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# Technical Data Sheet

3M™ Hot Melt Adhesive 3762LM

## Product Description

3M™ Hot Melt Adhesives are heat applied, 100% solids adhesives. They are fast setting thermoplastic adhesives with good “hot tack” and low to medium viscosity.

3M™ Hot Melt Adhesives bond to a wide variety of substrates such as corrugated, beadboard, repacking chipboard, recoupage, wood and many other lightweight materials.

- Low temperature application for handling ease. Economical hot melt with excellent “hot tack” and fast set.

## Product Features

- 100% solids, no VOCs
- Easy to use
- Fast-setting adhesive obtains strength in seconds
- Low Melt (LM) adhesives are designed for low temperature application and heat sensitive substrates
- “Quick grab” for instant adhesion that cools to a tack free solid
- Ideal for packaging and woodworking applications.

## 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 Physical Properties

Attribute Name	Temperature	Substrate	Value
Color			Light Amber
Density			1.01 g/cm <sup>3</sup> (0.036 lb/in <sup>3</sup> )
Viscosity	121 °C (250 °F)		4,000 <sup>1</sup>
Open Time		Douglas Fir to Douglas Fir	25 s <sup>2</sup>
Delivery Time			45 s <sup>3</sup>
Flash Point			293 °C (560 °F)

<sup>1</sup> Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

<sup>2</sup> 1/8" semicircular bead

<sup>3</sup> Extrusion time for one 1"x3" PG cartridge.

## Typical Performance Characteristics

Temperature: 22 °C (72 °F)

Attribute Name	Substrate	Value
180° Peel Adhesion	Flexible canvas bonded to Douglas Fir	96 oz/in
Overlap Shear Strength	Douglas Fir	480 lb/in <sup>2</sup>

Attribute Name	Test Method	Value
Application Temperature		121 — 132 °C (250 — 270 °F) <sup>1</sup>
Temperature Resistance		54 °C (130 °F) <sup>2</sup>
Ball & Ring Melt Point	ASTM E28-67	96 °C (205 °F)

<sup>1</sup> Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.

<sup>2</sup> Highest temperature that the adhesive will support a 2 psi dead load

## **Handling/Application Information**

### **Directions for Use**

1. Surface Preparation: Surfaces must be clean, dry and dust free. Wipe with a solvent such as isopropyl alcohol for plastic substrates to aid in removing oil and dirt.\*

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

2. Application: 3M™ Hot Melt Adhesives are designed for application with a 3M™ Hot Melt Applicators. Read and follow the precautions and directions for use in the user's manual before operating the applicator. 3M™ Hot Melt Adhesives are applied at 350-385°F, except the Low Melt (LM) series which are designed to be applied at 250-275°F. LM series are adhesives designed for lower temperature application but still yield long-lasting bonds.

Open Time is the maximum amount of time between dispensing adhesive and joining surfaces. Reported open time are based on 1/8" extruded beads and will vary based on bead size, dispense temperature and ambient temperature. Extruded bead sizes can be customized using 3M™ applicator tips.

3. Coverage: 3M™ Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.

4. Set Time: After the bond is made, 3M™ Hot Melt Adhesives immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates.

### **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**

5/8 in x8 in Q  
5/8 in x2 in TC  
1 in x3 in PG  
1/2 in x12 in AE  
1/8 in Bulk

### **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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