



Scotch-WeldTM Spray 76 Long Open Time Adhesive

Product Data Sheet

Updated : July 2006
Supersedes : August 1995

Product Description

Scotch-Weld Spray 76 Adhesive is an aerosol adhesive which has the advantage of non-misting lace spray pattern. The adjustable spray tip allows for selection of spray width and delivery rate.

The defined edge of the lace spray pattern permits accurate and economical application.

The adhesive develops tack quickly, has one hour bonding range for two surface application, and dries to give high strength bonds which have excellent resistance to water and long term ageing.

Physical Properties

Not for specification purposes

Solvent	Cyclohexane and Pentane	
Flash Point	Below -41°C	
Propellant	Dimethyl Ether	
Consistency	Thin Liquid in Aerosol	
Solids Content	11% approx.	
Colour	Clear/Pale Cream	
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 +80°C	
Water Resistance	Good	
Weathering Resistance	Good	
Fuel and Oil Resistance	Poor	

Strength of Adhesive

Test Results

180° Peel strength. Canvas (No. 10 Cotton Duck) was bonded to the following substrates. Both surfaces were coated, bonds were made at a 5 minutes open time, and dried one day at 24°C and 3 days at 50°C. Bonds were then pulled in 180° peel at a rate of 50mm per minute.

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Strength of Adhesive Cont'd ..	Substrate	180° Peel Strength N/cm
	Aluminium	47 - 51
	Cold Rolled Steel	47
	Polypropylene	47 - 55
	Polyethylene	20 - 24
	ABS	39 - 47
	Nylon	26
	PVC	51 - 59
	Perspex	35 - 43
	Polycarbonate	43 - 51
	Butyl Rubber	10 - 14
	EPDM Rubber	14 - 17
	Natural Rubber	10 - 13
	Neoprene Rubber	10 - 14
	Nitrile Rubber	7 - 10
	SBR	7 - 9

Additional Product Information

Coverage:

Approximately 3.7 square metres per container.

Approximate Drying or Setting Time:

Between 10-60 minutes.

Application Temperature Range:

16°C to 27°C

Storage Conditions

Store at 23°C for optimum shelf life.

Applications

Bonds paper, felt, fabric, cork, cardboard, rubber and plastics to themselves, metal, wood, glass etc.

Suitable for bonding supported vinyl (P.V.C.) but should be checked for plasticiser migration. Spray 76 Adhesive is widely used for bonding polypropylene and polyethylene films to themselves and other substrates.

Directions for Use

Ensure that all surfaces to be bonded are clean, dry and free from dust, oil or grease before application of adhesive.

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:

Low Setting = approx 2cm wide.

High Setting = approx 7cm wide.

Shake the can well before using, 5-10 seconds should be sufficient.

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.

For lightweight materials it is usually only necessary to coat one surface, the least porous bonds can be made up to 10 minutes after application.

Directions for Use
Cont'd ..

Where higher strength is required or heavier materials have to be bonded, apply adhesive to both surfaces. On some substrates, bonds can be made up to 60 minutes after application. Under normal circumstances apply Spray Adhesive 76 to both surfaces, allow adhesive to dry for a few minutes until aggressively tacky, and make bond using firm pressure.

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.

Clean Up:

Spray nozzle or excess material may be cleaned with Scotch-Grip 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.

Health & Safety
Information
Precautions:

Highly flammable. Vapour may be harmful. May cause eye irritation. Keep away from heat. Keep away from sources of ignition including pilot lights and sparks - No Smoking. Avoid prolonged breathing of vapours/spray. Do not use in confined areas or areas with little or no air movement. Do not spray directly into eyes. Avoid prolonged or repeated contact with the skin. Keep out of reach of children.

WARNING:

Pressurised container. Protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn, even after use. Do not spray on a naked flame or incandescent material.

First Aid:
Eye Contact:

Rinse immediately with plenty of water and seek medical advice.

Skin Contact:

Wash with soap and water.

For further information please contact our Toxicology Department at the Bracknell Head Office on (01344) 858000.

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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.

