



## A tradition of 40 years and the performance you'll want for a long time to come

This line offers a wide range of choices for contact adhesive applications. Select from bonding ranges, strengths, solids content, and solvent or water-based formulations to meet requirements for bonding laminate, foam, and more.

In the line, you'll find the water-based pioneer 3M™ Fastbond™ Contact Adhesive 30NF – proven for almost 40 years in cabinet shops and compliant with the stringent requirements of South Coast Air Quality Management District Rule 1168. Plus, there's 3M™ Fastbond™ Contact Adhesive 2000NF with handling speed exceeding most solvent-based systems and up to 350 psi in overlap shear.

26

### The 3M™ Fastbond™ Water-Based Story

While competition pressures you to improve productivity, regulatory legislation demands that you move toward more environmentally-responsible technologies. Some local and regional regulations have made traditional solvent-based contact adhesives virtually obsolete.

By replacing solvent-based adhesives with a water-based 3M™ Fastbond™ Adhesive, compliance is getting easier in more and more applications. At the same time, you have a choice of production and end-use characteristics as you can see in the chart at far right.



Fastbond is the 3M trademark on a continually growing line of water-based adhesives. For example, 3M™ Fastbond™ Foam Adhesive 100 is a one-part, water-dispersed formulation for bonding many porous substrates to porous or non-porous substrates with minimal dry time.



For tabletop lamination, 3M™ Fastbond™ Contact Adhesive 2000NF gives you three times the coverage of a typical solvent-based system. For production speed, you go from spray to trim in seconds.



In compound cushion assembly, 3M™ Fastbond™ Foam Adhesive 100 holds curves in seconds. Lighter density foam is adhered around the higher density core with a smooth rounded edge.



3M™ Fastbond™ Foam Adhesive 100 quickly bonds substrates throughout chairs and couches. Bond foam to foam and fiber fill, foam to wood, fiber fill to fabric, and more.



In cabinet assembly, 3M™ Fastbond™ Contact Adhesive 30NF is a formulation proven in shops for four decades. Combines open time of up to 4 hours with high immediate bond strength. Apply with roller, brush, or spray gun.



In bonding carpet to fiberglass flooring and steps, 3M™ Fastbond™ Contact Adhesive 2000NF helps withstand the foot traffic and moisture in boat cabins.

Photo courtesy of Grady White Boats Incorporated.

## Product Information: 3M™ Fastbond™ Contact Adhesives, Water-Based

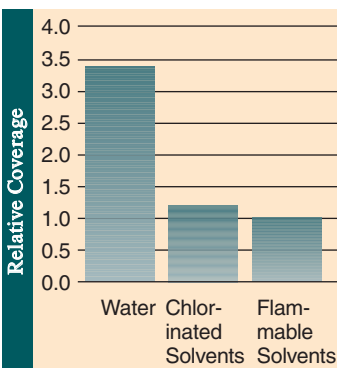
Product	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PIW)	
								75°F (24°C)	180°F (82°C)	75°F (24°C)	
Contact Adhesives, Water-Based	30NF	• Long bonding range with high immediate bond strength • Economical high coverage • Meets MIL-A-24179A, Type I	50%	None	Thin liquid	Green, Clear	Spray, roller, brush	Up to 4 hours	480 <sup>(1)</sup>	60 <sup>(1)</sup>	5.9 <sup>(2)</sup>
	30H	• High viscosity version of 30NF for roll coating	50%	None	Medium liquid	Green, Clear	Spray, roller, brush, roll coat	Up to 4 hours	480 <sup>(1)</sup>	60 <sup>(1)</sup>	5.9 <sup>(2)</sup>
	2000NF	• Water-dispersed, activated adhesive • Immediate bonding and handling strength without forced drying	49%	None	Thin liquid	Blue, Light Orange, Clear	Co-Spray	Up to 2 hours	350 <sup>(1)</sup>	50 <sup>(1)</sup>	4.1 <sup>(2)</sup>
	100	• One-part, fast setting with neoprene base • Bonds many porous substrates to porous or non-porous substrates	47%	None	Very thin liquid	Lavender, Clear	Spray	Up to 20 minutes	NA	NA	1.1 <sup>(2)</sup>

27

## Product Information: 3M™ Scotch-Grip™ Contact Adhesives

Product	Description	Solids Weight (Approx.)	Flash Point (Closed Cup)	Consistency	Color Dry Film	Application Method	Bonding Range	Overlap Shear Strength (PSI)		Peel Strength (PIW)	
								75°F (24°C)	180°F (82°C)	75°F (24°C)	
Contact Adhesives	5	• Rapid strength buildup • Heat and creep resistant bond • Meets mil spec MMM-A-121	19%	-14°F (-26°C)	Thin liquid	Green, Light Yellow	Spray	30 minutes maximum	482 <sup>(1)</sup>	65 <sup>(1)</sup>	19 <sup>(2)</sup>
	10	• Similar performance to 5 • Brushable with higher coverage • Meets mil spec MMM-A-121	22%	-14°F (-26°C)	Thin liquid	Light Yellow	Brush, roller	30 minutes maximum	482 <sup>(1)</sup>	65 <sup>(1)</sup>	19 <sup>(2)</sup>
	1357	• Rapid buildup to a very high strength bond for metal • Resists heat and continuous load stress • Meets MIL-A-21366A, MMM-A-121	25%	-14°F (-26°C)	Thin liquid	Gray-green, Light Yellow	Brush, spray	30 minutes maximum	536 <sup>(1)</sup>	199 <sup>(1)</sup>	42 <sup>(2)</sup>
	1357L	• Lower solids, lower viscosity version of 1357 for automatic spray	18%	-14°F (-26°C)	Thin liquid	Gray-green	Spray	30 minutes maximum	536 <sup>(1)</sup>	199 <sup>(1)</sup>	42 <sup>(2)</sup>

(1) Birch plywood to birch plywood @ 0.1 inches/minute separation rate. (2) Canvas to cold rolled steel @ 2.0 inches/minute separation rate.



Carrier	Water	Chlorinated Solvents	Flammable Solvents
% Solids	50%	15%	20%
Density (lbs/gal)	9.1	10.8	6.7
lbs. of adhesive/gal	4.6	1.6	1.3
Relative coverage	3.4	1.2	1.0
Issues		Toxicity	Flammability



**Buy only the quantity you need** – Depending on the specific adhesive, you can select tubes, quart or gallon jugs for convenient handling, or 5-gallon pails and 55-gallon drums for large bulk dispensing.

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