

3M™ Hi-Tack Pressure Sensitive Adhesive 3794

Product Description

3M™ Hot Melt Adhesives are 100% solids, thermoplastic resins that become fluid when heated and quickly wet the bonding surface. They cool and reach bond strength in seconds, keeping production flowing by eliminating clamps, fixturing and drying, and saving time energy and space.

3M™ Hi-Tack Pressure Sensitive Adhesive 3794 bonds to a wide variety of substrates such as wood, corrugated, fabrics and foams, plastics, metal and other lightweight materials.

- Sprayable and extrudable. Aggressive tack bonds well to most surfaces. Tackiness remains after cooling, allowing bond formation long after dispensing. Offers good low temperature flexibility.



Product Features

- 100% Solids, no VOCs
- Easy to use
- Extra-long open time
- Adhesive obtains strength in seconds
- Can be sprayed, extruded or roll coated
- Hi tack PSA provides tack even after cooling

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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 Uncured Physical Properties

Color (solid): Light Tan

Typical Physical Properties

Property	Values		Method	Notes	Test Condition	Substrate
Density	0.94 g/cm ³	0.034 lb/in ³				
Flash Point	204 °C	>400 °F	ASTM D92-72	Cleveland Open Cup		
Viscosity	15,000 cP			Brookfield Thermocel Viscometer	325°F(163°C)	
Open Time	>60 s			For 1/8" semicircular bead		Douglas Fir to Douglas Fir

Typical Performance Characteristics

Property	Values		Notes	Method
Peel Adhesion	256 oz/in		Flexible canvas bonded to Douglas Fir	

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Typical Performance Characteristics (continued)

Property	Values		Notes	Method
Application Temperature	162 to 196 °C	325 to 385 °F	Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life.	
Heat Resistance	49 °C	120 °F	Highest temperature that the adhesive will support a 2 psi dead load	
Ball & Ring Melt Point	107 °C	224 °F		ASTM E28-67
FDA Indirect Food Contact	21 CFR 175.105		Permitted for indirect food contact subject to the limitations in applicable CFR section(s).	

Available Sizes

Chubs (1.1 lb)

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 substrates to aid in removing 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 Adhesive 3794 is designed for bulk applicators.

Note: Plastic wrap encasing the chub DOES NOT need to be removed. Entire chub can be deposited into melting equipment. Wrap has no effect on process or performance.

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 time: After the bond is made, 3M™ Hot Melt Adhesive 3794 immediately build strength and no clamping is necessary. Set will occur faster on cold or metallic substrates, however 3M™ Hot Melt Adhesive 3794 will remain tacky after cooling.

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Storage and Shelf Life

Store below 120°F (49°C).

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

Trademarks

3M is a trademark of 3M.

References

1. 3m.com Product Page

Url: https://www.3m.com/3M/en_US/company-us/all-3m-products/~/3M-High-Tack-Pressure-Sensitive-Adhesive-3794?N=5002385+3293194250&rt=rud

2. Safety Data Sheet

Url: https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=3794

ISO Statement

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

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

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Product Selection and Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

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