



# Technical Data Sheet

## 3M™ Hot Melt Adhesive 3779

### 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


Property	Values	Additional Information
Open Time	25 s	View 

Substrate: OSB

Notes: 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.

Density	0.99 g/cm <sup>3</sup>	
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Density	0.036 lb/in <sup>3</sup>	
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Flash Point	288 °C	View 
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Test Method: ASTM D92-72

Notes: Cleveland Open Cup


Flash Point	550 °F	View 
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Test Method: ASTM D92-72

Notes: Cleveland Open Cup

Viscosity	7000 cP	<a href="#">View</a> 
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Notes: Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

Delivery Time	75 s	<a href="#">View</a> 
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Notes: Extrusion time for one 1"x3" PG cartridge.


### Typical Uncured Physical Properties

Property	Values	Additional Information
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Color (solid)	Amber	
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### Typical Performance Characteristics


Property	Values	Additional Information
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180° Peel Adhesion	288 oz/in	<a href="#">View</a> 
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Substrate: Flexible canvas bonded to Douglas Fir

Application Temperature C	177 to 196 °C	<a href="#">View</a> 
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Notes: Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.

Application Temperature F	350 to 385 °F	<a href="#">View</a> 
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Notes: Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.

Overlap Shear Strength	700 lb/in <sup>2</sup>	<a href="#">View</a> 
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Substrate: Douglas Fir

Temperature Resistance	149 °C	<a href="#">View</a> 
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Notes: Highest temperature that the adhesive will support a 2 psi dead load

Temperature Resistance	300 °F	<a href="#">View</a> 
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Notes: Highest temperature that the adhesive will support a 2 psi dead load

Ball & Ring Melt Point	163 °C	<a href="#">View</a> 
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Test Method: ASTM E28-67

Ball & Ring Melt Point	325 °F	<a href="#">View</a> 
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Test Method: ASTM E28-67

Notes: Permitted for indirect food contact subject to the limitations in applicable CFR section(s).

## Available Sizes

5/8 in x8 in Q

5/8 in x2 in TC

1 in x3 in PG

1/8 in Bulk

## Storage and Shelf Life

Store product below 120°F (49°C).

When stored at the recommended conditions, this product has a shelf life of 24 months from date of manufacture.

## Bottom Matter

3M

Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06

St. Paul, MN 55144-1000

800-362-3550

## Trademarks

3M is a trademark of 3M.

## 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.

## References

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/p/d/b40065549/">https://www.3m.com/3M/en_US/p/d/b40065549/</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=3779">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=3779</a>

## ISO Statement

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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