

# 3M

## Hot Melt Adhesive

### 3750LM • 3750

Technical Data

July, 2016

<b>Product Description</b>	<p>3M™ Hot Melt Adhesives are heat applied, 100% solids adhesives. They are fast setting thermoplastic adhesives with good “hot tack” and low to medium viscosity.</p> <p>3M™ Hot Melt Adhesives bond to a wide variety of substrates such as corrugated, beadboard, repacking chipboard, recouperage, wood and many other lightweight materials.</p> <p><b>3M™ Hot Melt 3750 Tan</b> Low viscosity adhesive for high flow rate and increased production rate. Ideal for high volume packaging. Use with AE II applicator only.</p> <p><b>3M™ Hot Melt 3750 Clear</b> General purpose adhesive with high peel strength. Use with AE II applicator only</p> <p><b>3M™ Hot Melt 3750LM</b> Low temperature application version with a fast set time. Use with AEII LT applicator only.</p>		
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<b>Features</b>	<ul style="list-style-type: none"><li>• 100% solids, no VOCs</li><li>• Easy to use</li><li>• Fast-setting adhesive obtains strength in seconds</li><li>• Low Melt (LM) adhesives are designed for low temperature application and heat sensitive substrates</li><li>• “Quick grab” for instant adhesion that cools to a tack free solid</li><li>• Ideal for packaging and many woodworking applications.</li></ul>
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#### Typical Physical Properties

**Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.**

	3M™ Hot Melt Adhesive		
	3750LM	3750 Tan	3750 Clear
<b>Color (solid)</b>	Tan	Tan	Clear
<b>Density (g/cm<sup>3</sup>)</b>	1.01	0.93	0.93
<b>Flashpoint (°F)</b>	560	>390	>530

#### Directions for Use

1. **Application:** 3M™ Hot Melt Adhesives are designed for use with 3M™ Hot Melt Applicators (excluding bulk sizes). 3M™ Hot Melts are applied at 350-385°F, except the LM series which are designed to be applied at 250-275°F. Read and follow the precautions and directions for use in the Applicators User’s Manual before operating the applicator.

**Open Time** is the maximum amount of time between dispensing adhesive and joining surfaces. Reported open time are based on 1/8” extruded beads and will vary based on bead size, dispense temperature and ambient temperature.

Extruded bead sizes can be customized using 3M™ applicator tips.

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### Directions for Use (continued)

- Coverage:** 3M™ Hot Melt Adhesives yield approximately 430 linear feet per pound of adhesive when extruded as a 1/8" diameter semi-circular bead.
- Set 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.

### Typical Application Properties

**Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes

	3M™ Hot Melt Adhesive		
	3750LM	3750 Tan	3750 Clear
<b>Application Temperature</b> <sup>1</sup>	250-270°F/ 121-132°C	350-385°F/ 177-196°C	350-385°F/ 177-196°C
<b>Viscosity (cps)</b> <sup>2</sup>	4000 @ 250°F	1900 @ 375°F	4800 @ 375°F
<b>Open Time (seconds)</b> <sup>3</sup>	25	30	40
<b>Delivery Time (seconds)</b> <sup>4</sup>	45	30-40	35-45
<b>Available sizes/forms</b>	1/2"x12"AE	1/2"x12"AE	1/2"x10"AE

(1) Recommended application temperature range. Temperature can be adjusted to regulate desired viscosity, delivery rate and pot life

(2) Brookfield Thermocel Viscometer in Centipoise using a #27 Spindle @ 10 RPM.

(3) For 1/8" semicircular bead, Douglas Fir to Douglas Fir

(4) Extrusion time for one 1"x3" PG cartridge

### Typical Performance Properties

**Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	3M™ Hot Melt Adhesive		
	3750LM	3750 Tan	3750 Clear
<b>Heat Resistance</b> <sup>1</sup>	128°F/ 54°C	125°F/ 52°C	135°F/ 57°C
<b>Ball &amp; Ring Melt Point</b> <sup>2</sup>	200°F/ 95°C	200°F/ 93°C	178°F/ 81°C
<b>Shear Strength</b> <sup>3</sup>	475 psi	500 psi	250 psi
<b>Peel Strength</b> <sup>4</sup>	6 pwi	6 pwi	12 pwi
<b>UL94 Listing</b>	n/a	n/a	n/a
<b>FDA Indirect Food Contact</b> <sup>5</sup>	21 CFR 175.105	n/a	n/a

(1) Highest temperature that the adhesive will support a 2 psi dead load

(2) ASTM E28-67

(3) Douglas Fir to Douglas Fir

(4) Canvas to Douglas Fir

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

# 3M™ Hot Melt Adhesive

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<b>Storage</b>	Store product below 120°F (49°C).
<b>Shelf Life</b>	When stored at the recommended conditions, this product has a shelf life of 2 years after 3M ships the product to a customer or distributor.
<b>Pre cautionary Information</b>	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
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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001: 2000 standards.



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