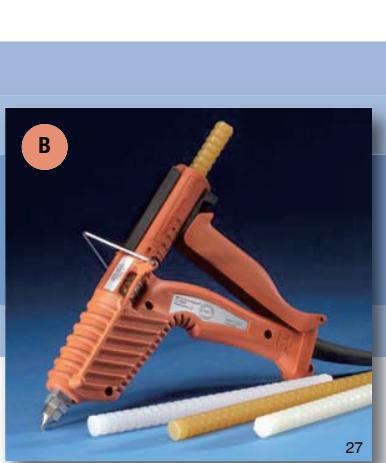
N/A = Not available

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

## Selecting a 3M™ Scotch-Weld™ Hot-Melt Applicator to fit your needs



3M™ Scotch-Weld™ Hot Melt Applicator LT.  
Medium volume using low melt adhesive.  
UPC# 021200-82245



3M™ Scotch-Weld™ Hot Melt Applicator LT  
with Quadrack™ Converter. Medium volume using  
low melt adhesive.  
UPC# 021200-89447



3M™ Scotch-Weld™ Pneumatic Hot Melt  
Applicator PG II LT with Speedloader. High volume  
using low melt adhesive.  
UPC# 021200-89395



3M™ Scotch-Weld™ Hot Melt Applicator AE II LT.  
Low volume using low melt adhesive.  
UPC# 051115-25567



3M™ Scotch-Weld™ Hot Melt Applicator TC.  
Medium volume.  
UPC# 021200-82244



3M™ Scotch-Weld™ Hot Melt Applicator TC  
with Quadrack™ Converter. Medium volume.  
UPC# 021200-89445



3M™ Scotch-Weld™ Pneumatic Hot Melt  
Applicator PG II with Speedloader.  
High volume.  
UPC# 021200-22033



3M™ Scotch-Weld™ Hot Melt Applicator AE II.  
Low volume.  
UPC# 021200-96594



3M™ Scotch-Weld™  
Hot Melt Applicator  
EC. Medium  
volume; variable  
temperature control.  
UPC# 021200-89519



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Lightweight, easy-to-use units... 3M's innovative melt-on-demand or progressive feed technology.

3M™ Scotch-Weld™ Hot Melt Applicators		Weight <sup>(1)</sup>	Output <sup>(2)</sup> lb/hr	Temperature <sup>(3)</sup>	Power (120V)	Adhesive dia. x length, inches	Features	Warranty (Months)
Low Melt Applicators	A LT	10.0 oz.	2.6	265°F (129°C)	150W	5/8 x 2 TC	For use with low melt adhesives	12
	B LT with Quadrack Converter	13.8 oz.	2.6	265°F (129°C)	150W	5/8 x 8 Q		
	C Pneumatic PG II LT with Speedloader	4.3 lbs.	6.0	265°F (129°C)	500W	1 x 3 PG	Pneumatic high output for low melt adhesives	12
	D AE II LT	20.0 oz.	4.0	265°F (129°C)	100W	1/2 x 12 AE	All electric operation for low melt adhesives	6
Hot Melt Applicators	E TC	10.0 oz.	3.5	385°F (196°C)	150W	5/8 x 2 TC	Easy to use with standard melt adhesives	12
	F TC with Quadrack Converter	13.8 oz.	3.5	385°F (196°C)	150W	5/8 x 8 Q		
	G Pneumatic PG II with Speedloader	4.3 lbs.	7.5	385°F (196°C)	500W	1 x 3 PG	Pneumatic high output for standard melt adhesives	12
	H AE II	20.0 oz.	4.0	400°F (204°C)	100W	1/2 x 12 AE	All electric operation for standard melt adhesives	6
Variable	H EC	24.0 oz.	5.5	260°F-450°F (127°-232°C)	350W	5/8 x 8 Q	Temperature modules to operate with standard and low melt adhesives	12

(1) Weight shown is for applicator only — does not include adhesive capacity. (2) Adhesive output will vary with conditions and the adhesive used. Values are approximate and are based on maximum steady-state flow.

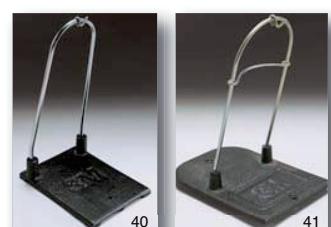
(3) Temperatures shown are nominal control values. Actual temperature will range slightly above and below this value.

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

## Accessories to improve your productivity



Tip No.	Description
9726	"T" Tip (shown with valve and adapter) for all 3M™ Applicators
9764	3/4" Slotted Spreader (3755LM adhesive only)
9777	1/4" Slotted Spreader (3755LM adhesive only)
9782	1/2" Slotted Spreader (3755LM adhesive only)
9727	"L" Tip (shown with adapter and valve) for all 3M™ Applicators
9916	3 Hole Spreader
9913	2 Hole Spreader (1/4" hole span)
9917	3 Hole 1" Spreader for 3M™ Applicator II only
9929	High Viscosity Valve (TC, EC, PG-II)
9946	.072" Brass Extension for 3M™ Applicators PG II and PG II LT only
9785	.070" Tapered Aluminum Extension for all 3M™ Applicators
9725	Mini Extension Tip .072" Opening for all 3M™ Applicators
9922	.063" Fluted Tip
9940	.125" Fluted Tip
9921	.090" Fluted Tip



**Heavy-Duty Benchstands**  
provide added convenience.

Foot pedal, magazine feeder, and benchmount accessories can provide high capacity, hands-free operation for 3M™ Scotch-Weld™ PG II and 3M™ Scotch-Weld™ PG II LT.



Increase loading capacity and ease of operation with Quadrack Converter and Palm Trigger.



Foot Pedal



Bench nozzle assembly



Magazine Feeder

A general purpose tip (.090) is supplied with each 3M™ Scotch-Weld™ Applicator. To increase productivity, optional tips can provide multiple beads, flat ribbons, guided beads for carton sealing, and extended reach.

# Ordering Information

## 3M™ Scotch-Weld™ Hot Melt Adhesives

Product	Color	Size	Container Size	UPC	SN
3750LM	Tan	1/2" x 12" AE	11 lbs	051115-31933	62-3758-9531-5
3755LM	Clear	5/8" x 2" TC	11 lbs	021200-83535	62-3755-9830-7
3762LM	Lt. Amber	1" x 3" PG	22 lbs	021200-49128	62-3720-9330-2
3762LM	Lt. Amber	1/2" x 12" AE	11 lbs	051115-25579	62-3720-9531-5
3762LM	Lt. Amber	5/8" x 2" TC	11 lbs	021200-49134	62-3720-9830-1
3762LM	Lt. Amber	5/8" x 8" Q	11 lbs	021200-49125	62-3720-9132-2
3762LMB	Lt. Amber	Pellets	22 lbs	021200-49130	62-3720-9335-1
3762LMB*	Lt. Amber	Pellets	950 lbs	021200-49133	62-3720-9339-3
3776LM*	Tan	1" x 3" PG	22 lbs	021200-89501	62-3733-9330-5
3776LM	Tan	1/2" x 12" AE	11 lbs	021200-25583	62-3733-9531-8
3776LM	Tan	5/8" x 8" Q	11 lbs	021200-89499	62-3733-9132-5
3792LM	Clear	1" x 3" PG	22 lbs	021200-83491	62-3760-9330-8
3792LM	Clear	1/2" x 12" AE	11 lbs	021200-25580	62-3760-9531-1
3792LM	Clear	5/8" x 2" TC	11 lbs	021200-82456	62-3760-9830-7
3792LM	Clear	5/8" x 8" Q	11 lbs	021200-82454	62-3760-9132-8
3792LMB	Clear	Pellets	22 lbs	021200-43778	62-3760-9335-7
3792LMB	Clear	Pellets	950 lbs	021200-49098	62-3760-9339-9
3798LM	Lt. yellow	5/8" x 2" TC	11 lbs	021200-41604	62-3798-9830-7
3798LMB*	Lt. yellow	Chips	11 lbs	021200-43825	62-3798-9335-7
3731	Tan	5/8" x 2" TC	11 lbs	021200-45271	62-3731-9132-9
3731*	Tan	1" x 3" PG	22 lbs	021200-49139	62-3731-9330-9
3731	Off-White	Chips	22 lbs	021200-49140	62-3731-9335-8
3738	Tan	1" x 3" PG	22 lbs	021200-82609	62-3738-9330-4
3738	Tan	1/2" x 12" AE	11 lbs	021200-82594	62-3738-9531-7
3738	Tan	5/8" x 2" TC	11 lbs	021200-82610	62-3738-9830-3
3738	Tan	5/8" x 8" Q	11 lbs	021200-65262	62-3738-9132-4
3738B	Tan	Pellets	22 lbs	021200-89305	62-3738-9335-3
3738B*	Tan	Pellets	950 lbs	021200-49094	62-3738-9339-5
3747	Tan	1" x 3" PG	22 lbs	021200-82221	62-3747-9330-5
3747	Tan	1/2" x 12" AE	11 lbs	021200-82220	62-3747-9531-8
3747	Tan	5/8" x 2" TC	11 lbs	021200-82560	62-3747-9830-4
3747	Tan	5/8" x 8" Q	11 lbs	021200-82561	62-3747-9132-5
3748	Off-White	1" x 3" PG	22 lbs	021200-82585	62-3748-9330-3
3748	Off-White	5/8" x 2" TC	11 lbs	021200-82584	62-3748-9830-2
3748	Off-White	5/8" x 8" Q	11 lbs	021200-76374	62-3748-9132-3
3748B	Off-White	Chips	22 lbs	021200-43752	62-3748-9335-2
3748	Black	5/8" x 8" Q	11 lbs	021200-45242	62-3724-9132-4
3748V0*	Lt. Yellow	1" x 3" PG	22 lbs	021200-85797	62-3768-9330-1
3748V0*	Lt. Yellow	5/8" x 2" TC	11 lbs	021200-85816	62-3768-9830-0
3748V0	Lt. Yellow	5/8" x 8" Q	11 lbs	021200-85795	62-3768-9132-1
3750	Tan	1/2" x 12" AE	11 lbs	021200-96269	62-3750-9531-2
3750	Clear	1/2" x 12" AE	11 lbs	021200-97353	62-3757-9531-7
3762	Tan	1" x 3" PG	22 lbs	021200-82614	62-3762-9330-4
3762	Tan	1/2" x 12" AE	11 lbs	021200-82596	62-3762-9531-7
3762	Tan	5/8" x 2" TC	11 lbs	021200-82615	62-3762-9830-3
3762	Tan	5/8" x 8" Q	11 lbs	021200-65261	62-3762-9132-4
3764	Clear	1" x 3" PG	22 lbs	021200-82598	62-3764-9330-0
3764	Clear	1/2" x 12" AE	11 lbs	021200-82597	62-3764-9531-3
3764	Clear	5/8" x 2" TC	11 lbs	021200-82599	62-3764-9830-9
3764	Clear	5/8" x 8" Q	11 lbs	021200-76054	62-3764-9132-0
3764B	Clear	Pellets	22 lbs	021200-87850	62-3764-9335-9
3764B	Clear	Pellets	950 lbs	021200-41526	62-3764-9337-5
3779	Amber	1" x 3" PG	22 lbs	021200-82602	62-3779-9330-8
3779	Amber	5/8" x 2" TC	11 lbs	021200-82603	62-3779-9830-7
3779	Amber	5/8" x 8" Q	11 lbs	021200-85799	62-3779-9132-8
3779B*	Amber	Pellets	22 lbs	021200-89307	62-3779-9335-7
3789	Brown	1" x 3" PG	22 lbs	021200-82371	62-3789-9330-7
3789	Brown	5/8" x 8" Q	11 lbs	021200-82369	62-3789-9132-7
3789*	Brown	Pellets	22 lbs	021200-89308	62-3789-9335-6
3792	Clear	1" x 3" PG	22 lbs	021200-82606	62-3792-9330-1
3792	Clear	1/2" x 12" AE	11 lbs	021200-82583	62-3792-9531-4

\*Non-stocked items

## 3M™ Scotch-Weld™ Hot Melt Adhesives (continued)

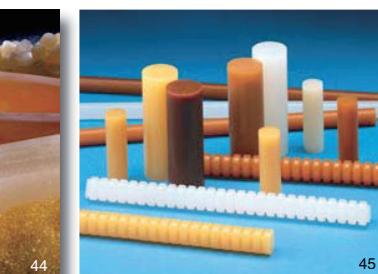
Hot Melt Technology: Applied 350°–385°F (177°–196°C)	Product	Color	Size	Container Size	UPC	SN
	3792	Clear	5/8" x 2" TC	11 lbs	021200-82589	62-3792-9830-0
	3792	Clear	5/8" x 8" Q	11 lbs	021200-65263	62-3792-9132-1
	<b>3792B*</b>	<b>Clear</b>	<b>Pellets</b>	<b>22 lbs</b>	<b>021200-87960</b>	<b>62-3792-9335-0</b>
	3792B	Clear	Pellets	950 lbs	021200-49097	62-3792-9339-2
	3794	Clear	2 lb Loaf	34 lbs	021200-43830	62-3794-6630-3
	3796	Lt. Tan	1" x 3" PG	22 lbs	021200-25352	62-3761-9330-6
	3796	Lt. Tan	5/8" x 2" TC	11 lbs	021200-25353	62-3731-9830-5
	3797	Off-White	1" x 3" PG	22 lbs	021200-82592	62-3797-9330-0
	3797	Off-White	5/8" x 2" TC	11 lbs	021200-82593	62-3797-9830-9
Bulk	6111B	Green	Chips	22 lbs	021200-96590	62-6112-9335-8
	6111B	Tan	Chips	22 lbs	021200-96589	62-6111-9335-0
	6111HTB	Tan	Chips	22 lbs	021200-43779	62-6113-9335-6
	6111HTB	Tan	Chips	850 lbs	021200-56567	62-6113-9339-8
	6111HTB	Blue	Chips	22 lbs	021200-49935	62-6115-9335-1
	<b>6111HTB*</b>	<b>Blue</b>	<b>Chips</b>	<b>850 lbs</b>	<b>021200-56568</b>	<b>62-6115-9339-3</b>
	6116	Off-White	Chips	22 lbs	021200-49924	62-6116-9335-9

\*Non-stocked items

## 3M™ Scotch-Weld™ Hot Melt Applicators

Product	UPC	SN
LT	021200-82245	62-9281-9930-6
LT with Quadrack Converter and Palm Trigger	021200-89447	62-9281-9950-4
Pneumatic PG II LT with Speedloader and Cartridge Feed	021200-89395	62-9783-9630-7
Pneumatic PG II LT with Speedloader and Magazine Feed	021200-89396	62-9783-9830-3
AE II LT	051115-25567	62-9799-9930-7
TC	021200-82244	62-9990-9935-1
TC with Quadrack Converter and Palm Trigger	021200-89445	62-9990-9950-0
Pneumatic PG II with Speedloader and Cartridge Feed includes bench stand and tips 9921 and 9946	021200-22033	62-9938-9630-7
Pneumatic PG II Refurbished with Speedloader and Cartridge Feed*	<b>021200-64787</b>	<b>62-9949-9931-6</b>
Pneumatic PG II with Speedloader and Magazine Feed includes bench stand and tips 9921 and 9946	021200-22034	62-9938-9830-3
Pneumatic PG II Refurbished with Speedloader and Magazine Feed	021200-64788	62-9949-9932-4
AEII	021200-96594	62-9796-9930-3
EC	021200-89519	62-9680-9930-9

\*Non-stocked items



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## 3M™ Scotch-Weld™ Hot Melt Accessories

Product	Description	UPC	SN
9726	"T" Tip Assembly	021200-64542	62-9726-9930-0
9764	3/4" Slotted Spreader for use w/3755LM adhesive	021200-83526	62-9764-9930-1
9777	1/4" Slotted Spreader for use w/3755LM adhesive	021200-83732	62-9777-9930-3
9782	1/2" Slotted Spreader for use w/3755LM adhesive	021200-83529	62-9782-9930-3
9727	"L" Tip with Adapter	021200-64543	62-9727-9930-8
9916	3 Hole Spreader	021200-21836	62-9916-9930-7
9913	2 Hole Spreader	021200-21830	62-9913-9930-4
9917	3 hole 1" Spreader	021200-21837	62-9917-9930-5
9729	High Viscosity Valve (TC, EC, PG II)	021200-64840	62-9729-9930-4
9946	.072" Brass Extension (PG II, PG II LT)	021200-22040	62-9946-6980-2
9785	.070" Tapered Aluminum Extension (all applicators)	021200-82554	62-9785-9930-6
9725	.072" Mini Extension Tip	021200-21786	62-9725-9930-2
9922	.063" Fluted Tip	021200-21841	62-9922-0066-7
9940	.125" Fluted Tip	021200-22036	62-9940-6920-1
9921	.090" Fluted Tip	021200-21840	62-9921-0066-9
Heavy Duty Bench Stand for use with PG II & PG II LT	–	021200-22039	62-9945-9930-6
Heavy Duty bench Stand for use with EC, TC, & LT	–	021200-82418	62-9945-9935-5
Bench Mount	–	021200-82277	62-9276-9930-6
Bench Nozzle Assembly	–	021200-21713	62-9233-2781-1
Foot Pedal Assembly	–	021200-82278	62-9277-9930-4
TC & LT Palm Trigger	–	021200-82701	62-9761-9930-7
TC Quadrack Converter	–	021200-83536	62-9275-9935-7

# Other 3M™ Adhesive Technologies for improved design, productivity, and performance



**3M™ Scotch-Weld™ Structural Adhesives** for the permanent bonding power of epoxies, urethanes, acrylics, and cyanoacrylates.



**3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Adhesive Systems** for structural adhesive benefits with hot melt speed.



**3M™ Scotch-Grip™ Rubber and Plastic Adhesives** for handy tubes of bonding power.



**3M™ Industrial Aerosol Adhesives** for a fistful of bonding power with a wide variety of materials.



**3M™ Scotch-Weld™ Cylinder Spray Adhesives** for bulk productivity with aerosol convenience and portability.

**Limited Product Warranty:** 3M warrants all 3M™ Scotch-Weld™ Hot Melt Applicators for 6 months from the date of manufacture, that the 3M product will be free of defects in material and manufacture. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. This warranty does not cover damage resulting from the use or inability to use the 3M product due to misuse, workmanship in application, or application or storage not in accordance with 3M recommended procedures. **Important Notice:** User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of these materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which 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 of application. **Limitation of Remedies and Liability:** If the 3M product is proved to be defective within the warranty period stated above, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.



Industrial Adhesives and Tapes Division

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