



Hi-Tack Composite Spray Adhesive 71

Technical Data Sheet

March 2018

Product Description A high tack, resin compatible mist spray aerosol adhesive for resin infused composite applications.

- Key Features**
- Securely bonds many lightweight materials used in resin infused composites. Such as glass fiber, carbon fiber, nylon fibers, peel ply & transfer mesh.
 - Meets CARB / OTC VOC Requirements.
 - Compatible with resins used in composite manufacture, including epoxy, vinyl ester & polyester resins.

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™ Hi-Tack Composite Spray Adhesive 71
Base	SBR type synthetic elastomer
Solids Content - (by wt.):	19 to 20% by wt
Density (lbs/gal):	6.6 lbs/gallon; 790 grams/liter
Color(s):	Translucent or Yellow Green
Volatile Organic Compounds (VOC):	<25%
CARB / OTC Compliant:	Yes
Coverage @ 10 gram / m ² per Can:	99 square feet; 10 square meters Per Can
Spray Pattern:	Mist/Particulate
Dry Time:	15 to 60 seconds
Bonding Range:	Up to 20 minutes
Shear Adhesion Failure Test - SAFT ⁽¹⁾ :	205°F 96°C
Flammable Solvent:	Yes
Flammable Propellant:	Yes

Test Descriptions:

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

Application

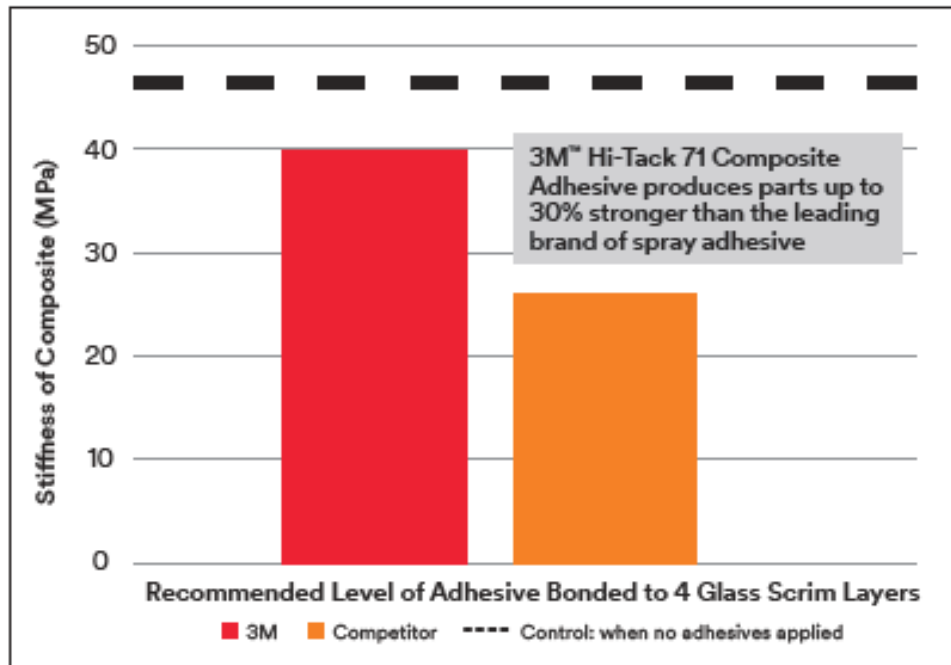
Aerosol Can: Hold can perpendicular 6" to 8"; 150 mm to 200mm from the substrate to be sprayed. Typical woven fiberglass materials only need 1 dry gram / square foot to hold up to 6 layers vertically. More adhesive may be needed depending on number of layers, configuration and nature of materials. For example the transfer mesh may need more adhesive to avoid edge curl. The color indicator adhesive is recommended when possible to minimize the amount of adhesive necessary. Only a slight indication of green is needed to bond most materials. See photo for approximate appearance on fiberglass fabric:



Green color indicator image (not enough, just right, too much.)

3M™ Hi-Tack Composite Spray Adhesive 71

3M™ Hi-Tack Composite Spray Adhesive 71 is formulated to be compatible with the resins used in the manufacturing of vacuum infused composite parts. Chart 1. Compares the effects 3M™ Hi-Tack Composite Spray Adhesive 71 on the strength of a polyester infused composite.



Ordering Information

Product	Stock Number/ UPC Number	Color	Net Weight	Case Quantity
3M™ Hi-Tack Composite Spray Adhesive 71	62-4867-4930-2 0-00-76308-14329-9	Green	18.04 oz	12
	62-4865-4930-6 0-00-76308-14327-5	Clear		

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.

3M™ Hi-Tack Composite Spray Adhesive 71

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, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

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.

Warranty, Limited Remedy, and Disclaimer Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

ISO 9001

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

3M
Industrial Adhesives and Tapes Division
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/spray71

3M is a trademark of 3M Company.
©3M 2018 (3/18)