



# Technical Data Sheet

## 3M™ Sprayable Hot Melt Adhesive 6111 HT



[Product Details](#)



[Regulatory Info/SDS](#)

### Product Description

3M™ Sprayable Hot Melt Adhesive is a heat applied, 100% solids, sprayable adhesive for a fast, neat alternative to aerosols, contact adhesives and solvent-based adhesives to bond most foams and many other lightweight materials.

- Sprayable 100% solids adhesives for most foams, fabrics particle board and thin metal. Has higher heat resistance than 6111. Tan in color for spraying on dark colored substrates

### Product Features

- Sprayable thermoplastic adhesive.
- One or two surface application.
- Immediate initial strength
- Bonds wide variety of substrates, including most foams, plastics, particle board, light gauge metals.
- Solvent-free, 100% solids.
- Long bonding range.
- Excellent adhesion to polypropylene
- Controlled application with minimal overspray.

**Note:** Not recommended for bonding unsupported vinyl and leather

### Technical Information Note

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

### Typical Uncured Physical Properties

Attribute Name	Value
Color	Tan/Blue <sup>1</sup>
Base	Polyolefin copolymer thermoplastic

<sup>1</sup> Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

### Typical Physical Properties

Attribute Name	Temperature	Value
Description		Higher Heat Resistance
Open Time		8 min <sup>1</sup>
Open Time		3 min <sup>2</sup>
Flash Point		276 °C (529 °F)
Available Formats		Chip
Specific Gravity		0.93
Viscosity	191 °C (375 °F)	2,500-4,500 cP <sup>3</sup>

<sup>1</sup> Two pieces of 3/4 in. thick, 2-lb. density polyester urethane foam were sprayed and bonded using 5 sec of firm pressure. After 24 hrs, bonds were pulled apart by hand. The criterion for open time is 100% foam tear.

<sup>2</sup> 3/4 in. thick, 2-lb. density polyester urethane foam. PVC cleaned with IPA and bonded to foam using 5 sec of firm pressure. 24 hr dwell, bonds were pulled apart by hand. The criterion for open time is 100% foam tear.

<sup>3</sup> Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

## Typical Performance Characteristics

### 180° Peel Adhesion

Temperature: 22 °C (72 °F)

Substrate	Value
ABS	264 oz/in <sup>1</sup>
Cold Rolled Steel	478.4 oz/in <sup>1</sup>
Fir	409.6 oz/in <sup>1</sup>
High Density Polyethylene (HDPE)	56 oz/in <sup>1</sup>
Polypropylene (PP)	230.4 oz/in <sup>1</sup>
Polyvinyl chloride (PVC)	260.8 oz/in <sup>1</sup>

<sup>1</sup> Peel bonds of cotton duck were tested at a peel angle of 180° @ 2in/min separation rate @RT. The value listed is the average force required to peel the canvas from the substrates in pounds per inch of bond width (PIW).

### Dead Load Shear

Test Condition	Value
150 g (0.22 lb) Load	91 °C (195 °F)
250 g (0.55 lb) Load	88 °C (190 °F)
1 lb Load	82 °C (180 °F)
2 lb Load	79 °C (175 °F)

Attribute Name	Value
Application Temperature	177 — 196 °C (350 — 385 °F)

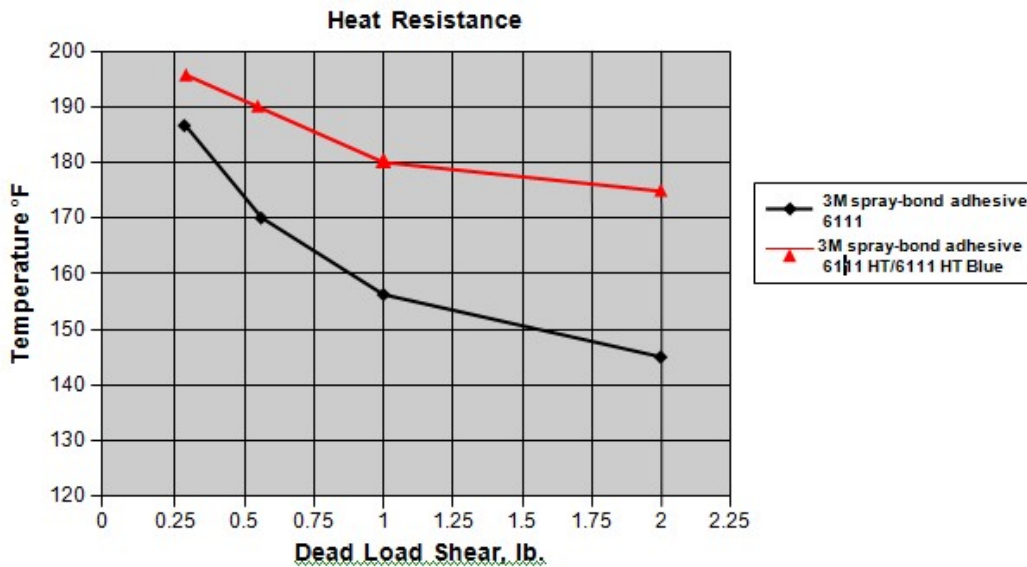
### Foam Tear

Substrate	Value
Fir	Yes <sup>1</sup>
ABS	Yes <sup>1</sup>
Polypropylene (PP)	Yes <sup>1</sup>
Polyvinyl chloride (PVC)	Yes <sup>1</sup>
Cold Rolled Steel	Yes <sup>1</sup>
High Density Polyethylene (HDPE)	No <sup>1</sup>

<sup>1</sup> PU foam of 1.2 lb./cu. ft. density bonded to various substrates. After 24hr @ RT, attempt to pull the foam from the substrate. It was noted if the adhesive released from the substrate or if there was tearing of the foam.

## Typical Environmental Characteristics

### Temperature Resistance



## Handling/Application Information

### Directions for Use

1. Surface Preparation: Surfaces must be clean, dry and dust free. Wiping with a solvent such as isopropyl alcohol for plastic substrates or MEK (methyl ethyl ketone) for metal will aid in removing oil and dirt.\*

\*Note: When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

2. Application: 3M™ Sprayable Hot Melt Adhesive is designed for spray application using either a hand held applicator or a "bulk" hot melt system designed for use with a sprayable hot melt adhesive.

## Lot Code Information

**Example of lot number:**8023K4

Code Description

8 Last digit of year manufactured 023 Julian date (day number 0 - 366)

K4 Alpha-numeric lot code (random not sequential)

In this example, the date of manufacture is January 23, 2008.

## Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) and 40 to 60% relative humidity in the original packaging, out of direct sunlight. For best performance, use this product within 24 months from date of manufacture.

## Available Sizes - Detailed

0.75 in dia. x 0.75 in Long

(1.9cm x 1.9cm)

22 pound boxes

850 pound Gaylord

## 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

## **Information**

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## **ISO Statement**

This product was manufactured under a 3M quality system registered to ISO 9001 standards.

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