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3M™ FoamFast 74 Spray Adhesive Orange Aerosol Can, 24 fl oz, 12 per case



For Bonding Flexible Urethane or Latex Foam Together or to Many Other Materials Like Wood, Metal, and Non-Vinyl Plastics.

It is used for bonding flexible urethane or latex foam together or to many other materials like wood, metal and plastics. THIS ADHESIVE IS NOT RECOMMENDED FOR BONDING VINYL PLASTICS. Its outstanding features include extra coverage, bonds immediately.

3M ID: 62-4935-4936-4

GTIN(UPC/EAN): 0 00 21200 82242 1

3M ID: 62-4935-4936-4

Minimum Order Quantity: 12 CAN

	Imperial	Metric
Length	12.300 INCH	0.312 MTR
Width	9.300 INCH	0.236 MTR
Height	9.700 INCH	0.246 MTR
Gross Weight	16.8000 LBS	7.6204 KG



Scotch-Weld™

Specialty Cylinder Spray Adhesives

70 • 74 • 74 NF • 78 • 78 ET • 78 HT

Technical Data

Product Description 3M™ Scotch-Weld™ Specialty Cylinder Spray Adhesives are industrial grade, versatile bulk spray adhesives formulated for specific substrates and market needs (soft foams – polystyrene foams). The adhesive is packaged in convenient, portable, no maintenance aerosol cylinders.

- Key Features**
- High solids, high coverage adhesive.
 - Fast drying formulas to help speed assembly.
 - Good moisture resistance to help protect bonds.
 - Temporary or permanent bonds on substrates like fabrics, soft foams, polystyrene foam, heavy papers, wood, metal, glass and most plastics.
 - One or two surface bonding capabilities.
 - Non-Flammable solvent and propellant adhesive.
 - High temperature resistance.

Typical Physical 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™ Specialty Cylinder Spray Adhesives											
	70		74		74 NF		78		78 ET		78 HT	
Base:	Synthetic Elastomer		Synthetic Elastomer		Synthetic Elastomer		Synthetic Elastomer		Synthetic Elastomer		Synthetic Elastomer	
Solids Content of Adhesive – propellant removed (by wt.):	40.6%		36%		28%		35%		30.5%		27%	
Solids Content – aerosol (by wt.):	20.9%		22%		22.3%		19.1%		16.8%		14.9%	
Color(s):	Clear		Clear, Orange		Clear		Clear		Clear, Green		Blue	
Volatile Organic Compounds (VOC):	546 g/L		563 g/L		162 g/L		558 g/L		570 g/L		602 g/L	
Hazardous Air Pollutants (HAPS) % wt. (calculated):	0%		0%		55-65%		0%		36.2%		0%	
MACT Compliant:	Yes		Yes		No		No		No		Yes	
Flammability:	Solvent	Propellant	Solvent	Propellant	Solvent	Propellant	Solvent	Propellant	Solvent	Propellant	Solvent	Propellant
	Yes	Yes	Yes	Yes	No	No	Yes	Yes	Yes	Yes	Yes	Yes

3M™ Scotch-Weld™ Specialty Cylinder Spray Adhesives

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Available Sizes and Expected Coverage

3M™ Scotch-Weld™ Specialty Cylinder Spray Adhesives	Cylinder Size Availability	Cylinder Adhesive Net. Wt. (lbs.)	Sq. Ft. Coverage per Wet lb. of Adh @ 1 gm./sq. ft. (dry wt.):	Sq. Ft. Coverage @ 1 gm./sq. ft. (dry wt.):	Sq. Ft. Coverage @ 2.5 gms./sq. ft. (dry wt.):
70	Large - Disposable	27.3	95	2,590	1,036
	Intermediate - Disposable	139	95	13,189	5,276
	Jumbo - Returnable	288	95	27,327	10,931
74	Large - Returnable	30.3	100	2,996	1,199
	Intermediate - Returnable	150	100	14,832	5,933
	Jumbo - Returnable	297	100	29,664	11,866
74 NF	Mini - Disposable	10.5	101	1,063	425
	Large - Disposable	37	101	3,746	1,498
	Intermediate - Returnable	185.6	101	18,791	7,516
	Jumbo - Returnable	371.7	101	37,362	15,053
78	Large - Returnable	29.3	87	2,541	1,016
78 ET	Large - Disposable	29.3	76	2,235	894
	Intermediate - Returnable	139	76	10,606	4,244
	Jumbo - Returnable	298	76	22,729	9,092
78 HT	Mini - Disposable	8.5	68	575	230
	Large - Disposable	28.5	68	1,928	771
	Intermediate - Returnable	138.6	68	9,376	3,750
	Jumbo - Returnable	287.1	68	19,421	7,768

Handling/ Application Information

Surface Preparation:

For best results, all surfaces to be bonded must be clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc.

Application Temperature:

For best results, the temperature of the adhesive and the surfaces being bonded should be between 60°-80°F (16°-27°C). Temperatures outside this range may affect bonding range and sprayability.

Equipment Setup:

Attach the larger flare fitting end to the spray applicator and tighten the nut securely. Check to see that the applicator gun trigger stop/adjusting nut is fully locked against the trigger. Attach the other end of the hose, a smaller flare fitting, to the cylinder valve and tighten securely.

Directions For Use:

- 1.) Slowly open the cylinder valve and inspect the connections for any leaks. Tighten if needed.
- 2.) Fully open the valve.
- 3.) Unscrew the trigger stop/adjusting nut away from the trigger 3-4 turns and spray a test pattern. For more adhesive output, continue to screw the nut away from the trigger. For less adhesive output, screw the nut back towards the trigger.
- 4.) Hold the applicator 3-10 inches away from the surface to be sprayed and apply a uniform coat of adhesive. (The smaller the spray pattern chosen in step 3, the closer the applicator gun will need to be to the surface and vice versa for larger patterns.)
- 5.) Apply 1-3 even coats of adhesive. (This will depend on the needed coverage for the bonding application.)
- 6.) Allow adhesive to dry until tacky and then apply sufficient pressure to ensure complete contact.

Note: Test the tackiness by gently touching the adhesive with your knuckle. If the adhesive transfers to your skin, it is too wet. If the adhesive is aggressively tacky and does not transfer to your skin, it is ready to bond. If the adhesive is too dry or only has a very light tack, it is too dry and another coat of adhesive should be applied to at least one of the surfaces.

3M™ Scotch-Weld™ Specialty Cylinder Spray Adhesives

70 • 74 • 74 NF • 78 • 78 ET • 78 HT

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 the 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.

Product Use All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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Industrial Adhesives and Tapes Division



Recycled Paper
40% pre-consumer
10% post-consumer



Material Safety Data Sheet

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SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

PRODUCT NAME: 3M(TM) Super Foam Fast Spray Adhesive 74, Orange

MANUFACTURER: 3M

DIVISION: Industrial Adhesives and Tapes Division

ADDRESS: 3M Center
St. Paul, MN 55144-1000

Issue Date: 02/19/2009

Supersedes Date: 12/02/2008

Document Group: 16-5619-8

Product Use:

Intended Use: Adhesive
Specific Use: Aerosol foam adhesive

SECTION 2: INGREDIENTS

<u>Ingredient</u>	<u>C.A.S. No.</u>	<u>% by Wt</u>
NONVOLATILE COMPONENTS -N.J. TRADE SECRET REGISTRY NO. 04499600-6460p	Trade Secret	15 - 25
DIMETHYL ETHER	115-10-6	15 - 25
ISOBUTANE	75-28-5	15 - 25
ACETONE	67-64-1	15 - 25
PENTANE	109-66-0	7 - 13
METHYL ACETATE	79-20-9	3 - 7
CYCLOHEXANE	110-82-7	1 - 5
PETROLEUM NAPHTHA	64742-48-9	1 - 3

SECTION 3: HAZARDS IDENTIFICATION

3.1 EMERGENCY OVERVIEW

Odor, Color, Grade: orange, sweet fruity odor

General Physical Form: Gas

Immediate health, physical, and environmental hazards: Extremely flammable liquid and vapor. Vapors may travel long distances along the ground or floor to an ignition source and flash back. Aerosol container contains flammable material under

MATERIAL SAFETY DATA SHEET 3M(TM) Super Foam Fast Spray Adhesive 74, Orange

ACETONE	ACGIH	STEL	750 ppm	Table A4
ACETONE	OSHA	TWA, Vacated	750 ppm	
ACETONE	OSHA	TWA	1000 ppm	Table Z-1
ACETONE	OSHA	STEL, Vacated	1000 ppm	
CYCLOHEXANE	ACGIH	TWA	100 ppm	
CYCLOHEXANE	OSHA	TWA	300 ppm	Table Z-1
DIMETHYL ETHER	AIHA	TWA	1000 ppm	
DIMETHYL ETHER	CMRG	TWA	1000 ppm	
PETROLEUM NAPHTHA	3M	TWA	100 ppm	
PETROLEUM NAPHTHA	CMRG	TWA	300 ppm	
ISOBUTANE	ACGIH	TWA	1000 ppm	
METHYL ACETATE	ACGIH	TWA	200 ppm	
METHYL ACETATE	ACGIH	STEL	250 ppm	
METHYL ACETATE	OSHA	TWA	200 ppm	Table Z-1A
METHYL ACETATE	OSHA	STEL	250 ppm	Table Z-1A
PENTANE	ACGIH	TWA	600 ppm	
PENTANE	OSHA	TWA, Vacated	600 ppm	
PENTANE	OSHA	STEL, Vacated	750 ppm	
PENTANE	OSHA	TWA	1000 ppm	Table Z-1

VAC Vacated PEL: Vacated Permissible Exposure Limits [PEL] are enforced as the OSHA PEL in some states. Check with your local regulatory agency.

SOURCE OF EXPOSURE LIMIT DATA:

- ACGIH: American Conference of Governmental Industrial Hygienists
- CMRG: Chemical Manufacturer Recommended Guideline
- OSHA: Occupational Safety and Health Administration
- AIHA: American Industrial Hygiene Association Workplace Environmental Exposure Level (WEEL)

SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

Odor, Color, Grade:	orange, sweet fruity odor
General Physical Form:	Gas
Autoignition temperature	<i>No Data Available</i>
Flash Point	-50 °F [<i>Test Method:</i> Tagliabue Closed Cup]
Flammable Limits - LEL	<i>No Data Available</i>
Flammable Limits - UEL	<i>No Data Available</i>
Vapor Density	2.97 [<i>Ref Std:</i> AIR=1]
Specific Gravity	0.718 [<i>Ref Std:</i> WATER=1]
pH	<i>No Data Available</i>
Melting point	<i>No Data Available</i>
Solubility in Water	Nil
Evaporation rate	1.90 [<i>Ref Std:</i> ETHER=1]
Hazardous Air Pollutants	<=0.1 % weight [<i>Test Method:</i> Calculated]
Volatile Organic Compounds	Approximately 55 % [<i>Test Method:</i> calculated SCAQMD rule 443.1]
Percent volatile	Approximately 78 % weight
VOC Less H2O & Exempt Solvents	55 %
Viscosity	<i>Not Applicable</i>