



Scotch-Weld™

Spray 74 Foam Adhesive

Product Data Sheet

Updated : February 2011
Supersedes : December 2007

Product Description	Spray 74 Adhesive is an aerosol adhesive which has been specially formulated for bonding flexible urethane or latex foam to themselves and most other materials (wood, metal plastic, etc.) with the advantage of non-misting lace spray pattern.	The defined edge of the lace spray pattern permits accurate and economical application.	The soft, non dimpling glueline can be repeatedly compressed with no dimpling even after years of ageing. The adhesive develops tack very quickly, allowing faster assembly of parts. The adhesive has a 5 second to 10 minute bonding range.
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Physical Properties
Not for specification purposes

Solvent	Petroleum distillates, Acetone	
Flash Point	Below -42°C	
Propellant	Dimethyl Ether	
Consistency	Thin Liquid in Aerosol	
Contents	363 g (500ml)	
Solids Content	22% approx.	
Colour	Light Orange	
Shelf Life	12 months from date of receipt by customer when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

Performance Characteristics
Not for specification purposes

Service Temperature Range	-32°C to +50°C	
Water Resistance	Good	
Weathering Resistance	Good	
Fuel and Oil Resistance	Poor	

Strength of Adhesive

180° Peel strength. Canvas (No. 10 Cotton Duck) was bonded to steel. Both surfaces were coated, bonds were made at a 5 minutes open time, and bonds were then pulled in 180° peel at a rate of 50mm per minute. 20 PIW (90 N/25mm)

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Additional Product Information	Coverage: Approximately 4.0 square metres per container.	Approximate Drying or Setting Time: Between 5 secs to 10 mins.	Application Temperature Range: 16°C to 27°C
Storage Conditions	Store at 23°C for optimum shelf life.		
Directions for Use	<p>Ensure that all surfaces to be bonded are clean, dry and free from dust, oil or grease before application of adhesive.</p> <p>Ensure that the nozzle points away from all persons and towards the surface to be sprayed. Select the spray pattern required by turning the nozzle between the "L" and "H" positions indicated on the plastic collar. Do not try to force the nozzle beyond these settings. This also changes the spray pattern width as follows:</p> <p>Low Setting = approx. 2cm wide. High Setting = approx. 7cm wide.</p> <p>Shake the can well before using, 5-10 seconds should be sufficient.</p>	<p>Hold the can between 12-18 cm from the surface to be sprayed. A narrowing of the pattern will occur if held more than 20 cm from the surface to be sprayed. When spraying, depress nozzle fully to avoid spluttering or dripping of adhesive.</p> <p>For most applications, apply a single coat of Spray 74 adhesive onto both surfaces to be bonded and allow the adhesive to dry approximately 10 to 30 seconds before bonding. Knife edge type bonds can be made for 10 minutes after application of the adhesive.</p>	<p>To prevent nozzle from blocking, at the end of each day turn the can upside down and press tip until the spray is clear from adhesive, and wipe tip.</p> <p>Clean Up: Spray nozzle or excess material may be cleaned with Scotch-Weld Solvent No. 1. NOTE: Solvent No. 1 is highly flammable. When using solvents for clean up it is essential that proper safety precautions are observed.</p>
Applications	Bonds flexible urethane or latex foam to themselves and to most other materials (felt, fabric, cork, cardboard, plastics, metal, wood, glass etc.		
Health & Safety 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.se		

Important Notice

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