



Scotch-Weld™ Hot Melt Comparison on Plastics

Technical Bulletin

August, 2006

The 3M™ Scotch-Weld™ Adhesive formulations are excellent candidates for bonding low surface energy (LSE) substrates. We can offer five formulas for extruding or spraying.

- The bonding range/open time is 30-120 seconds.
- Can be applied with 3M™ Scotch-Weld™ Hot Melt LT Applicators.
- Stable in bulk hot melt systems and available in bulk form. (except 3M™ Scotch-Weld™ Polyolefin Adhesive 3796)
- Adheres to difficult-to-bond substrates.
- Provide high heat resistance.
- Available in most of the popular 3M™ Scotch-Weld™ Hot Melt Adhesive sizes.

Comparison Data

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

	3M™ Scotch-Weld™ Polyolefin Adhesive 3731	3M™ Scotch-Weld™ Polyolefin Adhesive 3748	3M™ Scotch-Weld™ Polyolefin Adhesive 3764	3M™ Scotch-Weld™ Polyolefin Adhesive 3796	3M™ Sprayable Hot Melt Adhesive 6111 HT
Viscosity @ 375°F (191°C) (cps)	12,000	5,600	6,900	24,000	3,500
Heat Resistance - 2 Lb. Dead Load	265°F (129°C)	170°F (77°C)	140°F (60°C)	200°F (93°C)	175°F (79°C)
Bonding Range (sec)	30	40	40	50	120
Overlap Shear (PSI)					
PP/PP	550	348	285	260	388
HDPE/HDPE	420	363	389	61	100
Cold Rolled Steel/Cold Rolled Steel	390	221	235	789	365
ABS/ABS	450	193	454	655	372
PVC/PVC	430	272	450	873	417
Peel (PIW)					
PP/Canvas	22	22	5.3	1.4	14.4*
HDPE/Canvas	23	24	6.2	0.1	3.5*
Ball & Ring	315°F (157°C)	290°F (143°C)	190°F (88°C)	244°F (118°C)	212°F (100°C)

*Spray applied

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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.

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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



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10% post-consumer

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