

3M Scotch-Weld™ HoldFast 70 Spray Adhesive

Technical Data

March, 2012

Product Description

Extremely versatile, fast tacking industrial grade spray adhesive with unique wide-web spray pattern. Ideal for bonding a variety of substrates, including polystyrene.

Key Features

- Creates quick permanent bonds on many substrates, including polystyrene, drainboard, FRP panels, insulation, foams and fabrics.
- It features a very fast tacking adhesive that bonds almost immediately and has a long bonding range.
- It has a unique heavy body spray pattern with low soak-in ideally suited for irregular or porous substrates.
- Typically used in construction, specialty vehicle, RV, manufactured housing and HVAC.

Typical Properties

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

Product	3M™ Scotch-Weld™ HoldFast 70 Cylinder Spray Adhesive	3M™ Scotch-Weld™ HoldFast 70 Adhesive
Base:	Synthetic Elastomer	Synthetic Elastomer
Solids Content - (by wt.):	21%	26%
Density (lbs/gal):	5.7	6.3
Viscosity (cps):	N/A	10-200
Color(s):	Translucent	Translucent
Volatile Organic Compounds (VOC):	544 g/L	562 g/L
Hazardous Air Pollutants (HAPS) % wt (calculated):	No	No
CARB Compliant:	N/A	N/A
SCAQMD 1168 Compliant:	No	No
GREENGUARD Indoor Air Quality Certified®:	No	No
LEED® Eligible:	No	No
Coverage @ 2.5 gms /ft ² per lb (sqft):	38	47
Spray Pattern:	Lace	Lace
Dry Time:	30 seconds – 1 minute	30 seconds – 1 minute
Bonding Range:	30 seconds – 60 minutes	30 seconds – 60 minutes
Shear Adhesion Failure Test - SAFT ⁽¹⁾ :	190F	190F
Flammable Solvent:	Yes	Yes
Flammable Propellant:	Yes	N/A

⁽¹⁾SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90F and ramped 10F every 10 mn. until complete failure.

Available Sizes

Container Size	3M Stock Number	UPC Number
Mini Cylinder – 8.5 lbs.	62-4983-8010-4	00-051115-32201-3
Large Cylinder – 27.3 lbs.	62-4983-8030-2	00-048011-61690-2
Intermediate Cylinder – 139 lbs.	62-4983-8150-8	00-048011-61691-9
Jumbo Cylinder – 288 lbs.	62-4983-8300-9	00-048011-61692-6
5 gallon pail –lbs.	62-4847-8530-8	00-051115-63935-7
52 gallon drum –lbs.	62-4847-9530-7	00-051115-63934-0

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Storage	Store product at 60°-80°F (16°-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.
Shelf Life	When stored at the recommended conditions in original, unopened container, this product has a shelf life of 15 months from date of shipment.
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 or (651) 737-6501.
Technical Information	The technical information, recommendations and other statements contained in this document are based upon testes or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.
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