



Technical Data Sheet

3M™ Heavy Duty 20 Spray Adhesive



[Regulatory Info/SDS](#)

Product Description

A high strength, fast grabbing, industrial grade, lace spray aerosol adhesive.

Product Features

- Can be used to bond many different substrates, including wood, plastics, soft foams, fabrics and metal.
- High strength, fast grabbing adhesive forms a powerful, permanent bond.
- Ideal in woodworking and many other applications where high strength is required.

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 |
|----------------|------------|
| Density | 6.3 lb/gal |

Typical Physical Properties

| Attribute Name | Value |
|---------------------------------|-----------------------------------|
| Color | Translucent |
| Solids Content by Weight | 17.3 % |
| Base | Synthetic Elastomer |
| Spray Pattern | Variable Lace |
| Dry Time | 1 min ¹ |
| Flammable Solvent | Yes |
| Flammable Propellant | Yes |
| Coverage | 26.4 ft ² ² |
| Bonding Range | 1 — 30 min ³ |
| Container Size | 20 fl oz |
| 3M Stock Number | 62-4915-4920-0 |
| UPC Number | 00-051111-07861-7 |
| Net Weight | 13.8 oz |
| VOC | 51.8 % |
| Hazardous Air Pollutants (HAPS) | 16.8 % by weight |

¹ Dry time will depend on ambient temperature, humidity and coverage applied.

² @ 2.5 g/ft² per Can

³ 10 mil wet film 2 surfaces

Typical Performance Characteristics

| Attribute Name | Value |
|------------------------------------|---------------------|
| Shear Adhesion Failure Test - SAFT | 210 °F ¹ |

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 min. until complete failure.

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, unopened packaging, out of direct sunlight. Lower temperatures cause increased viscosity of a temporary nature. For best performance, use this product within 18 months from date of manufacture.

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

Automotive Disclaimer

Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Information

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3M™ Industrial Adhesives and Tapes Division
3M Center, St. Paul, MN 55144-1000
3M.com/iatd

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