

3M Hi-Strength 94 ET Spray Adhesive

Technical Data

March 2012

Product Description

A high performance, industrial grade spray adhesive with a unique low telegraphing pebble spray pattern.

Key Features

- Bonds to a variety of demanding substrates like decorative laminate, metal, and some rubbers.
- Typically used in woodworking and specialty vehicle applications, especially where VOC's are a concern.
- Extended tack allows for longer bonding range.
- Features a low telegraphing spray pattern.

Typical Properties

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

| Product | 3M™ Hi-Strength 94 ET Spray Adhesive - Low VOC <20% | 3M™ Hi-Strength 94 ET Cylinder Spray Adhesive | 3M™ Hi-Strength 94 ET Adhesive |
|---|---|---|--------------------------------|
| Base: | Synthetic Elastomer | Synthetic Elastomer | Synthetic Elastomer |
| Solids Content - (by wt.): | 20.5% | 25% | 25% |
| Density (lbs/gal): | 7 | 7.8 | 7.9 |
| Viscosity (cps): | N/A | N/A | < 500 |
| Color(s): | Translucent and Red | Translucent and Red | Translucent and Red |
| Volatile Organic Compounds (VOC): | < 20% | < 80 g/L | < 80 g/L |
| Hazardous Air Pollutants (HAPS) % wt (calculated): | No | No | No |
| CARB Compliant: | Yes | N/A | N/A |
| SCAQMD 1168 Compliant: | N/A | Yes | Yes |
| GREENGUARD Indoor Air Quality Certified®: | Yes | Yes | Yes |
| LEED® Eligible: | Yes | Yes | Yes |
| Coverage @ 2.5 gms /ft ² per lb (sqft): | 37 | 45 | 45 |
| Spray Pattern: | Variable Lace | Pebble | Pebble or Lace |
| Dry Time: | 1 minute | 1 minute | 1 minute |
| Bonding Range: | 1-60 minutes | 1-60 minutes | 1-60 minutes |
| Shear Adhesion Failure Test - SAFT ⁽¹⁾ : | 210F | 210F | 210F |
| Flammable Solvent: | Yes | Yes | Yes |
| Flammable Propellant: | Yes | Yes | N/A |

⁽¹⁾SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90F and ramped 10F every 10 mn. until complete failure.

Available Sizes

| Container Size | 94 ET - Clear | | 94 ET - Red | |
|----------------------------------|-----------------|-------------------|-----------------|-------------------|
| | 3M Stock Number | UPC Number | 3M Stock Number | UPC Number |
| 24 Fl. Oz. (Net Wt. 19.8 oz) | 62-4870-4930-6 | 00-051111-97977-8 | 62-4873-4930-0 | 00-051111-97978-5 |
| Large Cylinder – 26.2 lbs. | 62-4871-8030-9 | 00-051111-97979-2 | 62-4874-8030-3 | 00-051111-97986-0 |
| Intermediate Cylinder – 128 lbs. | 62-4871-8150-5 | 00-051111-97980-8 | 62-4874-8150-9 | 00-051111-97987-7 |
| Jumbo Cylinder – 266 lbs. | 62-4871-8300-6 | 00-051111-97981-5 | 62-4874-8300-0 | 00-051111-97988-4 |
| 5 gallon pail – 39.5 lbs. | 62-4872-8530-3 | 00-051111-97983-9 | 62-4875-7535-9 | 00-051111-97984-6 |
| 54 gallon drum – 426.6 lbs. | 62-4872-9530-5 | 00-051111-97990-7 | 62-4875-9530-8 | 00-051111-97991-4 |

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| Storage | Store product at 60°-80°F (16°-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis. |
| Shelf Life | When stored at the recommended conditions in original, unopened container, this product has a shelf life of 15 months from date of shipment. |
| Precautionary 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. |
| Technical Information | The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed. |
| Product Use | Many factors beyond 3M’s control and uniquely within user’s knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user’s method of application. |
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