



# Scotch-Weld<sup>TM</sup> Spray 77 Multi-Purpose Adhesive

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## Product Data Sheet

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Updated : April 2008  
Supersedes : August 1995

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**Product Description** Spray 77 Adhesive is a multi-purpose aerosol adhesive. It is fast tacking and has a long tack range when applied to both surfaces.  
Spray 77 Adhesive 77 is a light coloured, non staining adhesive.

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**Physical Properties**  
Not for specification purposes

Solvent	Petroleum Distillate / Cyclohexane	
Flash Point	-46°C	
Propellant	Hydrocarbon	
Contents	349g (500ml)	
Solids Content	25% approximately	
Spray Pattern	Particle	
Colour	Clear/Pale Cream	
Shelf Life	12 months from date of receipt by customer when stored in the original carton at 21°C (70°F) & 50 % Relative Humidity	

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**Performance Characteristics**  
Not for specification purposes

Service Temperature Range	-30°C to 60°C	
Water Resistance	Very Good	
Weathering Resistance	Fair	
Fuel and Oil Resistance	Poor	
UV Light Resistance	Fair	

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**Additional Product Information**

Coverage:  
Approximately 12m<sup>2</sup> (140 square feet) per container, depending on porosity of substrate.  
Conformity to British Standards and Other Specifications:  
Defence Standard 80-117

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**Storage Conditions** Store at 16°C to 27°C for maximum storage life in a cool dry place. Storage temperature must not exceed 49°C.

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**Directions for Use**

Ensure all surfaces to be bonded are clean, dry and free from dust, oil and grease before application of adhesive.

Ensure that the nozzle points away from all persons and towards the surface to be sprayed. Turn the spray tip to select the desired spray width.

Shake the can well before using, 5-10 seconds should be sufficient.

**For Strong Permanent Bonds:** Spray both surfaces to be bonded and allow a minimum of 30 seconds drying time before assembly.

**For Temporary Bonds with Easy Removal:** To bond substrates for short periods and to permit easy removal, apply a light coat to one surface and allow to dry for about 1 minute. Most surfaces can then be removed when desired without adhesive transfer.

**NOTE:** When bonding expanded polystyrene foam, leave surface open for about 10 minutes to allow most of the solvent to escape before making a bond.

To prevent spray nozzle from blocking, at the end of each day, turn the can upside down and press tip until spray is clear from adhesive.

**Clean Up:**  
Spray nozzle or excess material may be cleaned with Scotch-Grip Solvent No. 1.

**NOTE:** Solvent No. 1 is highly flammable. When using solvents for clean up it is essential that proper safety precautions are observed.

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**Applications**

Spray 77 Adhesive is extensively used for bonding lightweight boards, foams, plastics, fabric, paper and insulating materials.

For bonding fabric backcloths in studios and window dressing, and bonding polystyrene foam in fabricating packaging units.

The adhesive is also widely used in the heating and ventilating industry.

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## Health & Safety Information

### Precautions:

Highly flammable. Vapours may ignite explosively. Vapour may be harmful. Keep away from heat. Keep away from sources of ignition including pilot lights and sparks - No Smoking. Avoid prolonged breathing of vapours/spray. Do not use in confined areas or areas with little or no air movement. Do not spray directly into eyes. Avoid prolonged or repeated contact with the skin. Keep out of reach of children.

### WARNING:

Pressurised container. Protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn, even after use. Do not spray on a naked flame or incandescent material.

### First Aid:

#### Eye Contact:

Rinse immediately with plenty of water and seek medical advice.

#### Skin Contact:

Wash with soap and water.

For further information please contact our Toxicology Department at the Bracknell Head Office on (01344) 858000.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



Industrial Adhesives & Tapes Division

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