

# 3M Scotch-Weld™ Hi-Strength Postforming 94 CA Spray Adhesive

Technical Data

March 2012

## Product Description

A low VOC, high performance, postformable 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.
- Formulated with exceptionally high solids.
- 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™ Scotch-Weld™ Hi-Strength Postforming 94 CA Cylinder Spray Adhesive	3M™ Scotch-Weld™ Hi-Strength Postforming 94 CA Spray Adhesive
Base:	Synthetic Elastomer	Synthetic Elastomer
Solids Content - (by wt.):	28%	34%
Density (lbs/gal):	7.9	7.8
Viscosity (cps):	N/A	< 500
Color(s):	Translucent and Red	Translucent and Red
Volatile Organic Compounds (VOC):	< 80 g/L	< 80 g/L
Hazardous Air Pollutants (HAPS) % wt (calculated):	No	No
CARB Compliant:	N/A	N/A
SCAQMD 1168 Compliant:	Yes	Yes
GREENGUARD Indoor Air Quality Certified®:	Yes	Yes
LEED® Eligible:	Yes	Yes
Coverage @ 2.5 gms /ft <sup>2</sup> per lb (sqft):	51	62
Spray Pattern:	Pebble	Pebble or Lace
Dry Time:	1 minute	1 minute
Bonding Range:	1 – 15 minutes	1 – 15 minutes
Shear Adhesion Failure Test - SAFT <sup>(1)</sup> :	210F	210F
Flammable Solvent:	Yes	Yes
Flammable Propellant:	Yes	N/A

<sup>(1)</sup>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 - Note: 94 CA FF = 3M™ Scotch-Weld™ Hi-Strength Postforming 94 CA Spray Adhesive (94 CA) but with NO ADDED FRAGRANCE**

Container Size	3M Stock Number 94 CA - clear	3M Stock Number 94 CA - red	3M Stock Number 94 CA FF - clear	3M Stock Number 94 CA FF - red
Mini Cylinder – 7.6 lbs.	62-4960-8010-2	62-4970-8010-1	62-4920-8010-6	N/A
Large Cylinder – 26.2 lbs.	62-4960-8030-0	62-4970-8030-9	62-4920-8030-4	62-4940-8030-2
Interm. Cyl. – 128 lbs.	62-4960-8150-6	62-4970-8150-5	62-4920-8150-0	62-4940-8150-8
Jumbo Cyl. – 266 lbs.	62-4960-8300-7	62-4970-8300-6	62-4920-8300-1	62-4940-8300-9
5 gallon pail – 40 lbs.	62-4924-8530-5	62-4988-8530-0	62-4922-8530-9	62-4944-8530-3
54 gallon drum – 432 lbs.	62-4924-9530-4	62-4988-9530-9	62-4922-9530-8	62-4944-9530-2
Open Head drum	62-4924-9531-2	62-4988-9531-7	N/A	N/A

# **3M** **Scotch-Weld™ Hi-Strength Postforming 94 CA Spray Adhesive**

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<b>Storage</b>	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.
<b>Shelf Life</b>	When stored at the recommended conditions in original, unopened container, this product has a shelf life of 15 months from date of shipment.
<b>Precautionary Information</b>	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.
<b>Technical Information</b>	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.
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## **3M**

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