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Product Description	3M [™] Hot Melt Adhesives are heat applied, 100% solids adhesives. 3M [™] Hot Melt 3747, 3779, 3789 and 3797 are thermoplastic adhesives to bond to wide variety of substrates such as wood, plastic, vinyl, metal and glass.					
	3M [™] Hot Melt Adhesive 3747 3M [™] Hot Melt Adhesive 3779		General purpose adhesive for bonding dissimila substrates such as wood to plastic, fabric to me			
			High strength bonding with excellent environmental stability including very high hea resistance. Fast set time.			
	3M [™] Hot Melt Adhesive 3789		High performance for plastic with good fuel, oil and plasticizer resistance. Long open time.			
	3M [™] Hot Melt Adhesive 3797		Low viscosity for fast flow rates, good high temperature resistance, and fast set. Good for electrical potting.			
Features	• 100% solids, no VOCs					
	• Easy to use					
	• Long open times allow for easy use on large assemblies and large surfaces					
	A dhosiya sats and obtains strength in seconds					
	Autestve sets and obtains strength in seconds					
	Creates high performance bonds					
	• Ideal for woodworking and general industrial applications.					
 Typical Physical	Note: The following technical information and data should be considered representative					
Properties	or typical only and should not be used for specification purposes.				purposes.	
		2717	3M ^{1M} Hot M	alt Adhesive	2707	
	Color (solid)	3/4/ Tan	Amber	Brown	Off-White	
	Density (g/cm ³)	0.97	0.99	0.95	0.92	
	Flashpoint (°F) ¹	509	550	>392	570	
	(1) Determined by Cleveland Open Cup ASTM D 92-72.					
Directions for Use	1. Surface Preparation: Surfaces must be clean, dry and dust free. Wipe with a solvent such as isopropyl alcohol for plastic, metal and glass substrates to remove oil and dirt.* *Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.					
	2. Application: 3M TM Hot Melt Adhesives are designed for application with a 3M TM Hot Melt Applicators. Read and follow the precautions and directions for use in the user's manual before operating the applicator. 3M TM Hot Melt Adhesives are applied at 350-385°F. Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead. Extruded bead sizes can be customized using 3M TM applicator tips.					

3MTM Hot Melt Adhesive

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3. Coverage: 3M TM Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.					
4. Set up time: After strength and no clan substrates.	er the bond is mad nping is necessar	de, 3M™ Hot Me y. Set will occur f	It Adhesives imme aster on cold or n	ediately build netallic	
Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.					
-	3747	3779	3789	3797	
Application Temperature ¹	350-385°F/ 177-196°C	350-385°F/ 177-196°C	350-385°F/ 177-196°C	350-385°F/ 177-196°C	
Viscosity (CPS) ²	4,100 @ 375°F	7,000 @ 375°F	5,200 @ 375°F	2,650 @ 375°F	
Open Time (seconds) ³	45	25	50	30	
Delivery Time (seconds) ⁴	45	75	70	55	
Available sizes/forms	5/8"x8" Q 5/8"x2" TC 1"x3" PG 1/2"x12" AE	5/8"x8" Q 5/8"x2" TC 1"x3" PG 1/8" Bulk	5/8"x8" Q 1"x3" PG 1/8" Bulk	5/8"x2" TC 1"x3" PG	
	3. Coverage: 3M TM of adhesive when ex- 4. Set up time: Aft strength and no clan substrates. Note: The followin ty Application Temperature ¹ Viscosity (CPS) ² Open Time (se conds) ³ Delivery Time (se conds) ⁴ Available sizes/forms	3. Coverage: 3M [™] Hot Melt Adhes of adhesive when extruded as a 1/8" 4. Set up time: After the bond is made strength and no clamping is necessar substrates. Note: The following technical inform typical only and sh 3747 Application Temperature ¹ 350-385°F/ Tempe rature ¹ 177-196°C Viscosity (CPS) ² 4,100 @ 375°F Open Time (se conds) ³ 45 Delivery Time (se conds) ⁴ 45 S/8"x8" Q 5/8"x2" TC 1"x3" PG 1/2"x12" AE	 3. Coverage: 3M[™] Hot Melt Adhesives yield approxin of adhesive when extruded as a 1/8" diameter semi-cire 4. Set up time: After the bond is made, 3M[™] Hot Me strength and no clamping is necessary. Set will occur f substrates. Note: The following technical information and data sh typical only and should not be used for 3M[™] Hot M 3747 3779 Application 350-385°F/ 350-385°F/ 177-196°C Viscosity (CPS)² 4,100 @ 7,000 @ 7,000 @ 375°F Open Time (se conds)³ 45 25 Delivery Time 45 75 Available 5/8"x8" Q 5/8"x8" Q 5/8"x8" Q 5/8"x2" TC 1"x3" PG 1/2"x12" AE 1/8" Bulk 	3. Coverage: 3M TM Hot Melt Adhesives yield approximately 430 linear of adhesive when extruded as a 1/8" diameter semi-circular bead. 4. Set up time: After the bond is made, 3M TM Hot Melt Adhesives immess strength and no clamping is necessary. Set will occur faster on cold or n substrates. Note: The following technical information and data should be considered typical only and should not be used for specification purchases. Mote: The following technical information and data should be considered typical only and should not be used for specification purchases. Mote: The following technical information and data should be considered typical only and should not be used for specification purchases. Mote: The following technical information and data should be considered typical only and should not be used for specification purchases. Mote: The following technical information and data should be considered typical only and should not be used for specification purchases. Mathematical information and data should be considered typical only and should not be used for specification purchases. Mathematical information and data should be considered typical only and should not be used for specification purchases. Mathematical information and data should be considered typical only and should not be used for specification purchases. Application 350-385°F/ Temperature ¹ 177-196°C Viscosity (CPS) ² <td< td=""></td<>	

(2) Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

(3) Open time is the maximum time between the application of the adhesive and when the parts must be joined together. Data based on 1/8" semicircular bead on non-metallic substrates at 75°F. Higher environmental temperatures and/or larger beads will lengthen open times.
(4) Extrusion time for one 1"x3" PG cartridge.

Typical Performance	Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.					
Properties		3MTM Hot Melt Adhesive				
		3747	3779	3789	3797	
	Heat Resistance ¹	145°F/ 63°C	300°F/ 149°C	220°F/ 104°C	170°F/ 77°C	
	Ball & Ring Melt Point ²	220°F/ 104°C	325°F/ 163°C	270°F/ 132°C	304°F/ 151°C	
	She ar Strength ³	430 psi	700 psi	570 psi	350 psi	
	Peel Strength ⁴	20 piw	18 piw	16 piw	10 piw	
	UL94 Listing	n/a	V0	V2	V2	
	FDA Indirect Food Contact ⁵	21 CFR 175.105	21 CFR 175.105	21 CFR 175.105	21 CFR 175.105	

(1) Highest temperature that the adhesive will support a 2 psidead load

(2) ASTM E28-67

(3) Overlap shear measured on Douglas Fir to Douglas Fir

(4) Measured in pounds per inch width (piw). Flexible canvas bonded to Douglas Fir

(5) Permitted for indirect food contact subject to the limitations in applicable CFR section(s).

3MTM Hot Melt Adhesive

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Storage	Store product below 120°F (49°C).	
Shelf Life	When stored at the recommended conditions, this product has a shelf life of 2 y after 3M ships the product to a customer or distributor.	
Pre cautionary Information	Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501	
Product Use	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. How ever, many factors beyond 3Ms control can affect the use and performance of a 3M product in a particular application, including the conditions under w hich the product is used and the time and environmental conditions in w hich the product is expected to perform. Since these factors are uniquely within the user's know ledge and control, it is essential that the user evaluate the 3M product to determine w hether it is fit for a particular purpose and suitable for the user's method of application.	
Warranty and Limited Remedy	Unless stated otherwise in 3Ms product literature, packaging inserts or product packaging for individual products, 3Mw arrants that each 3M product meets the applicable specifications at the time 3M ships the product. Individual products may have additional or different warranties as stated on product literature, package inserts or product packages. 3MMAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If the 3M product is defective within the w arranty period, your exclusive remedy and 3Ms and seller's sole obligation will be, at 3Ms option, to replace the product or refund the purchase price.	
Limitation of Liability	Except w here prohibited by law, 3M and seller w ill not be liable for any loss or damage arising from the 3M product, w hether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including w arranty, contract, negligence or strict liability.	

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001: 2000 standards.

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