



Technical Data Sheet

3M™ Nitrile High Performance Plastic Adhesive 1099-L



[Regulatory Info/SDS](#)

Product Features

- 3M™ Nitrile High Performance Plastic Adhesive 1099-L is a low viscosity grade for spray application.
- Fast drying.
- Provides strong, flexible bonds.
- Resists weathering, water, fuels, oil and plasticizers.
- Bonds vinyl extrusions and sheeting. (May stain light colored vinyls).
- Also bonds fabrics, foams and many plastics. (Not recommended for polyolefin plastic bonding).
- May be heat cured to obtain superior physical properties.

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
Net Weight	7 — 7.4 lb/gal
Base	Nitrile Rubber

Typical Physical Properties

Attribute Name	Temperature	Value
Color		Light Tan (we and dry)
Solids Content by Weight		22 — 26 %
Carrier Solvent		Acetone and Methyl Ethyl Ketone (MEK)
Coverage		313 ft ² /gal ¹
Bonding Range		Up — 20 min ²
Flash Point		-18 °C (0 °F) ³
Viscosity	27 °C (80 °F)	200 — 325 cP ⁴

¹ @ 2.5 g/ft² dry wt.

² 10 mil wet film 2 surfaces

³ Closed Cup

⁴ Brookfield Viscometer RVF #2 spindle @ 20 rpm

Typical Performance Characteristics

180° Peel Adhesion

Substrate: Canvas to Steel

Dwell Time	Temperature	Value
24 h	22 °C (72 °F)	264 oz/in
72 h	22 °C (72 °F)	416 oz/in
120 h	22 °C (72 °F)	376 oz/in
168 h	22 °C (72 °F)	440 oz/in
2 week	22 °C (72 °F)	496 oz/in
3 week	22 °C (72 °F)	480 oz/in

Dwell Time	Temperature	Value
3 week	-34 °C (-29 °F)	280 oz/in
3 week	66 °C (150 °F)	112 oz/in
3 week	82 °C (180 °F)	56 oz/in

Overlap Shear Strength

Substrate: Aluminum to Aluminum

Dwell Time: 30 min

Environmental Condition: +100 psi

Temperature	Test Condition	Value
121 °C (250 °F)		467 lb/in ²
177 °C (300 °F)	-55°C (-67°F)	2,989 lb/in ²
177 °C (300 °F)	-34°C (-30°F)	2,409 lb/in ²
177 °C (300 °F)	22°C (72°F)	1,306 lb/in ²
177 °C (300 °F)	66°C (150°F)	897 lb/in ²
177 °C (300 °F)	82°C (180°F)	643 lb/in ²
177 °C (300 °F)	93°C (200°F)	607 lb/in ²

Handling/Application Information

Directions for Use

1. Surface Preparation: Remove all dust, dirt, oil, grease, wax, loose paint, etc.

Wiping with methyl ethyl ketone (MEK)* or 3M™ Citrus Base Cleaner* will aid in preparing the surface for bonding.

2. Application Temperature: For best results, the temperature of the adhesive and surfaces should be at least 65°F (18°C).

3. Application: Stir well before using.

Porous Surface(s): Brush, flow or spray a thin, even coat of adhesive to one or both surfaces. Coating both surfaces is preferred since it gives greater strength and permits longer open time before bonding. Very absorbent materials may require more than one coat. Bond while adhesive is still wet or aggressively tacky. Join surfaces with firm pressure.

Non-Porous Surface(s): Brush, flow or spray a thin, even coat of adhesive to both surfaces. Allow adhesive to dry until tacky. Join surfaces with firm pressure.

4. Drying Time: Drying time depends on temperature, humidity, air movement, and porosity of the materials bonded. Greater immediate strength may be obtained by heat or solvent reactivation. See Reactivation below.

5. Reactivation: To solvent reactivate, coat both surfaces with adhesive. Allow to dry tack-free. Lightly wipe one surface with a solvent such as methyl ethyl ketone (MEK).* Complete bond within 30 seconds.

To heat reactivate, coat both surfaces with adhesive. Allow adhesive to dry completely. Reactivate by heating one or both surfaces to a minimum of 180°F (82°C). Assemble immediately (while hot), using firm pressure to ensure contact.

6. Curing: 3M™ Nitrile High Performance Plastic Adhesive 1099 and 1099-L may be heat cured to obtain superior properties. Cure assembled parts at time and temperature listed using 100 psi pressure on the bond line.

Temperature of Bondline Time for Minimum Cure

200°F (93°C) 120 minutes

240°F (116°C) 40 minutes

280°F (138°C) 12 minutes

320°F (160°C) 8 minutes

360°F (182°C) 5 minutes

400°F (204°C) 2 minutes

7. Cleanup: Excess adhesive may be removed with methyl ethyl ketone (MEK)* or acetone,* preferably while adhesive is still wet.

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

Application Equipment

Note: Appropriate application equipment can enhance adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

1. Pumping:

3M™ Nitrile High Performance Plastic Adhesive 1099, 1099-L*

5 Gallon or less dispensing system:

Pressure pot 100 psi operating pressure. Fluid hose should be nylon lined.

55 Gallon dispensing system:

Pump - 2:1 ratio, double acting, ball type checks, bung mounting, divorced design.

*Synthetic materials such as packings, seals and hose lines must be resistant to the solvent in these adhesives. nylon, compar, and PTFE lined or coated parts are suggested.

2. Spray:

Plastic Adhesive 1099-L: Production

Type Spray Equipment

Spray Gun	Air Cap	Fluid Tip	Air Pressure	Approximate Air Requirement ¹	Fluid Flow ²
DeVilbiss JGA, MSA	777	FX	65 psi	16 CFM	5 fl. oz./min.
Binks No. 95 or 2001	63PB	63BSS	65 psi	16 1/2 CFM	6 fl. oz./min.

Note: This adhesive is not recommended for airless spraying.

12-3 H.P. Compressor for intermittent use.

4 H.P. Compressor for continuous use.

2 To Measure Fluid Flow: Pressurize fluid source only; pull trigger; flow material into measuring device for 60 seconds, increase or decrease fluid source pressure to obtain desired fluid flow.

All material hoses should be nylon or PVA lined.

3. Brush/Roller: Typical brushes designed for oil based paints may be used.

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 24 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

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the

purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Disclaimer: 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.

ISO Statement

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

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

3M is a trademark of 3M Company.
©3M 2024 (6/24)