Hi-Tack Composite Spray Adhesive 71

Technical Data Sheet March 2018

Product Description

A high tack, resin compatible mist spray aerosol adhesive for resin infused composite applications.

Key Features

- Securely bonds many lightweight materials used in resin infused composites. Such as glass fiber, carbon fiber, nylon fibers, peel ply & transfer mesh.
- Meets CARB / OTC VOC Requirements.
- Compatible with resins used in composite manufacture, including epoxy, vinyl ester & polyester resins.

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-Tack Composite Spray Adhesive 71
Base	SBR type synthetic elastomer
Solids Content - (by wt.):	19 to 20% by wt
Density (lbs/gal):	6.6 lbs/gallon; 790 grams/liter
Color(s):	Translucent or Yellow Green
Volatile Organic Compounds (VOC):	<25%
CARB / OTC Compliant:	Yes
Coverage @ 10 gram / m^2 per Can:	99 square feet; 10 square meters Per Can
Spray Pattern:	Mist/Particulate
Dry Time:	15 to 60 seconds
Bonding Range:	Up to 20 minutes
Shear Adhesion Failure Test - SAFT(1):	205°F 96°C
Flammable Solvent:	Yes
Flammable Propellant:	Yes

Test Descriptions:

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

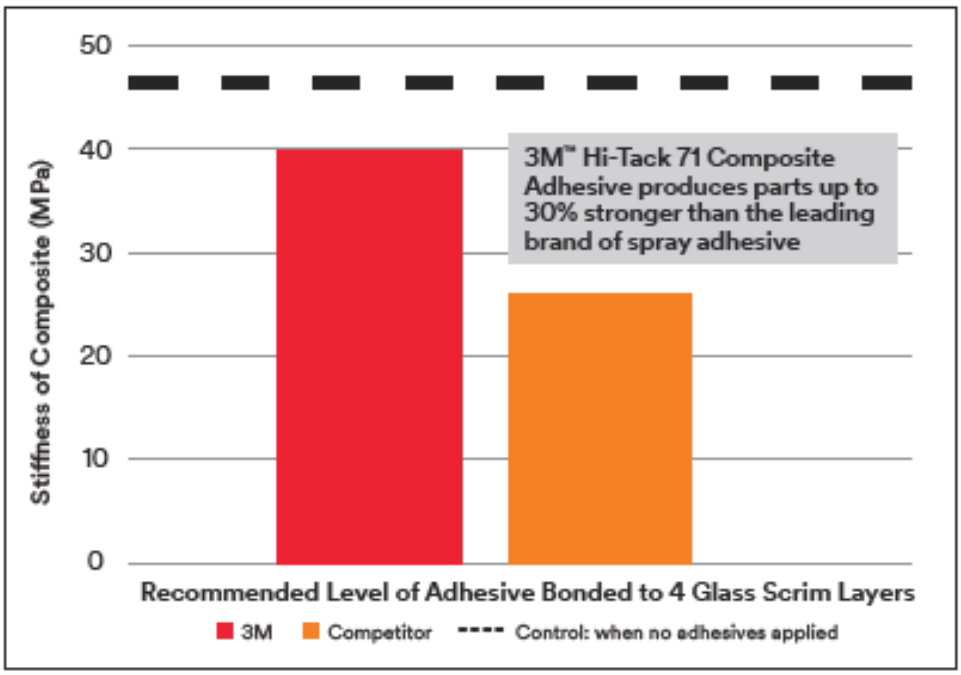
Application

Aerosol Can: Hold can perpendicular 6” to 8”; 150 mm to 200mm from the substrate to be sprayed. Typical woven fiberglass materials only need 1 dry gram / square foot to hold up to 6 layers vertically. More adhesive may be needed depending on number of layers, configuration and nature of materials. For example the transfer mesh may need more adhesive to avoid edge curl. The color indicator adhesive is recommended when possible to minimize the amount of adhesive necessary. Only a slight indication of green is needed to bond most materials. See photo for approximate appearance on fiberglass fabric:

Green color indicator image (not enough, just right, too much.)

3M™ Hi-Tack Composite Spray Adhesive 71

3M™ Hi-Tack Composite Spray Adhesive 71 is formulated to be compatible with the resins used in the manufacturing of vacuum infused composite parts. Chart 1. Compares the effects 3M™ Hi-Tack Composite Spray Adhesive 71 on the strength of a polyester infused composite.



Ordering Information

Product	Stock Number/ UPC Number	Color	Net Weight	Case Quantity
3M™ Hi-Tack Composite Spray Adhesive 71	62-4867-4930-2 0-00-76308-14329-9	Green	18.04 oz	12
	62-4865-4930-6 0-00-76308-14327-5	Clear		

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 if 15 months from date of shipment.

3M™ Hi-Tack Composite Spray Adhesive 71

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

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ISO 9001

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

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