



Scotch-Weld™ Spray 74 Foam Adhesive

Product Data Sheet

Date: April 2008

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.

Physical Properties

Not for specification purposes

Solvent	Petroleum distillates, Acetone	
Flash Point	Below -42°C	
Propellant	Dimethyl Ether	
Consistency	Thin Liquid in Aerosol	
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	

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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)

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 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 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.
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-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.

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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

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.



Industrial Adhesives & Tapes Division

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