

# Technical Data Sheet

3M™ Hot Melt Adhesive 3779



[Product Details](#)



[Regulatory Info/SDS](#)

## Product Description

3M™ Hot Melt Adhesives are heat applied, 100% solids adhesives. 3M™ Hot Melt 3779 is a thermoplastic adhesive to bond to wide variety of substrates such as wood, plastic, vinyl, metal and glass.

- High strength bonding with excellent environmental stability including very high heat resistance. Fast set time.

## Product Features

- 100% solids, no VOCs
- Easy to use
- Long open times allow for easy use on large assemblies and large surfaces
- Adhesive sets and obtains strength in seconds
- Creates high performance bonds
- Ideal for woodworking and general industrial 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	Test Method	Temperature	Substrate	Value
Color				Amber
Density				0.99 g/cm <sup>3</sup> (0.036 lb/in <sup>3</sup> )
Open Time			OSB	25 s <sup>1</sup>
Flash Point	ASTM D92-72			288 °C (550 °F) <sup>2</sup>
Delivery Time				75 s <sup>3</sup>
Viscosity		191 °C (375 °F)		7,000 cP <sup>4</sup>

<sup>1</sup> Open time is the max time between the application of the adhesive and joining the parts. Data based on 1/8in semicircular bead on non-metallic substrates at 75°F. Higher environmental temperatures and/or larger beads will lengthen open times.

<sup>2</sup> Cleveland Open Cup

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

<sup>4</sup> Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

## Typical Performance Characteristics

Attribute Name	Test Method	Temperature	Substrate	Value
180° Peel Adhesion		22 °C (72 °F)	Flexible canvas bonded to Douglas Fir	288 oz/in
Overlap Shear Strength		22 °C (72 °F)	Douglas Fir	700 lb/in <sup>2</sup>
Ball & Ring Melt Point	ASTM E28-67			163 °C (325 °F)

Attribute Name	Value
Application Temperature	177 — 196 °C (350 — 385 °F) <sup>1</sup>
Temperature Resistance	149 °C (300 °F) <sup>2</sup>

<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, metal and glass substrates to remove 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. Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead. 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 up 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  
1/8 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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