



# Technical Data Sheet

## 3M™ Industrial Adhesive 4475

### Product Features

- Dries quickly to a firm bond.
- Excellent resistance to water, plasticizer migration, many detergent and soap solutions, oils and grease.
- A general purpose adhesive for bonding most vinyls, ceramics, glass, leather and cloth to a variety of substrates.

### 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

Property	Values	Additional Information
Solids Content by Weight	41 to 45 %	
Color	Clear	
Flash Point	20 °F	View
Notes: Closed Cup		
Carrier Solvent	methyl ethyl ketone (MEK)	
Coverage	487 sq ft/gal	View
Notes: 1 mil dry film		
Viscosity	6,500-10,500 cP	View
Notes: Brookfield Viscometer RVF #5 sp. @ 20 rpm		

### Typical Uncured Physical Properties

Property	Values	Additional Information
Base	Synthetic Resin	

Net Weight 8.3 lb/gal

### Typical Performance Characteristics

Property	Values	Additional Information
180° Peel Adhesion	208 oz/in	<a href="#">View</a>
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	384 oz/in	<a href="#">View</a>
Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	440 oz/in	<a href="#">View</a>
Dwell/Cure Time: 120.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	520 oz/in	<a href="#">View</a>
Dwell/Cure Time: 168.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	560 oz/in	<a href="#">View</a>
Dwell/Cure Time: 2.0 Dwell Time Units: week Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	704 oz/in	<a href="#">View</a>
Dwell/Cure Time: 3.0 Dwell Time Units: week Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Canvas to Steel		
180° Peel Adhesion	352 oz/in	<a href="#">View</a>
Dwell/Cure Time: 3.0		

Dwell Time Units: week  
Temp C: -34C  
Temp F: -29F  
Environmental Condition: 50%RH  
Substrate: Canvas to Steel

180° Peel Adhesion

272 oz/in

View 

Dwell/Cure Time: 3.0  
Dwell Time Units: week  
Temp C: 66C  
Temp F: 150F  
Environmental Condition: 50%RH  
Substrate: Canvas to Steel

180° Peel Adhesion

112 oz/in

View 

Dwell/Cure Time: 3.0  
Dwell Time Units: week  
Temp C: 82C  
Temp F: 180F  
Environmental Condition: 50%RH  
Substrate: Canvas to Steel

## Storage and Shelf Life

Best storage temperature is 60-80°F (16-27°C). Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a “first in, first out” basis.

When stored at the recommended temperature in the original, unopened container, this product has a shelf life of 30 months from date of manufacture.

## Bottom Matter

3M  
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## Trademarks

3M is a trademark of 3M Company.

## Automotive Disclaimer

Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer’s automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M’s Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer’s use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

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## Handling/Application Information

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### Application Equipment

Note: Appropriate application equipment can enhance adhesive performance. The user is responsible for evaluating application equipment in light of the user's particular purpose and method of application.

#### 1. Pumping

##### 5-Gallon Pail Dispensing System

Pump – 9:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 4 1/4" diameter air motor minimum.

Pail cover to be used to reduce solvent loss.

##### 55-Gallon Drum Dispensing System

Pump – 10:1 ratio double acting ball check type pump, 11.0 cubic inches per cycle, 4 1/4" diameter air motor minimum, Bung mount type.

#### 2. Accessories

Hose – 1000 psi minimum working pressure, nylon lined. Flow rate at 40°F, 20 ft. of 3/4-ID plus 10 ft. 1/2-ID and a flow gun equals 1 pound/minute at pump air pressure of 75 psi.

#### 3. Chemical Resistance Requirements

Synthetic materials in contact with this product must be resistant to ketones and aromatic solvents. Compare, nylon or PTFE coatings are suggested for packings and gaskets.

### Directions for Use

1. Surface Preparation: Best results are achieved on clean, dry surfaces. Oil, grease and other contaminants can be removed by wiping with a solvent such as methyl ethyl ketone (MEK).\*

2. Application: Apply adhesive to one or both surfaces (best results are obtained by coating both surfaces) and bond immediately using firm pressure.

3. Drying Time: Allow to dry a minimum of 24 hours for maximum strength.

4. Cleanup: Remove unhardened or hardened material with cloth dampened with a solvent such as methyl ethyl ketone (MEK).\*

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

## References

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Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/p/d/b40069415/">https://www.3m.com/3M/en_US/p/d/b40069415/</a>
Safety Data Sheet SDS	<a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=4475">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=4475</a>

## Family Group

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Link Tags:

• 4475

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Products	Color
4475	Clear

## ISO Statement

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This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

## Precautionary Information

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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.

## Information

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